



# Duxone® National Rule Basecoat




**COMPONENTS**  
Duxone Basecoat Color  
DX565, DX575, DX585 Reducers



**APPLICATION**  
2 - 3 coats  
4 - 8 minute flash  
between coats




**MIX RATIO**  
2 : 1



**DRY TIME**  
15 - 20 Minutes



**VISCOSITY**  
Zahn #2  
17-18 seconds



**VOC**  
779 grams / liter  
6.5 lbs / gallon



## GENERAL

### DESCRIPTION

A 6.5 lbs/gal | 779 grams/liter VOC basecoat system designed for use on cars, commercial vehicles and equipment; as well as for repairs to existing OEM two and three stage systems and design work. The basecoat has been formulated with a high quality range of light fast pigments to meet the OEM color standards. Good coverage and ease of application provide the refinisher with a quality product.

### NOT RECOMMENDED FOR USE OVER

Use over 1K substrates

### 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 Basecoat Color to 1 part Duxone Reducer. Thin to spray viscosity of 16 secs with #4 Ford @ 77°F/25°C for spraying.



Option for longer re-coating: Add 5% hardener to premixed basecoat.

Component	Volume
Duxone Basecoat Color	2
Duxone Reducers (DX565 Fast, DX575 Medium, DX585 Slow)	1

**Package Sizes**

- 1 gallon
- 1 quart
- 1 pint

**INITIAL APPLICATION VISCOSITY**

Ford #4 Viscosity 16 seconds




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**APPLICATION**

**APPLICATION EQUIPMENT**

HVLP Gravity	1.3 -1.4 mm	1.0 - 1.5 (Bar)	6-8 PSI	*At the cap
High Efficiency	1.3 - 1.4 mm	1.0 - 1.5 (Bar)	17-19 PSI	At gauge



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

**APPLICATION**

Apply 2 to 3 single coats with 4 - 8 minute flash off between coats. An additional coat may be required with colors difficult to cover. Not recommended over 1K substrates.

Option for metallics and blending basecoat: After the final coat of color, adjust the air pressure and apply a final medium-wet drop coat. (**Do not** dry spray color.) Flash off for 15 - 20 minutes before applying clear.

NOTE: Underhood and jambs.

METHOD 1: As an underhood color, the basecoat can be sprayed by adding 5% hardener to the mix without the need of clear coating. This matches many of the OEM hood colors.

METHOD 2: Integrate 20 - 50% hardened clear Duxone DX800 Clearcoat or Duxone DX820 Clearcoat into your already properly thinned basecoat. This provides more durability than Method 1 and is ideal when spraying jambs.

**\*\*IMPORTANT TECHNICAL NOTES:** To prevent white peeling when un-tapping, the best practice recommendation is when two-toning with white; slightly over-reduce, using a slower solvent AND 5% Duxone DX901 Fast hardener. Allow a 10 minute flash between coats, then a 20 minute minimum wait to unmask two-toned color and clear. When pulling the tape away AFTER the 20 minute minimum wait, pull the tape at a 45° angle using extreme care. Always spray white over P400-P500 grit sandpaper scratch. Do **not** apply Duxone White basecoat over adhesion promoter, as peeling does occur when using either on all panels that have been tested.

**BLENDING**

Apply a single coat of Duxone Blending Additive DX056 over the entire repair area. Allow the coat of blending additive to flash 4 – 8 minutes before applying the first coat of color. Apply the first color coat beyond the repaired area. Apply the second coat just beyond the first color coat. Each subsequent color coat should be applied just beyond the previous coat. Stay within the area in which the Duxone Blending Additive DX056 was applied. Flash 15 – 20 minutes, then apply clearcoat over the entire panel.

Add 5% Duxone Metallic Additive DX040 when blending difficult colors to the translucent blending step, Duxone Blending Additive DX056.

**RECOAT**

Must be recoated with clear after 15 minutes and before 12 hours or 24 hours when Hardener is added to the basecoat. Allow basecoat to properly flash before applying clearcoat. Cooler temperatures may require longer flash times.



**DRY TIMES**

**AIR DRY**

**75°F (23°C) & 50% RH at recommended film thickness**

Hand Slick	5 Minutes
Dust Free	5 Minutes
Tape Free	20 Minutes
To Clearcoat	15 - 20 Minutes
Dry to Handle	Overnight (after clear)
Flash Before Force Dry	N/A
To Sand/Buf	N/A



**PHYSICAL PROPERTIES**

Recommended Film Thickness	± 10 Micron / .mils
Mixed Volume Solids	11-13% (Average)
Theoretical Coverage	200.432 Sq. Ft. @ 1 Mil DFT/mixed gallon
Recommended Coats	2-3 (x1)
DFT per Coat	Approximately 0.5 mil

**MAXIMUM SERVICE CONDITIONS**

200°F (93°C).

**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 779 grams/liter | 6.5 lbs/gallon (RFU)

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**  
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**In Canada:**  
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