

# DUXONE® BASECOAT

## ACRYLIC LACQUER

### Description

A new generation 1-component topcoat system for solid and metallic colours for use on cars. Composition based on acrylic copolymer.

### Products

DXT...	DUXONE® Tints
DXB208	Basecoat Binder
DX32	Thinner Fast
DX34	Standard Thinner

### Properties

- DUXONE® Basecoat combines ease of application and fast drying with the colour and gloss retention of high quality baking enamels.
- Can be used for spot, panel and overall repair of original refinishing as finishes or baking enamels.


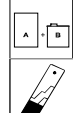






### Substrates

- all cleaned and sanded sound old finishes
- all OEM finishes and DUXONE® primers

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### PRODUCT PREPARATION

	<b>Colour tools</b>	See colour formula.		
	<b>Mixing ratio</b>	DUXONE® Basecoat DX32/DX34	1 0.5-0.8	
	<b>VOC</b>	720-750 g/li		
	<b>Pot life at 20°C</b>	Not applicable		
	<b>Spray viscosity at 20°C</b>	<b>DIN 4</b> <b>FORD 4</b> <b>AFNOR 4</b>	14-16 s 14-16 s 15-18 s	
	<b>Spray equipment</b>		<b>Fluid tip</b>	<b>Spray distance</b>
		<b>Gravity feed</b> <b>Suction feed</b>	1.2-1.6 mm 1.4-1.8 mm	15-20 cm 15-20 cm
	<b>Spray pressure</b>		<b>Overall, panel and spot repair</b>	
		<b>Gravity feed</b> <b>Suction feed</b>	3-4 bar (30-50 PSI) 3-4 bar (30-50 PSI)	
	<b>Number of coats</b>	2-3		
	<b>Flash time</b>	Till flat between coats and before clearcoating. Tack rag-free after 20 min.		
	<b>DFT</b>	Metallics	10-20 μ	
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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## ACRYLIC LACQUER

### RECOMMENDED USE

#### Surface preparation

1. Clean surface with water and soap.
2. Degrease and wipe dry with clean cloth.
3. Repair according to damage.
4. Sand:  
dry mechanical P320 - P400 (finally with P500 will give best results);  
wet P800 - P1000.
5. Degrease.
6. Wipe dry and tack rag.

#### Clearcoat application

DUXONE<sup>®</sup> clear must be applied when DUXONE<sup>®</sup> Basecoat is completely flat.  
Maximum time before clearcoating is 3 days.

#### Remarks

- Excessive coats of colour will slow up drying, avoid heavy coats.
- Material has to be at room temperature (18-20°C) before use.

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## ACRYLIC LACQUER

### RECOMMENDED USE (con'd)

#### Product data

Theoretical coverage: 5-7 m<sup>2</sup>/li at recommended DFT - ready-to-spray

Products	Packages (li)	Storability at 20°C (year)	Density (kg/li)
DXT111	4	2	/
DXT131	4	2	/
DXT1..	1	2	/
DXT2..	1	3	/
DXB208	4	2	0.911
DX32	1 - 5	1	0.874
DX34	1 - 5	1	0.874

#### Safety

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

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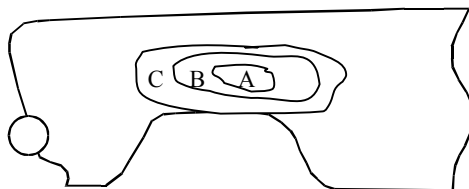
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### REPAIR SYSTEMS

#### Spot and panel repair - surface preparation

1. Repair with recommended undercoats according to damage.
2. Sand primed spots as recommended.
3. Prepare complete blending area with fine rubbing compound.
4. Clean carefully afterwards.

#### Spot and panel repair - system



- Apply 1 coat DUXONE<sup>®</sup> Basecoat over the primer spot (A). Flash 5-10 min. Wipe off spray dust with tack rag in zone B-C (if needed).
- Apply 2 to 3 coats. Extend each coat slightly beyond the previous one and always allow each coat to flash (5-10 min.) before applying the next coat. Tack wipe after each coat to eliminate spray dust around the colour coat (if needed).