DX62

2K HS PRODUCTIVE PRIMER

Description

Extremely fast drying, 2-component high solids primer.
Colour: medium grey.
Composition based on functional acrylic copolymer.

Products

DX62	2K HS Productive Primer
DX25	Activator
DX20	Standard Activator
DX22	HS Activator Fast
DX24	Activator Extra Fast
DX32	Thinner Fast
DX34	Standard Thinner

Properties

- Easy to apply, smooth flow.
- Very high productive primer: easy wet and dry sandability after 1 hr air dry, very short flash time between coats.
- Very easy to sand, many days after application.
- Superb filling.
- Can be coated with DUXONE® topcoat.

Substrates

- OEM finishes.
- Cured repair finishes.
- Sanded putties.
- Primed steel, zinc galvanised steel and aluminium.
- DUXONE® 1K Primer Filler DX61.

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PRODUCT PREPARATION

	Mixing ratio		**Standard** (DX25)		**Standard/Fast** (DX20/DX24)		**Fast** (DX22)	
			Volume	Weight	Volume	Weight	Volume	Weight
		DX62	3	100	4	100	6	100
		DX25	1	24	-	-	-	-
		DX20/DX24	-	-	1	18	-	-
		DX22	-	-	-	-	1	12
		DX32/DX34	-	-	0.5	8	1	11
	VOC	520 g/l						
	Pot life at 20°C	DX20/DX25	1 hr		1 hr		-	
		DX22/DX24	-		30 min		30 min	
	Spray viscosity at 20°C	**DIN 4**	22-28 s					
		FORD 4	22-28 s					
		AFNOR 4	24-30 s					
	Spray equipment		**Fluid tip**		**Distance**		**Pressure**	
		Conventional guns						
		Gravity feed	1.4-1.8 mm		20-25 cm		3-4 bar	
		Suction feed	1.6-1.8 mm		20-25 cm		3-4 bar	
		Pressure feed	1.0-1.2 mm		20-25 cm		3-4 bar	
		Compliant guns (HVLP/HTE)						
		Gravity feed	1.4-1.7 mm		15-20 cm		According to	
		Suction feed	1.6-1.8 mm		15-20 cm		supplier's	
		Pressure feed	1.0-1.2 mm		15-20 cm		specifications	
	Number of coats	1-3						
	Flash time	Between coats till flat. 10 min before bake.						
	DFT	50-100 µ						
	Dry to sand		**DX20/DX25**		**DX24**		**DX22**	
	at 15°C		2-3 hr		1-2 hr		1-2 hr	
	at 20°C		1-2 hr		1 hr		1 hr	
	at 40°C		30-40 min		30 min		30 min	
	at 60°C		30 min		20 min		25 min	
	IR drying*	Distance	80 cm		* Guideline for short/medium wave IR equipment.			
		Half power	5 min					
		Full power	10-15 min					

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

Surface preparation

- Before applying DX62, clean the surface, sand and degrease properly.

Equipment cleaning

Use a correct solventborne gunwash.

Remarks

- Do not use activated DX62 beyond the pot life nor reduce it further to get viscosity down again.
- For faster drying and/or at low temperatures DX62 can be activated with DX22 in volume ratio 4 to 1.
- If DX62 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.

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RECOMMENDED USE (con'd)

Product data

Package viscosity:	2500-3000 cp (at 5 rpm) 900-1200 cp (at 20 rpm)
Theoretical coverage:	7 m²/l at 50 µ DFT - ready-to-spray

Products	Packages (l)	Shelf life at 20°C (year)	Density (kg/l)
DX62	1	2	1.330
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
DX25	0.5	2	0.949
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.