

TECHNICAL DATA SHEET

DUXONE®
AUTOMOTIVE PAINT SYSTEMS

CLEARCOAT ADDITIVES



DESCRIPTION

Clearcoat additives allow end users to match and repair colours with high Chroma values in a cost effective manner. The different additives are packed in suitable 100ml cans.

PRODUCT LIST

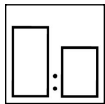
- AXT100 Clearcoat Additive Maroon 100
- AXT101 Clearcoat Additive Magenta 101
- AXT102 Clearcoat Additive Red 102
- AXT103 Clearcoat Additive Red 103
- AXT104 Clearcoat Additive Red 104
- AXT105 Clearcoat Additive Red 105
- AXT106 Clearcoat Additive Maroon 106
- AXT107 Clearcoat Additive Blue 107
- AXT108 Clearcoat Additive Orange 108
- AXT109 Clearcoat Additive Blue 109
- DX40 2K Clear
- DX44 2K Fast Clear
- DX46 2K HS Standard Clear
- DX48 2K HS Appearance Clear
- DX1044 2K Productive VOC Clear

CLEARCOAT ADDITIVES

Product preparation - application STANDARD



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Can be used with:	
2K Activated Clearcoat	DX40
	DX44
	DX46
	DX48
	DX1044
	DX1046

Product preparation according to the recommendations in the TDS of selected quality.
For recommended instructions see following pages.



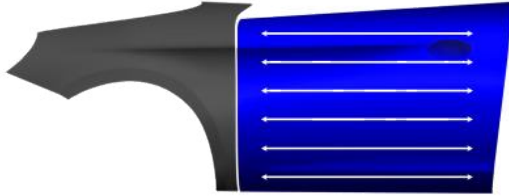
Refer to the original TDS of the selected quality.

VOC compliant

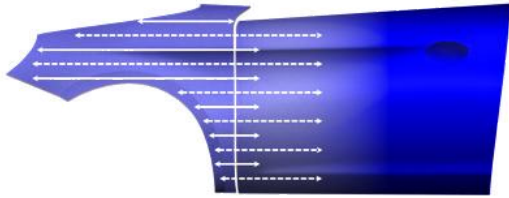
2004/42/IIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

CLEARCOAT ADDITIVES

Blend-in method for tinted Clears



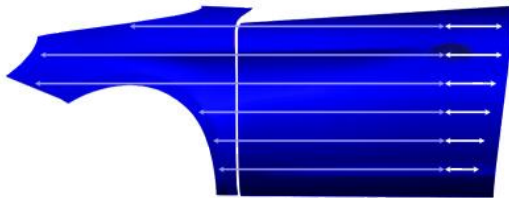
Adjacent panel: sand panel with suitable abrasive e.g. Trizact – P1000
New part / repair: sand surfacer (minimum P500)



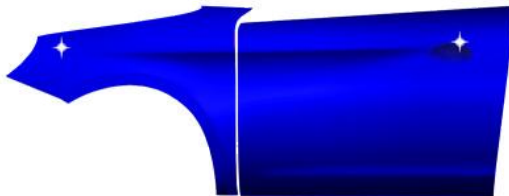
Apply the Basecoat in single coats to achieve full hiding. Flash off between coats and finish with an effect coat at reduced pressure. Flash off or dry the Basecoat according to the TDS recommendations. Activate the tinted and untinted clears as normal using the same activator in both. Consider using a slower activator to allow for easier application and for creating a smooth graduation between tinted and untinted clears.



Apply a single closed coat making sure you cover the Basecoat colour completely. Switch to the untinted clear and apply a single coat merging the 2 clears up to the panel edges or final blending zone. Flash off for 5 – 10 mins.
Note: The use of 2 spray guns or disposable cups is recommended.



Apply a second coat of tinted clear beyond the first to achieve the required finish. Make sure this coat is extended beyond the first coat of tinted clear. Switch to the untinted clear and apply a second coat to merge the 2 clears together to complete the repair to the panel edges or final blending area i.e. pillar. If a third coat is required flash off for 10 mins and repeat the previous process step. Fade out the untinted clear if required using DX32 as a fade out thinner. Ensure that you allow sufficient drying time of the final finish. Allow to cool fully before attempting further processing.



Allow the surface to fully cool before lightly sanding with P1000/P1200, take care not to sand through on edges and corners. Apply untinted clear as normal and dry as per TDS recommendations. After drying and cool down polish as normal if required.

CLEARCOAT ADDITIVES

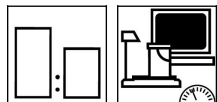
Products

AXT100 Clearcoat Additive Maroon 100
AXT101 Clearcoat Additive Magenta 101
AXT102 Clearcoat Additive Red 102
AXT103 Clearcoat Additive Red 103
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AXT105 Clearcoat Additive Red 105
AXT106 Clearcoat Additive Maroon 106
AXT107 Clearcoat Additive Blue 107
AXT108 Clearcoat Additive Orange 108
AXT109 Clearcoat Additive Blue 109

DX40 2K Clear
DX44 2K Fast Clear
DX46 2K HS Standard Clear
DX48 2K HS Appearance Clear

DX1044 2K Productive VOC Clear
DX1046 2K VOC Appearance Clear

Product mix



Mixing ratios with special agents are available in the productmix table on Colour Room and in the specific TDS.



Clean after use with a suitable solventbased cleaning thinner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Allow additional time for preheating up to panel temperature.
- Surplus ready for use material should not be returned to original can.
- Duxone Clears can be overcoated with themselves within 24 hours without intermediate sanding.
- Shake Clearcoat Additive cans by hand before use.
- Details can be found in Colour Room.
- For general information refer to the TDS of the respective Duxone Clear.

TECHNICAL DATA SHEET



CLEARCOAT ADDITIVES

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

All other products referred to in the refinish build up are from our Duxone product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Duxone product range, unless explicitly indicated otherwise.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.