

DX1064

2K VOC SURFACER

Description

2K VOC compliant chromate-free sanding surfacer.
Colour: grey.
Composition based on functional acrylic copolymer.

Products

DX1064	2K VOC Surfacer
DX1024	HS Activator Fast
DX1020	HS Activator
DX32	Thinner Fast
DX34	Standard Thinner

Properties

- Easy to apply, smooth flow.
- Excellent vertical stability.
- High filling power and easy to sand.
- Outstanding isolation properties and perfect topcoat hold-out.
- Excellent adhesion.
- Can be coated with basecoat or 2K topcoat.
- VOC compliant, conform with directive 2004/42/EC.

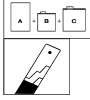







Substrates

- OEM finishes.
- Cured repair finishes.
- Sanded putties.
- Primed steel, zinc galvanised steel and aluminium.
- DUXONE® 1K Wash Primer Filler DX1061.

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PRODUCT PREPARATION

	Mixing ratio DX1064 DX1024 DX1020 DX32/DX34	Standard (DX1020)		Fast (DX1024)	
		Volume	Weight	Volume	Weight
		4	100	4	100
		-	-	1	15
		1	15	-	-
		10-15 %	8-16	10-15 %	8-16
	VOC	540 g/l			
	Pot life at 20°C	2 hr			
	Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	20-25 s 21-27 s 23-31 s		
	Spray equipment Conventional guns Gravity feed Suction feed Pressure feed Compliant guns (HVLPHTE) Gravity feed Suction feed Pressure feed	Fluid tip	Distance	Pressure	
		1.4-1.8 mm 1.6-1.8 mm 1.0-1.2 mm	20-25 cm 20-25 cm 20-25 cm	3-4 bar 3-4 bar 3-4 bar	
		1.4-1.7 mm 1.6-1.8 mm 1.0-1.2 mm	15-20 cm 15-20 cm 15-20 cm	According to supplier's specifications	
	Number of coats	1-3			
	Flash time	Between coats till flat. 10 min before bake.			
	DFT	80-200 µ			
	Dry to sand at 15°C at 20°C at 40°C at 60°C	DX1020 O.N. 3-4 hr 30-40 min 25-30 min	DX1024 6-8 hr 3 hr 30 min 25 min		
	IR drying*	Distance Half power Full power	80 cm 5 min 15-20 min * Guideline for short/medium wave IR equipment.		
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.					

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RECOMMENDED USE

Surface preparation

- Before applying DX1064, clean the surface, sand and degrease properly.
- Treat bare metal spots with 1 coat of wash primer or DUXONE[®] 1K Wash Primer Filler DX1061.

Equipment cleaning

Use a correct solventborne gunwash.

Remarks

- Do not use activated DX1064 beyond the pot life nor reduce it further to get viscosity down again.
- If DX1064 is applied over thermoplastic acrylic finishes, complete panel or overall car has to be treated. Spot repairing or sand throughs of the filler can result in spot marking or lifting when applying a basecoat.
- Do NOT exceed recommended film thickness to avoid film defects, poor film through cure and poor adhesion.
- Respect mixing ratios, drying times, spray pressure and DFT to avoid poor sandability and paperfilling.
- Activated material should not be returned to original can of non-activated material.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Material has to be at room temperature (18-25°C) before use.

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RECOMMENDED USE (con'd)

Product data

Package viscosity: 2500-3000 cp (at 5 rpm)
900-1200 cp (at 20 rpm)

Theoretical coverage: 5.5-5.8 m²/l at 80 μ DFT - ready-to-spray

Directive 2004/42/EC: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

Products	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
DX1064	1	2	1.592
DX1020	0.5	3	1.007
DX1024	0.5	3	1.007
DX32	1 - 5	5	0.874
DX34	1 - 5	5	0.903

Safety

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.