


Duxone® DX277 Low VOC Primer Sealer




COMPONENTS
DX277 Low VOC Primer Sealer
DX954 or DX955 LV Activators



APPLICATION
1 medium wet coat




MIX RATIO
5 : 1



DRY TIME
Air dry @ 77°F (25°C)
To topcoat – 20-30 Minutes
To nib sand – 20-30 Minutes



VISCOSITY
Zahn #2
17-19 seconds



VOC
246 grams / liter
2.1 lbs / gallon



GENERAL

DESCRIPTION

Duxone DX277 Low VOC Primer Sealer is a non-sanding urethane sealer that applies smoothly and maintains superior color and gloss retention for high quality finishes. DX277 Low VOC Primer Sealer is designed to increase inter-coat adhesion while providing a uniform ground coat over repairs.

COMPATIBLE SUBSTRATES

Thoroughly sanded OEM finishes adjoining metal. Thoroughly sanded and cured paint adjoining metal. Properly cleaned and prepared steel, aluminum and 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

Mix 5 parts Duxone DX277 Low VOC Primer Sealer to 1 part Duxone Low VOC Activator. . Maximum RFU (ready for use) VOC 2.1 lbs/gal.

Component	Volume
Duxone DX277 Low VOC Primer Sealer	5
Duxone Low VOC Activator (DX954 Medium or DX955 Slow)	1

Package Sizes

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

COLOR

- DX277 Grey

INITIAL APPLICATION VISCOSITY

Zahn #2 17-19 seconds

POT LIFE

60 minutes @77°F (25°C)



APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.3 - 1.4 mm	8 - 10 PSI	at the cap
High Efficiency	1.3 - 1.4 mm	25 - 35 PSI	at the gauge

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

SURFACE PREPARATION

Remove dust or oxidation prior to applying primer by media blasting, grinding or sanding. Be certain all surfaces are free of waxes, oils, grease or other contaminants.

Do not use over lacquer primer, laquer finishes or uncured substrates.

APPLICATION

Apply 1 single medium wet coat. Allow 20-30 minutes flash prior to topcoating with solvent basecoat.

30 minute flash when topcoating with water basecoat.



DRY TIMES

AIR DRY

77°F (25°C)

To Sand (Dry Nib)	20-30 Minutes (longer in cooler shops)
To Topcoat	20-30 Minutes (longer under water basecoat)

Flash time to basecoat with water base may be longer depending on shop conditions.



PHYSICAL PROPERTIES

Theoretical Coverage:at 1 mil	546 ft ² /RTS Gal (13.4 m ² /RTS L)
Recommended Dry Film Thickness:	0.8 to 1.2 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)
Max. VOC (LE)	246 g/L (2.1 lbs./gal)
Max. VOC (AP)	117 g/L (1.0 lbs./gal)
Avg. Gal. Wt.:	1377 g/L (11.49 lbs./gal)
Avg. Wt.% Volatiles:	55.6%
Avg. Wt.% Exempt Solvent:	47.1%
Avg. Wt.% Water:	0.0%
Avg. Vol.% Exempt Solvent:	52.6%
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

