

# TECHNICAL DATA SHEET

## DX1048

### 2K VOC CLEAR

**DUXONE**<sup>®</sup>  
AUTOMOTIVE PAINT SYSTEMS



## DESCRIPTION

DX1048 2K VOC Clear is part of the Duxone repair system. This VOC compliant, easy-to-apply and versatile clear delivers an exceptional quality finish that has excellent polishability.

## FEATURES

- For application over Duxone waterborne basecoat and activated Duxone basecoat.
- Very good vertical stability.
- Superb polishability.
- Excellent mar, chemical and weather resistance.
- Suitable for spot, panel and overall repairs.
- VOC compliant.

## PRODUCT LIST

- DX1048 2K VOC Clear
- DX1020 HS Activator Standard
- DX1024 HS Activator Fast

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DX1048

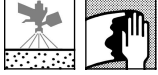
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## Product preparation - application STANDARD



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Activated Duxone Basecoat: Surfaces must be dried / flashed-off in accordance with TDS before application  
Existing finishes: Surfaces must be sanded and degreased before application



|               | Spot & panel repair |        | Standard |        |
|---------------|---------------------|--------|----------|--------|
|               | Volume              | Weight | Volume   | Weight |
| <b>DX1048</b> | 2                   | 100    | 2        | 100    |
| <b>DX1020</b> | -                   | -      | 1        | 51     |
| <b>DX1024</b> | 1                   | 51     | -        | -      |



Pot life at 20°C: 55 min



|                  | Spray nozzle | Spray pressure |                      |
|------------------|--------------|----------------|----------------------|
| <b>Compliant</b> | 1.2 - 1.4    | 1.8 - 2.2 bar  | inlet pressure       |
| <b>HVLP</b>      | 1.2 - 1.4    | 0.7 bar        | atomisation pressure |

see manufacturer's instructions



2 coats

intermediate and final flash-off: 5 min



|                   | DX1024 | DX1020 |
|-------------------|--------|--------|
| <b>20 °C</b>      | 6 hr   | 8 hr   |
| <b>60 - 65 °C</b> | 20 min | 25 min |



Guideline for short wave IR equipment  
Half power: 5 min  
Full power: 15 - 20 min

VOC compliant

2004/42/IIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

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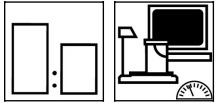
## Products

DX1048 2K VOC Clear

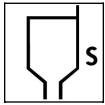
DX1020 HS Activator Standard

DX1024 HS Activator Fast

## Product mix



Mixing ratios with special agents are available in the productmix table on Colour Room and in the specific TDS.



DIN 4: 21 - 23 s at 20°C



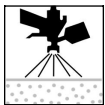
60 - 70 µm (2 coats)

### Theoretical coverage

490 - 495 m<sup>2</sup>/l at 1 micron dry film thickness

Due to different activator characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.

Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.



DX1048 2K VOC Clear can be overcoated with itself within 24 hours, without intermediate sanding



Clean after use with a suitable solventbased guncleaner.

## Remarks

- Material has to be at room temperature (18-25°C) before use.
- Allow additional time for preheating up to panel temperature.
- Surplus ready for use material should not be returned to original can.
- Close can of clear and activator tightly immediately after use, as both products will react with humid air and water and lose their hardening effect.

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

All other products referred to in the refinish build up are from our Duxone product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Duxone product range, unless explicitly indicated otherwise.

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