



Duxone® DX267 Low VOC Primer Filler




COMPONENTS

DX267 Low VOC Primer Filler
DX954 or DX955 Low VOC Activator
DX500 Low VOC Thinner




APPLICATION

Apply 1 – 3 single coats
5-10 minute flash between coats



MIX RATIO

5 : 1 : 1




DRY TIME

1 hour @ 77°F (25°C) per coat
30 minutes @140°F (60°C)



VISCOSITY

Zahn #3
14-17 seconds



VOC

232 grams / liter
1.9 lbs / gallon



GENERAL

DESCRIPTION

Duxone DX267 Low VOC Primer Filler is a high-build, two-component primer filler (surfacers) for automotive refinishing and new bodywork. DX267 is designed to provide an excellent substrate for all refinishing with excellent gloss hold out.

COMPATIBLE SUBSTRATES

Thoroughly sanded OEM finishes adjoining metal. Thoroughly sanded and cured paint adjoining metal. Properly cleaned and prepared steel, aluminum, galvanized steel following an etch primer. Properly prepared semi-rigid plastic and fiberglass.

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



MIXING

COMPONENTS

5 parts DX267 Low VOC Primer Filler to 1 part Duxone Low VOC Activator. Reduce with 1 part Duxone Low VOC Thinner. Spray viscosity of 14-17 secs with Zahn #3 @ 77°F (25°C)

Maximum RFU (ready for use) VOC 2.1 lbs/gal.

Component	Volume
Duxone DX267 Low VOC Primer Filler	5
Duxone Low VOC Activator (DX954 Normal or DX955 Slow)	1
Duxone DX500 Low VOC Thinner	1

POT LIFE

45 minutes @ 77°F (25°C)

Package Sizes

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

INITIAL APPLICATION VISCOSITY

Zahn #3 Viscosity 14-17 seconds.



APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.7 -1.9 mm	6-8 PSI	at the cap
High Efficiency	1.7 -1.9 mm	17-19 PS	at the gauge

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

SURFACE PREPARATION

Degrease then sand with P180-P320 grit sandpaper. Abrade steel with P80-P180 grit sandpaper. Dry sand P360-P400 grit sandpaper. Existing surfaces (featheredge); P180-P400 grit sandpaper. Large areas of bare metal should be etch primed prior to application of DX267 Low VOC Filler Primer.

APPLICATION

Shake or stir product before use. Be sure that primer is thoroughly mixed. Apply 1-3 single coats depending on desired film build. Allow 5-10 minute flash off between coats.



DRY TIMES

AIR DRY

To Sand/Buf	1 hour @ 77°F (25°C) per coat
	30 minutes @140°F (60°C) metal temperature
Wet-on-Wet	30 minutes @77°F (25°C) (for small repairs)

Infrared Short Wave	15 minutes full power @36"
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PHYSICAL PROPERTIES

Theoretical Coverage: at 1 mil	621 ft ² /RTS Gal(15.3 m ² /RTS L)
Recommended Dry Film Thickness:	1.6 to 2.0 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 (5:1:1)
Max. VOC (LE)	232 g/L (1.9 lbs./gal)
Max. VOC (AP)	122 g/L (1.0 lbs./gal)
Avg. Gal. Wt.:	1470 g/L (12.27 lbs./gal)
Avg. Wt.% Volatiles:	46.8%
Avg. Wt.% Exempt Solvent:	38.5%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	47.7%
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

