



Duxone® National Rule Blending Additive




COMPONENTS
Duxone Blending Additive
DX565, DX575, DX585 Reducers



APPLICATION
1 coat
4 - 8 minute flash off
before applying color




MIX RATIO
2 : 1



DRY TIME
To Clearcoat 15 - 20
Minutes



VISCOSITY
Zahn #2
28 - 29 Seconds



VOC
779 grams / liter
6.5 lbs / gallon



GENERAL

DESCRIPTION

Blending Additive DX056 is a specialized, colorless basecoat designed for tri-coats, wet beds, intercoat clear, design work and light or hard to control metallics. Color blender is not intended for use as a durable topcoat clear, it must be over coated with clearcoat. Specially formulated to be intermixed with Duxone topcoats.

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



MIXING

COMPONENTS

Wet bed-intercoat clear: Mix 2 parts Duxone Blending Additive DX056 to 1 part Duxone Reducer (DX565, DX575, or DX585)



Translucent blending procedure: Add equal amounts of reduced Duxone Blending Additive DX056 to the remaining reduced Duxone basecoat and mix well. This creates a translucent basecoat to be used in the blending process only, when spraying difficult colors.

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

Component	Volume
Duxone Blending Additive	2
Duxone Reducers (DX565 Fast, DX575 Medium, DX585 Slow)	1

Package Sizes

- 1 gallon

INITIAL APPLICATION VISCOSITY

Zahn #2 Viscosity 28 - 29 seconds



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

Wet Bed: Apply a single coat with 4 - 8 minute flash off before applying basecoat colors over wet bed.

Translucent blending: Apply an additional coat of this translucent basecoat color, blending out past the repair area.

RECOAT

Blending Additive must be clearcoated for durability. Allow Blending Additive and basecoat to thoroughly flash before applying clearcoat. Apply clearcoat within 12 hours or extend up to 24 hours when hardener is added to the basecoat. Cooler temperatures may require longer flash times.



DRY TIMES

AIR DRY

75°F (23°C)

Hand Slick	5 Minutes
Dust Free	5 Minutes
Tape Free	20 Minutes
To Clearcoat	15 - 20 Minutes
Dry to Handle	Overnight (after clear)



PHYSICAL PROPERTIES

Recommended Film Thickness	± 10 Micron / 0.39.mils
VOC as Applied	6.5 lbs/gallon (RFU)
Mixed Volume Solids	11-13% (Average)
Theoretical Coverage	Approx. 193 Sq. Ft. @ 1 Mil DFT/mixed gallon
Recommended Coats	2-3 (x1)
DFT per Coat	Approximately 0.5 mil
Zahn #2 Viscosity	28 – 29 Seconds

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

Max VOC (LE): 791.8 g/L (6.6 lbs./gal)

Max VOC (AP): 791.3 g/L (6.6 lbs./gal)

Avg. Gal. Wt: 7.71 lbs./gal

Avg. Wt.% Volatiles: 85.682%

Avg. Wt.% Exempt Solvent: 0%

Avg. Wt.% Water: 0.076%

Avg. Vol.% Exempt solvent: 0.0%

Avg. Vol.% Water: 0.071%

Flash Point: See SDS

Theoretical Coverage: 184.66 Sq Ft/Gal at 1 Mil

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: December 2021

In the United States:
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In Canada:
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