



## Duxone® DX822 Clearcoat - Panel




**COMPONENTS**  
DX822 Clearcoat - Panel  
DX900, DX901, DX902, DX903  
Activator



**APPLICATION**  
2-3 single coats  
Allow 10 minutes flash off  
between coats




**MIX RATIO**  
3 : 1



**DRY TIME**  
Air dry:  
Hand slick: 20 minutes @77°F  
Bake: 30-40 Minutes @140°F



**VISCOSITY**  
Zahn #2  
17-19 seconds



**VOC**  
511 grams / liter  
4.3 lbs / gallon



### GENERAL

#### DESCRIPTION

This two-component high build medium solids clear coat is formulated for the Duxone Basecoat system. It is quick dry with excellent gloss and flow characteristics. Duxone DX822 Clearcoat - Panel is designed to provide a proper film build after application of two coats.

#### COMPATIBLE COATINGS

Compatible with Duxone basecoat.

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



### MIXING

#### COMPONENTS

Mix 3 parts Duxone DX822 Clearcoat - Panel to 1 part Duxone Activator. Mixed VOC 4.2 lbs/gal.

Component	Volume
Duxone DX822 Clearcoat - Panel	3
Duxone Activator (DX900 Very Fast, DX901 Fast, DX902 Normal, DX903 Slow)	1

#### Package Sizes

- 1 gallon (3.875 liters)
- 1 quart (0.95 liter)

#### INITIAL APPLICATION VISCOSITY

Zahn #2 Viscosity 17-19 seconds

**POT LIFE**

When mixed, 3 hours @ 77°F (25°C)




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**APPLICATION**

**APPLICATION EQUIPMENT**

HVLP Gravity	1.3 -1.4 mm	8-10 PSI	at the cap
High Efficiency	1.3 - 1.4 mm	27-32 PSI	at thegauge

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). When applying over a water basecoat, allow an additional 20 minutes.

**APPLICATION**

Apply 2 to 3 single coats allowing 10 minute flash off between coats or hand slick.

Notes:

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




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**DRY TIMES**

**AIR DRY**

**77°F (25°C)**

Hand Slick	20 Minutes
Hard Dry	24 Hours
To Light Polish	6 Hours
To Heavy Compound	10 Hours
Force Dry Time	30-40 Minutes @140°F (60°C)
Infrared Short Wave	3-5 Minutes half power followed by 10-15 Minutes full power @ 36"




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**PHYSICAL PROPERTIES**

Recommended Film Thickness	25-30 microns / 1.0-1.25 mils per coat, dry film
Recommended Dry Film Thickness:	2.0 to 2.5 mil in 2 coat
Mixed Volume Solids	37% (Average)
Recommended Coats	2 (x1)
Theoretical Coverage at 1 mil	526 ft 2/RTS Gal (12.9 m 2/RTS L)
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).

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**VOC REGULATED AREAS**

All Values Ready To Spray

	<b>Standard Reduction (3:1)</b>
Max. VOC (LE)	511 g/L (4.3 lbs./gal)

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.

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**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**

