

TECHNICAL DATA SHEET

DX44

2K FAST CLEAR

DUXONE[®]
AUTOMOTIVE PAINT SYSTEMS



DESCRIPTION

DX44 2K Fast Clear is part of the Duxone repair system and is suitable for use in a clear-over-base system and has noticeable in-can viscosity. It delivers fast air drying times with short flash-off times between coats and bake cycle. It also has fast dust-free times, which helps to prevent defects caused by air contamination. Use of different activators provides a wide range of applications.

FEATURES

- High in-can viscosity.
- Superb polishability.
- Different applications possible thanks to different activators.
- Suitable for spot, panel and overall repairs.

PRODUCT LIST

- DX44 2K Fast Clear
- DX18 Activator Slow
- DX20 Activator Standard
- DX22 HS Activator Fast
- DX24 Activator Extra Fast
- DX32 Thinner Fast
- DX34 Thinner Standard

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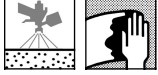
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Product preparation - application STANDARD



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



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		Spot & panel repair.		Standard		Large surface	
	Volume	Weight	Volume	Weight	Volume	Weight	Volume	Weight
DX44	2	100	4	100	2	100	2	100
DX18	-	-	-	-	-	-	1	49
DX20	-	-	-	-	1	49	-	-
DX22	-	-	1	25	-	-	-	-
DX24	1	49	-	-	-	-	-	-
DX32	-	-	40 %	45	-	-	-	-
DX32 / DX34	25 %	34	-	-	25 %	34	-	-
DX34	-	-	-	-	-	-	25 %	35



Pot life at 20°C: 1 hr 30 min - 3 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.5	1.8 - 2.2 bar	inlet pressure
HVLP	1.3 - 1.5	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 coats

intermediate and final flash-off: 5 min



	DX24	DX20	DX18
20 °C	3 hr	5 hr	6 hr
60 - 65 °C	15 min	30 min	40 min



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

VOC compliant

This product mix is not VOC compliant.

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Products

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DX18 Activator Slow

DX20 Activator Standard

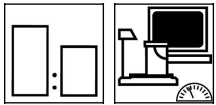
DX22 HS Activator Fast

DX24 Activator Extra Fast

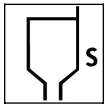
DX32 Thinner Fast

DX34 Thinner Standard

Product mix



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



DIN 4: 14 - 15 s at 20°C



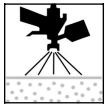
55 - 65 µm

Theoretical coverage

295 - 305 m²/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.



DX44 2K Fast 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.
- Not to be used with Duxone Waterborne Basecoat.

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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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