

Duxone® DX862 Low VOC Clearcoat - Universal



COMPONENTS

DX862 Low VOC Clearcoat - Universal
DX954,DX955
Low VOC Activator



APPLICATION

2 single wet coats
10 minute flash between coats



MIX RATIO

2 : 1



DRY TIME

Air dry
Dust-free: 30 minutes @ 77°F
Bake: 30 minutes @ 140°F



VISCOSITY

Zahn #2
17-19 seconds



VOC

245 grams / liter
2.0 lbs / gallon



GENERAL

DESCRIPTION

Duxone DX862 Low VOC Clearcoat - Universal is a two-component high build, medium solids clearcoat formulated for the Duxone LV Basecoat system. It offers excellent gloss and flow characteristics and is designed to deliver a proper film build after application of two coats.

COMPATIBLE COATINGS

Compatible with Duxone Low VOC basecoat.

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



MIXING

COMPONENTS

Mix 2 parts Duxone DX862 Low VOC Clearcoat - Universal to 1 part Duxone Low VOC Activator.

Component

Component	Volume
Duxone DX862 Low VOC Clearcoat - Universal	2
Duxone Low VOC Activator (DX954 Normal, DX955 Slow)	1

Package Sizes

- 1 gallon (3.785 liters)
- 1 quart (0.95 liters)

INITIAL APPLICATION VISCOSITY

Zahn #2 Viscosity 17-19 seconds



APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.2 -1.4 mm	8 - 10 PSI	at the cap
High Efficiency	1.2 -1.4 mm	28 - 35 PSI	at the gauge

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

SURFACE PREPARATION

Apply basecoat as needed and allow to flash 20 to 30 minutes @ 77°F (25°C). When applying over a water basecoat, should flash an additional 20 minutes @ 77°F (25°C) after dry process.

APPLICATION

Apply 2 single wet coats with 10 minute flash off between coats. Recoatability: Can be recoated after 24 hours. Best after full cure: 7 days @ 77°F (25°C).

Notes:

- Do not expose to rain or excessive moisture for 24 hours.
- Cooler temperatures and thicker films may require longer flash times.
- Applying graphics best after 7 days or a full cure.
- 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)**

Dust Free	30 minutes
Hard Dry	24 hours
To Light Polish	6-8 hours
To Heavy Compound	12 hours
Force Dry Time	30 minutes @ 140°F (60°C)
Infrared Short Wave	15-20 minutes full power @36"



PHYSICAL PROPERTIES

Theoretical Coverage:at 1 mil	665 ft ² /RTS Gal (16.3 m ² /RTS L)
Recommended Dry Film Thickness:	2.0 to 2.5 mil in 1 coat
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

All Values Ready To Spray

	Standard Reduction (2:1)
Max. VOC (LE)	245 g/L (2.0 lbs./gal)
Max. VOC (AP)	143 g/L (1.2 lbs./gal)
Avg. Gal. Wt.:	1108 lbs/gal (9.25lbs/gal)
Avg. Wt.% Volatiles:	58.3%
Avg. Wt.% Exempt Solvent:	45.4%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	41.7%
Avg. Vol.% Water:	0.0%

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

