



DULUX®

Armorspray®

424 J0006 2:1 2K Clearcoat

Dulux Australia
ABN 67 000 049 427

Product Name:

424-J0006 Dulux® Armorspray® 2:1 2K Clearcoat

Product Description:

Dulux® Armorspray® 2:1 2K Clearcoat is a premium quality high gloss two pack clear top coat designed specifically for use in the Dulux® Armorspray® 2:1 2K colour system.
For use in the application of plastic components, please refer overleaf for mixing ratios.

Product & Additives:

Dulux® Armorspray® 2:1 2K Clearcoat 424-J0006
Dulux® AutoSpeed® 2K Hardener Normal 980-89290
Dulux® AutoSpeed® 2K Hardener Slow 980-S0028
Dulux® AutoSpeed® RP Hardener-Fast 980-89790 Cold Temperatures /Rapid Production
Dulux® AutoSpeed® 2K Thinner-Normal 920-89292
Dulux® AutoSpeed® RP Thinner-Fast 920-89819 Cold Temperatures /Rapid Production
Dulux® AutoSpeed® 2K Thinner-Slow 920-89847 High Temperatures

	Mixing Ratio	2 Parts 424-J0006
	Hardener	1 Part 980-89290, 980-S0028 (Large Areas) or 1 Part 980-89790 (Small areas)
	Thinner	0-5% by Vol. 920-89292 or 920-89819 (Small areas) 920-89847 (High Temperatures Large areas)
	Spray Viscosity DIN Cup 4 @ 25°C	16-18 seconds
	Gravity Feed	Fluid Tip: CONVENTIONAL: 1.2 - 1.5mm HVLP: 1.5 - 1.9mm Spraying Pressure: 400 kPa/ 4 bar 200 kPa/ 2 bar Or refer to manufacturer's recommendations
	Suction Feed	CONVENTIONAL: 1.4 - 1.8mm HVLP: 1.8 - 2.2mm 400 kPa/ 4 bar 200 kPa/ 2 bar. Or refer to manufacturer's recommendations
	Application	1 st coat Light to Medium 2 nd coat Medium to wet (2 coats Max)
	Air Flash	3 - 5 minutes air flash






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	Baking	30 mins @ 60°C (980-89290) 15 mins @ 60°C (980-89790)
	Infrared	Short wave: 8 mins Medium wave: 10 - 15 mins
	Spraying	Use air fed mask at all times. Refer to applicable AS/NZS Standards

Recommendation:

Dulux recommend the complete painting of panels to provide maximum durability when applying topcoats such as clear coats. Blend outs will not give the appropriate film builds required and may break down prematurely.



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Weight Mixing Ratios for 424-J0006 Armorspray 2:1 2K Clear and Flex 485-89930

a. Using the Intelligent balance and adding by percentage addition

Note: This order of addition must be maintained when using the intelligent balance. The RFU quantity is approximately twice the clear that you start with.

424-J0006 Armorspray Clear	100
485-89930 Flex Additive	20.0%
980-89292 2K Hardener	58.3%
920-89292 2K Thinner	5.3%

The quantity of thinner added can be varied to suit your spraying conditions.
See notes below regarding alternate thinners and hardener.

b. Using an ordinary balance and adding by grams.

Volume of RFU Clear (ml)	424-J0006 Clear (g)	485-89930 Flex (g)	980-89290 Hardener* (g)	920-89292 Thinner ** (g)
50	24.69	4.94	17.28	2.47
100	49.39	9.88	34.56	4.93
150	74.09	14.82	51.84	7.4
200	98.78	19.76	69.12	9.86
250	123.48	24.7	86.4	12.33
300	148.17	29.64	103.68	14.79
350	172.9	34.58	121	17.23
400	197.6	39.52	138.2	19.72
450	222.2	44.46	155.5	22.19
500	247.0	49.4	172.8	24.65
550	271.6	54.34	190.1	27.11
600	296.3	59.28	207.4	29.58
650	321.0	64.22	224.6	32.04
700	345.7	69.16	241.9	34.51
750	370.4	74.1	259.2	36.98
800	395.1	79.04	276.5	39.44
850	419.8	83.98	293.8	41.90
900	444.5	88.92	311.0	44.37
950	469.2	93.86	328.3	46.84
1000 (1L)	493.9	98.8	345.6	49.3

* Use 980-89790 Autospeed RP 2K Hardener for improved production times

** Use 920-89819 Autospeed RP Thinner in cold weather or
920-89847 Autospeed Hot Weather Thinner as required.



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Weight Mixing Ratios for 424-J0006 Armorspray 2:1 2K Clear

b. Using the Intelligent balance and adding by percentage addition

Note: This order of addition must be maintained when using the intelligent balance. The RFU quantity is approximately twice the clear that you start with.

424-J0006 Armorspray Clear	100.00%
980-89292 2K Hardener	50.00%
920-89292 2K Thinner	5.00%

The quantity of thinner added can be varied to suit your spraying conditions.
See notes below regarding alternate thinners and hardener.

b. Using an ordinary balance and adding by grams.

Volume of RFU Clear (ml)	424-J0006 Clear (g)	980-89290 Hardener* (g)	920-89292 Thinner ** (g)
50	31.35	15.68	2.35
100	62.70	31.36	4.70
150	94.05	47.03	7.05
200	125.41	62.71	9.40
250	156.76	78.39	11.75
300	188.11	94.07	14.10
350	219.46	109.75	16.45
400	250.81	125.43	18.80
450	282.16	141.10	21.15
500	313.51	156.78	23.50
550	344.86	172.46	25.86
600	376.22	188.14	28.21
650	407.57	203.82	30.56
700	438.92	219.49	32.91
750	470.27	235.17	35.26
800	501.62	250.85	37.61
850	532.97	266.53	39.96
900	564.32	282.21	42.31
950	595.68	297.88	44.66
1000 (1L)	627.03	313.56	47.01

* Use 980-89790 Autospeed RP 2K Hardener for improved production times

** Use 920-89819 Autospeed RP Thinner in cold weather or
920-89847 Autospeed Hot Weather Thinner as required.



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Weight Mixing Ratios for 424-J0006 Armorspray 2:1 2K Clear With Autospeed MT Flatting Base 48589915

Matt Clearcoat

c. Using the Intelligent balance and adding by percentage addition

Note: This order of addition must be maintained when using the intelligent balance. The RFU quantity is approximately twice the clear that you start with.

424-J0006 Armorspray Clear	100.00%
485-89915 Autospeed MT Flatting Base	92.21%
980-89292 2K Hardener	51.79%
920-89292 2K Thinner	34.46%

The quantity of thinner added can be varied to suit your spraying conditions.
See notes below regarding alternate thinners and hardener.

b. Using an ordinary balance and adding by grams.

Volume of RFU Clear (ml)	424-J0006 Clear (g)	485-89915 Flatting Base	980-89290 Hardener* (g)	920-89292 Thinner ** (g)
50	16.97	15.65	8.79	5.85
100	33.95	31.30	17.58	11.70
150	50.92	46.96	26.37	17.55
200	67.90	62.61	35.17	23.40
250	84.87	78.26	43.96	29.25
300	101.84	93.91	52.75	35.10
350	118.82	109.57	61.54	40.95
400	135.79	125.22	70.33	46.80
450	152.77	140.87	79.12	52.65
500	169.74	156.52	87.91	58.50
550	186.71	172.18	96.71	64.35
600	203.69	187.83	105.50	70.20
650	220.66	203.48	114.29	76.05
700	237.64	219.13	123.08	81.90
750	254.61	234.79	131.87	87.75
800	271.58	250.44	140.66	93.60
850	288.56	266.09	149.46	99.45
900	305.53	281.74	158.25	105.30
950	322.51	297.40	167.04	111.15
1000 (1L)	339.48	313.05	175.83	117.00

* Use 980-89790 Autospeed RP 2K Hardener for improved production times

** Use 920-89819 Autospeed RP Thinner in cold weather or
920-89847 Autospeed Hot Weather Thinner as required.



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Weight Mixing Ratios for 424-J0006 Armorspray 2:1 2K Clear With Autospeed MT Flatting Base 48589915

Satin Clearcoat

d. Using the Intelligent balance and adding by percentage addition

Note: This order of addition must be maintained when using the intelligent balance. The RFU quantity is approximately twice the clear that you start with.

424-J0006 Armorspray Clear	100
485-89915 Autospeed MT Flatting Base	46.11%
980-89292 2K Hardener	51.79%
920-89292 2K Thinner	27.58%

The quantity of thinner added can be varied to suit your spraying conditions.
See notes below regarding alternate thinners and hardener.

b. Using an ordinary balance and adding by grams.

Volume of RFU Clear (ml)	424-J0006 Clear (g)	485-89915 Flatting Base	980-89290 Hardener* (g)	920-89292 Thinner ** (g)
50	21.22	9.78	10.99	5.85
100	42.43	19.57	21.98	11.70
150	63.65	29.35	32.97	17.55
200	84.87	39.13	43.96	23.40
250	106.09	48.91	54.95	29.25
300	127.30	58.70	65.93	35.10
350	148.52	68.48	76.92	40.95
400	169.74	78.26	87.91	46.80
450	190.95	88.04	98.90	52.65
500	212.17	97.83	109.89	58.51
550	233.39	107.61	120.88	64.36
600	254.60	117.39	131.87	70.21
650	275.82	127.17	142.86	76.06
700	297.04	136.96	153.85	81.91
750	318.26	146.74	164.84	87.76
800	339.47	156.52	175.82	93.61
850	360.69	166.30	186.81	99.46
900	381.91	176.09	197.80	105.31
950	403.12	185.87	208.79	111.16
1000 (1L)	424.34	195.65	219.78	117.01

* Use 980-89790 Autospeed RP 2K Hardener for improved production times

** Use 920-89819 Autospeed RP Thinner in cold weather or
920-89847 Autospeed Hot Weather Thinner as required.



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For Safe Handling:

Please refer to the Material Safety Data Sheet No: 003041 for this product before use. This product may contain materials that are being introduced to Australia under a permit.

In the event of an emergency contact: 1 800 033 111 (ALL HOURS)

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