



Duxone® DX215 Primer Filler




COMPONENTS
 DX215 Primer Filler
 DX900, DX901, or DX902 Activator
 DX565, DX575, or DX585 Reducer



APPLICATION
 1-3 coats
 5-10 minute flash off between coats




MIX RATIO
 4 : 1 : 1



DRY TIME
 To sand: 45 minutes to 1 hour
 (per coat) @ 75°F



VISCOSITY
 Ford #4
 18 seconds



VOC
 534 grams / liter
 4.46 lbs / gallon



GENERAL

DESCRIPTION

Duxone® DX215 Primer Filler is a two-component high-build primer filler (surfacers) for automotive refinishing and new bodywork. DX215 offers fast dry times, delivering excellent sanding characteristics while providing a stable substrate for all refinishing essentials.

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

COLOR

- DX215 Grey



MIXING

COMPONENTS

Mix 4 parts Duxone DX215 Primer Filler to 1 part Duxone Activator to 1 part Duxone National Rule Reducer (a spray viscosity of 18 secs with Ford #4 @77°F/25°C).

NOTE: If used without thinning, can cause improper drying issues.



Component	Volume
Duxone DX215 Primer Filler	4
Duxone Activator (DX900 Very Fast, DX901 Fast, DX902 Medium)	1
Duxone National Rule Reducer (DX565 Fast, DX575 Medium, DX585 Slow)	1

Package Sizes

- 1 gallon (3.785 Liters)

INITIAL APPLICATION VISCOSITY

Ford #4 - 18 seconds

POT LIFE

1 hour @75°F(24°C)



APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.4 - 1.6 mm	1.0 - 1.25 (Bar)	6 - 8 PSI	*At the cap
High Efficiency	1.4 - 1.6 mm	1.0 - 1.25 (Bar)	17 - 19 PSI	At gauge



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

SURFACE PREPARATION

Degrease then sand body filler with P180 – P320 grit sandpaper. Abrade steel with P180 grit sandpaper. Existing surfaces (Featheredge); use P180 – P400 grit sandpaper. Large bare metal areas should be coated with an etch primer before priming with 431-40.

APPLICATION

Apply 1 – 3 single coats depending on desired film build. Allow 5 – 10 minutes flash off between coats. Brush or roll on for small repairs; apply 1 even coat to beyond the featheredge; a second coat if needed, after the first coat has tacked up, to within ¾ inch of the first coat.



DRY TIMES

AIR DRY

75°F (24°C)

To Sand	45 minutes – 1 hour (per coat)
To Topcoat	Must be sanded first
Rolled or Brushed	Overnight dry is required

INFRARED SHORT WAVE

15 Minutes full power @36"

NOTE: Topcoat within 6 – 7 hours after initial sanding or re-scuffing is necessary.



PHYSICAL PROPERTIES

Recommended Film Thickness	± 63.5 microns / 2-3 mils per coat
VOC as Applied	4.46 lbs/gallon (RFU)
Mixed Volume Solids	45.5% (Average)
Theoretical Coverage	Approx. 611 SqFt @ 1 Mil DFT/mixed gallon
Recommended Coats	2-3 (x1)
Film Thickness	2.0 – 3.0 mils per coat
Recommended Dry Film After Sanding	1.5 – 3.0 mils per coat
Pot Life	45 Minutes @77°F(25°C)
Flash Point	See SDS

STORAGE CONDITIONS

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

VOC REGULATED AREAS

VOC as Applied

534 grams/liter | 4.46 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.

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In the United States:
1.855.6.AXALTA
duxone.us

In Canada:
1.800.668.6945

