

DX1044

2K PRODUCTIVE VOC CLEAR

Description

2-component fast dry VOC compliant clear to be used in clear over base system.
Composition based on acrylic polyurethane copolymer.

Products

DX1044	2K Productive VOC Clear
DX1020	HS Activator
DX1024	HS Activator Fast

Properties

- Gives very fast air drying and allows short flash times between coats and bake.
- The fast dust-free times prevent surface defects by air contamination.
- Has excellent polishability.
- Can be used for spot, panel and overall repair.
- VOC compliant, conform with directive 2004/42/EC.

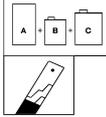
Substrates

- Basecoat.
- All cleaned and sanded OEM finishes (not recommended on thermoplastic acrylic finishes).

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PRODUCT PREPARATION

 Mixing ratio	DX1044 DX1020 DX1024	Standard		Fast	
		Volume	Weight	Volume	Weight
		2	100	2	100
		1	51	-	-
		-	-	1	51
VOC	DX1020 DX1024	420 g/l			
 Pot life at 20°C	DX1020 DX1024	1hr15min.			
 Spray viscosity at 20°C	DIN 4 FORD 4 AFNOR 4	20-22 s 20-22s 22-24s			
 Spray equipment	Conventional guns Gravity feed Suction feed Pressure feed	Fluid tip	Distance	Pressure	
		1.4-1.6 mm 1.6-1.8 mm 1.0-1.2 mm	15-20 cm 15-20 cm 15-20 cm	3-4 bar 3-4 bar 3-4 bar	
	Compliant guns (HVLP/HTE) Gravity feed Suction feed Pressure feed	1.3-1.5 mm 1.5-1.6 mm 1.0-1.2 mm	10-15 cm 10-15 cm 10-15 cm	According to supplier's specifications	
 Number of coats	2				
 Flash time	5 min between coats. 5 min before bake.				
DFT	60-70 μ				
 Drying	Dust-free Dry to handle Tape-free	DX1020		DX1024	
		20°C	20 min x 60°C	20°C	25 min x 60°C
		50 min 5 hr 30 min. O.N.	imm. Imm. 1 hr 30 min	35 min 3 hr 8 hr	imm. Imm. 45 min
 IR drying*	Flash time Distance Half power Full power	5 min 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

Clearcoat application

When the basecoat is completely flat, apply DX1044 in 2 coats with 5 min flash between coats.

Chemical resistance

When fully cured, DX1044 is resistant to short exposures of the chemicals as listed:

sodium hydroxide	20 %	battery acid
sulphuric acid	25 %	Toluene
hydrochloric acid	20 %	Xylene
phosphoric acid	20 %	Glycol
ammonia	10 %	brake fluid, petrol

Equipment cleaning

Use a correct solventborne gunwash.

Recoatibility

At any time after tape-free time. After 24 hr, scuff sanding is required.

Remarks

- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Activated material should not be returned to original can of non-activated material.
- Material has to be at room temperature (18-25°C) before use.

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RECOMMENDED USE (con'd)

Product data

Package viscosity: 180 cp
Theoretical coverage: 7.9 m²/l at recommended DFT - ready-to-spray
Directive 2004/42/EC: 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.

Products	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
DX1044	1	4	0.998
DX1020	0.5	3	1.007
DX1024	0.5	3	1.007

Safety

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