

DX1064

2K VOC SURFACER

Description

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

Products

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

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 DUXONE® 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-Surfacer DX1061.

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PRODUCT PREPARATION

 	Mixing ratio		Standard (DX1020)		Fast (DX1024)		
			Volume	Weight	Volume	Weight	
		DX1064	4	100	4	100	
		DX1020/DX1024 DX32/DX34	1 0 -5%	15 0 - 4	1 0 -5%	15 0 - 4	
	VOC (2004/42/EC)	540 g/l					
	Pot life at 20°C	DX1020 DX1024	2 hr				
	Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	20-25 s 21-27 s 23-31 s				
	Spray equipment		Fluid tip (mm)	Distance (cm)	Pressure (bar)		
		Compliant guns					
		Gravity feed	1.4-1.7	15-20	According to supplier's specifications		
		Suction feed	1.6-1.8	15-20			
		Pressure feed	1.0-1.2	15-20			
		Conventional guns					
Gravity feed	1.4-1.8	20-25	3-4				
Suction feed	1.6-1.8	20-25	3-4				
Pressure feed	1.0-1.2	20-25	3-4				
	Number of coats	1 - 3					
	Flash time at 20°C	Between coats till flat. 10 min before bake.					
	DFT	80-100µ/coat					
	Dry to sand		DX1020		DX1024		
		at 15°C	O.N.		6-8 hr		
		at 20°C	3 - 4 hr		3 hr		
		at 40°C	30-40 min		30 min		
		at 60°C	25-30 min		25 min		
	IR drying	Distance	80 cm				
		Half power	5 min				
		Full power	10-15 min				
		* Guideline for short/medium wave IR equipment.					

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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-Surfacer 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 primer 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.

Product data

Package viscosity:	2500-3000 cp (at 5 rpm) 900-1200 cp (at 20 rpm)
Theoretical coverage:	5.5-5.8 m ² /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.

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Safety

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

All other products referred to in the paint system build-up are from Duxone®. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Duxone®, unless explicitly indicated otherwise.

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This Technical Data Sheet supersedes all previous issues.