



Duxone® DX800 Universal Clearcoat




COMPONENTS
DX800 Universal Clearcoat
DX900, DX901, DX902 or
DX903 Activator



APPLICATION
2 - 3 coats
5-10 minute flash to hand
slick between coats



MIX RATIO
2 : 1




DRY TIME
Air dry:
Hand slick – 30 minutes @ 77°F

Bake: 30 Minutes @ 140°F



VISCOSITY
Zahn #2
17-18 seconds



VOC
503 grams / liter
4.2 lbs / gallon



GENERAL

DESCRIPTION

This two-component high build VOC-compliant clearcoat is designed to provide excellent gloss and flow characteristics. Duxone® DX800 Universal Clearcoat ensures a proper film build after application of only two full coats. Specifically designed for complete resprays and panel repairs over Duxone Basecoat.

COMPATIBLE COATINGS

Compatible with Duxone primer, sealer, and clearcoat products

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

Mix 2 parts Duxone DX800 Universal Clearcoat to 1 part Duxone Activator.



Component	Volume
Duxone DX800 Universal Clearcoat	2
Duxone Hardener (DX900 Very Fast, DX901 Fast, DX902 Medium, DX903 Slow)	1

Package Sizes

- 1 gallon (3.785 liters)
- 1.057 quart (1 liter)

INITIAL APPLICATION VISCOSITY

Zahn #2 - 17-18 seconds

POT LIFE

When mixed, 3 hours @ 77°F/25°C
 Note: Accelerator will shorten pot life.

ADDITIVE

DX800 Universal Clearcoat may be used with Axalta VS6200 Matte Base Additive to achieve matte, eggshell, and sheen gloss levels. See VS6200 Matte Base Additive TDS for complete mixing instructions.



APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.3 -1.4 mm	2.0 - 2.5 (Bar)	8-10 PSI	*At the cap
High Efficiency	1.3 - 1.4 mm	2.0 - 2.5 (Bar)	27-32 PSI	At gauge



NOTE: Refer to spray gun manufacturer for further information regarding HVLP Inlet Pressures

SURFACE PREPARATION

Apply basecoat as needed and allow to flash 15 to 20 minutes @ 77°F/25°C.

APPLICATION

Apply 2 to 3 single coats allowing flash to hand slick (5-10 min.) between coats.

Notes:

- Cooler temperatures and thicker films may require longer flash times.
- Do not expose to rain or excessive moisture for 24 hours.
- Applying decals best after 7 days or full cure to avoid decal blistering. Applying more than 3 coats is not recommended.
- When baking, no flash time needed. Go straight to bake.

RECOAT

Can be recoated after 24 hours. Best after full cure (7 days @ 77°F/25°C).



DRY TIMES

AIR DRY

77°F (25°C)

Hand Slick	30 Minutes
Dust Free	45 Minutes
Hard Dry	24 Hours
To Light Polish	8 Hours
To Heavy Compound	24 Hours
Force Dry Time	30 Minutes @ 140°F (60°C)



PHYSICAL PROPERTIES

Recommended Film Thickness	25-30 micron / 1.0-1.5 mils per coat, dry film
Mixed Volume Solids	41.8% (Average)
Theoretical Coverage	N/A
Recommended Coats	2 (x1)
DFT per Coat	Approximately 1.0-1.5+ mil

STORAGE CONDITIONS

Store in a dry, well ventilated area. Storage temperatures should be between -30°F (-34°C) and 120°F (48°C).

PERFORMANCE PROPERTIES

Solvent Resistance	MEK pass 100 rubs Xylene pass 1000 rubs
Chemical Resistance	Acid (HCl) – No effect, 6 hrs. Base (NaOH) – No effect, 6 hrs.
Film Hardness	2H
Impact Resistance	Forward – 80 in/lbs Reverse – 40 in/lbs
Flexibility	Pass Conical Mandrel
Crosslinking	All crosslinking stop at 60°F/15°C

VOC REGULATED AREAS

VOC as Applied 503 grams/liter | 4.2 lbs/gallon

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Revised: June 2021

In the United States:
1.855.6.AXALTA
duxone.us

In Canada:
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