

# DX44

## 2K FAST DRY CLEAR

### Description

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

### Products

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

### 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.

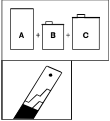
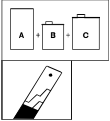








### Substrates

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

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### PRODUCT PREPARATION

	Mixing ratio		Very fast (15-20°C)		Fast (15-20°C)		Standard (20-25°C)		High temperature (> 30°C)			
			Volume	Weight	Volume	Weight	Volume	Weight	Volume	Weight		
		DX44	2	100	4	100	2	100	2	100		
		DX18	-	-	-	-	-	-	1	50		
		DX20	-	-	-	-	1	50	-	-		
		DX22	-	-	1	25	-	-	-	-		
		DX24	1	50	-	-	-	-	-	-		
		DX32	0.7	32	2	45	0.7	32	-	-		
		DX34	-	-	-	-	-	-	0.7	32		
VOC		DX18	-		-		-		609 g/l			
		DX20	-		-		601 g/l		-			
		DX22	-		627 g/l		-		-			
		DX24	602 g/l		-		-		-			
	Pot life at 20°C	DX18	2 hr									
		DX20	3 hr									
		DX22	4 hr									
		DX24	1 hr 30 min									
	Spray viscosity at 20°C	DIN 4	14-15 s									
		FORD 4	14-16 s									
		AFNOR 4	15-18 s									
	Spray equipment	Conventional guns	Fluid tip			Distance		Pressure				
			Gravity feed			1.4-1.6 mm		15-20 cm		3-4 bar		
			Suction feed			1.6-1.8 mm		15-20 cm		3-4 bar		
			Pressure feed			1.0-1.2 mm		15-20 cm		3-4 bar		
		Compliant guns (HVLP/HTE)	Gravity feed			1.3-1.5 mm		10-15 cm		According to supplier's specifications		
			Suction feed			1.5-1.6 mm		10-15 cm				
			Pressure feed			1.0-1.2 mm		10-15 cm				
	Number of coats	2-3										
	Flash time	5 min between coats. 5 min before bake.										
	DFT	55-65 µ										
	Drying	Dust-free Dry to handle Tape-free	DX18		DX20		DX22		DX24			
			20°C	40 min x 60°C	20°C	30 min x 60°C	20°C	20 min x 60°C	20°C	15 min x 60°C		
			45 min	imm.	35 min	imm.	25 min	imm.	15 min	imm.		
			6 hr	25 min	5 hr	25 min	3 hr 30 min	25 min	3 hr	20 min		
			O.N.	1 hr 15 min	O.N.	1 hr 15 min	4 hr 30 min	1 hr 30 min	4 hr	1 hr 15 min		
	IR drying*	Flash time	5 min									
		Distance	80 cm									
		Half power	5 min									
		Full power	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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## 2K FAST DRY CLEAR

### RECOMMENDED USE

#### Clearcoat application

When the DUXONE® Basecoat is completely flat, apply DX44 in 2 to 3 coats with 5 min flash between coats.

#### Chemical resistance

When fully cured, DX44 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.

#### Recoatability

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

#### Remarks

- If necessary for minor viscosity adjustments, use DUXONE® basecoat thinners (maximum 5 %).
- 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: 50-60 cp  
Theoretical coverage: 6.6-7.1 m<sup>2</sup>/l at recommended DFT - ready-to-spray

Products	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
DX44	1 - 4	2	0.974
DX18	0.5 - 1	2	0.972
DX20	0.25 - 0.5 - 1	2	0.959
DX22	0.25 - 0.5 - 1	2	0.986
DX24	0.5 - 1	2	0.962
DX32	1 - 5	2	0.874
DX34	1 - 5	2	0.903

#### Safety

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