

Universal Flexibilizer

DX814

DX814 Universal Flexibilizer when used as recommended will form a coating that will withstand the customary abuse of impact and flexing in topcoats and undercoats during and after installation of the part.

Preparation: Apply **DPX801 Universal Plastics Adhesion Promoter** to bare plastic substrate before applying flexibilized undercoat or color. See bulletin P-194 for proper preparation.
If the DX814 is stored in a cold area, it must be allowed to come up to room temperature and shaken before use.

Mixing by Volume:

Undercoat	Mix Ratio	Product	Reducer	Hardener	DX814	Pot Life	VOC Less Water, Less Exempt lbs/gal (g/l)
K36 Surfacer RTS *	10:1	10	–	–	1	1½ hrs.	4.69 (562)
K36 Sealer RTS	10:1	10	–	–	1	1½ hrs.	4.60 (551)
K38 RTS*	10:1:1	10	1	–	1	³ / ₄ – 1 hr.	4.55 (545)
K93 Surfacer RTS *	10:1	10	–	–	1	1 hr.	4.71 (564)
K93 Sealer RTS	10:1	10	–	–	1	1 hr.	4.59 (550)
NCP250/260 RTS	5:1	5	2	–	1	2 hrs.	5.33 (639)
DAS3025 RTS	10:1	10	–	–	1	1 hr.	4.63 (555)
DSL3025	10:1	10	–	–	1	¹ / ₂ – 1 hr.	3.13 (375)
DPS3055 RTS	10:1	10	–	–	1	¹ / ₂ – 1 hr.	4.72 (566)
DPLV3055 RTS	10:1	10	–	–	1	¹ / ₂ – 1 hr.	2.63 (315)

RTS = Ready to Spray

* When using DX814 to flexibilize these surfacers, use K201 primer surfacer catalyst only.

Color	Mix Ratio	Product	Reducer	Hardener	DX814	Pot Life	VOC Less Water, Less Exempt lbs/gal (g/l)
DCC/DU5 or DU6	2:1:2:1	2	1	2	1	2 hrs.	4.85 (581)
DCC/DCX9,61	2:1:1:1	2	1	1	1	3 hrs.	4.55 (545)
CLV/DCX61 + 1oz. DX84/87 RTS qt	2:1:2:1	2	1	2	1	1 hr.	3.46 (415)
DAR/DXR80	8:4:2:1	8	4	1	2	8 hrs.	5.10 (611)

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Mixing by Volume *continued*:

Color	Mix Ratio	Product	Reducer	Hardener	DX814	Pot Life	VOC Less Water, Less Exempt lbs/gal (g/l)
DCU2002/DCX8, 9, or 61	4:1:2:2	4	1	2	2	1 – 2 hrs.	4.03 (483)
DCU2010/DCX20xx	2:1:1	2	–	1	1	1 – 2 hrs.	2.98 (357)
DCU2021/DCX8, 9, or 61	4:1:2:2	4	1	2	2	1 – 2 hrs.	4.03 (483)
DCU2035/DCX + 1oz. DX84/RTS qt	1:1:1:1	1	1	1	1	4 hrs.	4.34 (520)
DCU2042/DCX9 or 61	4:1:2:1	4	1	2	1	1 – 2 hrs.	3.90 (467)
DCU2082 / DCH208x	2:2:1	2	–	2	1	3 hrs.	4.46 (534)
DC3000 / DCH30xx	3:1:1/2	3	–	1	1/2	1 – 2 hrs.	3.98 (477)
DC3010 / DCH35xx	3:1:1/2	3	–	1	1/2	1 – 2 hrs.	2.52 (302)
DC4000 / DCH30xx	3:1:1/2	3	–	1	1/2	1 – 2 hrs.	4.19 (502)
DC4010 / DCH35xx	3:1:1/2	3	–	1	1/2	1 – 2 hrs.	2.50 (300)

Note: The following products do not require DX814 for use over flexible substrates:
Deltron® (DBU), *Deltron*® 2000 (DBC) or any other basecoat products.

Technical Data:	Color	Clear Liquid
	VOC (Package)	5.10 lbs./US Gal (611 g/l)
	Weight Solids	34.1%
	Volume Solids	29.4%
	Flash Point (PMCC)	82°F (28°C)

Important: The contents of this package must be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Material Safety Data Sheet and Labels for additional safety information and handling instructions.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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