1 Refinishing Systems for Commercial Vehicles NON-VOC

1-1 Guarantee Systems for Commercial Vehicles

1-1-1 Guarantee Systems for Metal Substrates
1-1-1-1 VOC – Guarantee System V5

1-2 Quality Refinishing System for Commercial Vehicles

1-2-1 Quality Refinishing System for Metal Substrates
1-2-1-1 VOC Quality Refinishing Systems
1-2-1-2 VOC – Quality Refinishing System V1
1-2-1-3 VOC – Quality Refinishing System V2
1-2-1-4 VOC – Quality Refinishing System V3
1-2-1-5 VOC – Quality Refinishing System V4
1-2-1-6 Quality Refinishing Systems NON-VOC countries

1-2-2 Warranty Paint Systems for Plastic Substrates
1-2-2-1 Plastic – Warranty Refinishing Systems
1-2-2-2 Plastic – Warranty Refinishing System K1
1-2-2-3 Plastic – Warranty Refinishing System K2
1-2-2-4 Plastic – Warranty Refinishing System K3
1-2-2-5 Plastic – Warranty Refinishing System K4

2 More Information

2-1 [S1] Substrate pretreatment
2-2 [S9] Blending-in with Basecoat [Non-VOC]
2-3 [S10] Infrared drying
2-4 [T5] Conversion table
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3 Technical Data Sheets for Commercial Vehicles Refinishing

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3-1-2 Standofleet 2K Non Sanding Filler U2500 CV621
3-1-3 Standofleet Wash Primer 1:1 Transparent U2530 CV610
3-1-4 Standofleet 1K Welding Primer U2120 Red Brown CV611
3-1-5 Standofleet 2K Sealer Transparent U2020 CV622
3-1-6 Standofleet EP Primer Surfacer U7200 932 MB

3-2 Clear
3-2-1 Standofleet 2K HS Plus Clear K9360 CV655

3-3 Topcoat
3-3-1 Standofleet 2K HS Topcoat CV630
3-3-2 Standofleet 2K HS High Build Topcoat CV632

3-4 Others
3-4-1 Standofleet Silicone Remover CV666
3-4-2 Standofleet Degreaser CV667

3-5 NON-VOC Technical Data Sheets
3-5-1 Standofleet 2K MS Topcoat CV631
3-5-2 Standofleet 2K MS Clear K9310 CV652
## VOC Guarantee Systems for Mercedes-Benz

<table>
<thead>
<tr>
<th>Number</th>
<th>Application</th>
<th>System</th>
</tr>
</thead>
<tbody>
<tr>
<td>V5</td>
<td>Truck cabs / busses / vans</td>
<td>Sanding System</td>
</tr>
</tbody>
</table>

Guarantee systems for passenger cars can also be used for vans, commercial vehicles and busses.
VOC – Guarantee System V5 for Mercedes-Benz

<table>
<thead>
<tr>
<th>Application:</th>
<th>Truck cabs / busses / vans Sanding System</th>
</tr>
</thead>
<tbody>
<tr>
<td>Substrate:</td>
<td>Old paintwork</td>
</tr>
<tr>
<td></td>
<td>Replacement parts</td>
</tr>
<tr>
<td></td>
<td>Through-sanding to the bare metal</td>
</tr>
<tr>
<td></td>
<td>Damaged areas</td>
</tr>
<tr>
<td>Pretreatment / Cleaning:</td>
<td>Cleaning</td>
</tr>
<tr>
<td></td>
<td>Remove rust by sanding and blasting</td>
</tr>
<tr>
<td></td>
<td>Damaged areas with P 80 - P 150</td>
</tr>
<tr>
<td></td>
<td>Overlapping areas with P 180</td>
</tr>
<tr>
<td></td>
<td>Intact paintwork with P 400.</td>
</tr>
<tr>
<td></td>
<td>Reclean with Standohyd Degreaser TB 50.</td>
</tr>
<tr>
<td>Stopper:</td>
<td>Standox PE Rapid Stopper or</td>
</tr>
<tr>
<td></td>
<td>Standox PE Soft Stopper</td>
</tr>
<tr>
<td></td>
<td>Standox Spray Filler</td>
</tr>
<tr>
<td>Primer/ Filler:</td>
<td>Standox EP Primer Surfacer 3:1</td>
</tr>
<tr>
<td>Topcoat:</td>
<td>Standofleet 2K HS Topcoats</td>
</tr>
<tr>
<td></td>
<td>or</td>
</tr>
<tr>
<td></td>
<td>Standohyd Basecoat with</td>
</tr>
<tr>
<td></td>
<td>Standofleet 2K-HS-Klarlack</td>
</tr>
</tbody>
</table>
### VOC Quality Refinishing Systems for Mercedes-Benz

<table>
<thead>
<tr>
<th>Number</th>
<th>Application</th>
<th>System</th>
</tr>
</thead>
<tbody>
<tr>
<td>V1</td>
<td>Truck cabs / busses / vans</td>
<td>Wet on Wet System</td>
</tr>
<tr>
<td>V2</td>
<td>Truck cabs / busses / vans</td>
<td>Sanding System</td>
</tr>
<tr>
<td>V3</td>
<td>Respray</td>
<td>Wet on Wet System</td>
</tr>
<tr>
<td>V4</td>
<td>Chassis refinishing</td>
<td>Wet on Wet System</td>
</tr>
</tbody>
</table>

Guarantee systems for passenger cars can also be used for vans, commercial vehicles and busses.
### Pretreatment / Cleaning:

| Substrate:                  | Old paintwork
|                            | Replacement parts
|                            | Through-sanding to the bare metal
|                            | Damaged areas

### Application:

| Truck cabs / busses / vans
| Wet-on-Wet system

### Stopper:

| Standox PE Rapid Stopper or
| Standox PE Soft Stopper

### Primer on metal substrates:

| Standofleet 1K W elding Primer or
| Standofleet Wash Primer 1:1 Transparent

### Filler:

| Standofleet 2K Non Sanding Filler
| Standofleet 2K Primer Surfacer

### Topcoat:

| Standofleet 2K HS Topcoats
| Standohyd Basecoat with
| Standofleet 2K-HS-Klarlack
<table>
<thead>
<tr>
<th>Application:</th>
<th>Truck cabs / busses / vans Sanding System</th>
</tr>
</thead>
<tbody>
<tr>
<td>Substrate:</td>
<td>Old paintwork</td>
</tr>
<tr>
<td></td>
<td>Replacement parts</td>
</tr>
<tr>
<td></td>
<td>Through-sanding to the bare metal</td>
</tr>
<tr>
<td></td>
<td>Damaged areas</td>
</tr>
<tr>
<td>Pretreatment / Cleaning:</td>
<td>Cleaning</td>
</tr>
<tr>
<td></td>
<td>Remove rust by sanding and blasting</td>
</tr>
<tr>
<td></td>
<td>Damaged areas with P 80 - P 150</td>
</tr>
<tr>
<td></td>
<td>Overlapping areas with P 180</td>
</tr>
<tr>
<td></td>
<td>Intact paintwork with P 400.</td>
</tr>
<tr>
<td></td>
<td>Reclean with Standohyd Degreaser TB 50.</td>
</tr>
<tr>
<td>Stopper:</td>
<td>Standox PE Rapid Stopper or</td>
</tr>
<tr>
<td></td>
<td>Standox PE Soft Stopper</td>
</tr>
<tr>
<td></td>
<td>Standox Spray Filler</td>
</tr>
<tr>
<td>Primer on metal substrates:</td>
<td>Standofleet 1K Welding Primer or</td>
</tr>
<tr>
<td></td>
<td>Standofleet Wash Primer 1:1 Transparent</td>
</tr>
<tr>
<td>Filler:</td>
<td>Standofleet 2K Primer Surfacer</td>
</tr>
<tr>
<td>Topcoat:</td>
<td>Standofleet 2K HS Topcoats or</td>
</tr>
<tr>
<td></td>
<td>Standohyd Basecoat with</td>
</tr>
<tr>
<td></td>
<td>Standofleet 2K-HS-Klarlack</td>
</tr>
</tbody>
</table>
# VOC – Quality Refinishing System V3 for Mercedes-Benz

| Application:        | Respray  
|                    | Wet-on-Wet system |
| Pretreatment / Cleaning: | Clean with grey ultra fine sanding pad soaked in Standohyd Degreaser TB 50.  
|                    | Reclean with Standohyd Cleaner |
| Adhesion promoter: | Standofleet 2K Sealer Transparent or Standofleet 2K Primer Surfacer |
| Topcoat:           | Standofleet 2K HS Topcoats |
VOC – Quality Refinishing System V4 for Mercedes-Benz

| Application:       | Chassis refinishing  
                    | Wet-on-Wet system   |
|--------------------|----------------------|
| Substrate:         | OEM paintwork        
                    | Old paintwork       |
| Pretreatment / Cleaning: | Steam blasting by adding degreaser |
| Solvent test:      | Solvent test with 2K Thinner. 
                    | If the paintwork dissolves up to the bare steel it must be removed. |
| Adhesion promoter: | Standofleet 2K Primer Surfacer  
                    | or Standofleet 2K Sealer Transparent |
|                    | Bare metal parts must be pre-primed (1K Primer) |
| Topcoat:           | Standofleet 2K HS Topcoats |
Quality Refinishing Systems NON-VOC countries for Mercedes-Benz

<table>
<thead>
<tr>
<th>Application:</th>
<th>see VOC - Quality Refinishing Systems V1-V4</th>
</tr>
</thead>
<tbody>
<tr>
<td>Substrate:</td>
<td>see VOC - Quality Refinishing Systems V1-V4</td>
</tr>
<tr>
<td>Pretreatment / Cleaning:</td>
<td>see VOC - Quality Refinishing Systems V1-V4</td>
</tr>
<tr>
<td>Stopper:</td>
<td>see VOC - Quality Refinishing Systems V1-V4</td>
</tr>
<tr>
<td>Primer on metal substrates:</td>
<td>see VOC - Quality Refinishing Systems V1-V4</td>
</tr>
<tr>
<td>Filler:</td>
<td>see VOC - Quality Refinishing Systems V1-V4</td>
</tr>
</tbody>
</table>
| Topcoat:    | Standofleet 2K MS Topcoats  
Standox Basecoat with  
Standofleet 2K Clear |
## Plastic – Quality Refinishing Systems for Mercedes-Benz

<table>
<thead>
<tr>
<th>Number</th>
<th>Substrate</th>
</tr>
</thead>
</table>
| **K1** | Exterior hard plastic parts  
PP/EPDM, ABS, SAN, PC, PA, PUR,  
R-TPU, PPO, PBT |
| **K2** | Polystyrene |
| **K3** | GFK  
SMC (UP-GF) |
| **K4** | Exterior hard plastic parts (structure)  
PP/EPDM, ABS, PC, PA, PUR, R-TPU,  
PPO, PBT, UP-GF |

Guarantee systems for passenger cars can also be used for vans, commercial vehicles and busses.
### Plastic – Quality Refinishing System K1 for Mercedes-Benz

<table>
<thead>
<tr>
<th><strong>Application:</strong></th>
<th>Plastic-refinishing</th>
</tr>
</thead>
</table>
| **Substrate:**   | Exterior hard plastic parts  
PP/EPDM, ABS, SAN, PC, PA, PUR,  
R-TPU, PPO, PBT |
| **Pretreatment / Cleaning:** | Temper for 60 min / 60 - 65°C  
Clean several times with plenty of fresh  
Standoflex Plastic Cleaner Antistatic and ultra fine pad.  
Reclean with Standoflex Plastic Cleaner Antistatic.  
Temper for 20 min / 60 - 65°C  
Dry and prime |
| **Remove all traces of release agent!** |  |
| **Application:** | Standoflex 2K Plastic Primer Surfacer  
For filling small scratches and imperfections, after pre-priming with Standoflex 2K Plastic Primer Surfacer and drying according to instructions, apply Standox PE Fine Stopper.  
After denibbing the body filler spot should be isolated with Standoflex 2K Plastic Primer Surfacer. |
| **Important remark:** |  
Do not steam clean the finish within 6 weeks of application and drying.  
Then keep a minimum distance of 30 cm between the jet nozzle and the surface.  
Standox 2K Plastic Primer Surfacer  
Standohyd Basecoat and  
Standofleet 2K HS Clear with  
15% Standox 2K Plasticiser |
## Plastic – Quality Refinishing System K2 for Mercedes-Benz

<table>
<thead>
<tr>
<th>Application:</th>
<th>Plastic-refinishing</th>
</tr>
</thead>
<tbody>
<tr>
<td>Substrate:</td>
<td>Polystyrene</td>
</tr>
<tr>
<td><strong>Pretreatment / Cleaning:</strong></td>
<td></td>
</tr>
<tr>
<td>Remove all traces of release agent!</td>
<td></td>
</tr>
<tr>
<td>Temper for 60 min / 60 - 65°C</td>
<td>Clean several times with plenty of fresh</td>
</tr>
<tr>
<td></td>
<td>Standoflex Plastic Cleaner Antistatic and ultra fine pad.</td>
</tr>
<tr>
<td></td>
<td>Reclean with Standoflex Plastic Cleaner Antistatic.</td>
</tr>
<tr>
<td></td>
<td>Temper for 20 min / 60 - 65°C</td>
</tr>
<tr>
<td></td>
<td>Dry and prime</td>
</tr>
<tr>
<td><strong>Application:</strong></td>
<td></td>
</tr>
<tr>
<td><strong>Important remark:</strong></td>
<td>Do not steam clean the finish within 6 weeks of application and drying.</td>
</tr>
<tr>
<td></td>
<td>Then keep a minimum distance of 30 cm between the jet nozzle and the surface.</td>
</tr>
<tr>
<td></td>
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</tr>
<tr>
<td></td>
<td>Standohyd Stone Chip Primer</td>
</tr>
<tr>
<td></td>
<td>Drying</td>
</tr>
<tr>
<td></td>
<td>Standofleet 2K HS Topcoats with 15% Standox 2K Plasticiser or Standohyd Basecoat and Standofleet 2K HS Clear with 15% Standox 2K Plasticiser</td>
</tr>
</tbody>
</table>
Plastic – Quality Refinishing System K3 for Mercedes-Benz

<table>
<thead>
<tr>
<th>Application:</th>
<th>Plastic Painting</th>
</tr>
</thead>
<tbody>
<tr>
<td>Substrate:</td>
<td>GFK</td>
</tr>
<tr>
<td></td>
<td>SMC (UP-GF)</td>
</tr>
<tr>
<td>Pretreatment / Cleaning:</td>
<td>Temper for 60 min / 60 - 65°C</td>
</tr>
<tr>
<td></td>
<td>Clean several times with plenty of fresh</td>
</tr>
<tr>
<td></td>
<td>Standoflex Plastic Cleaner Antistatic and ultra</td>
</tr>
<tr>
<td></td>
<td>fine pad.</td>
</tr>
<tr>
<td></td>
<td>Reclean with Standoflex Plastic Cleaner Antistatic.</td>
</tr>
<tr>
<td></td>
<td>Temper for 20 min / 60 - 65°C</td>
</tr>
<tr>
<td></td>
<td>Dry and prime</td>
</tr>
<tr>
<td>Application:</td>
<td>Standofleet 2K Non Sanding Filler</td>
</tr>
<tr>
<td></td>
<td>Standofleet 2K HS Topcoats</td>
</tr>
<tr>
<td></td>
<td>or</td>
</tr>
<tr>
<td></td>
<td>Standofleet 2K Primer Surfacer</td>
</tr>
<tr>
<td></td>
<td>Standohyd Basecoat</td>
</tr>
<tr>
<td></td>
<td>with</td>
</tr>
<tr>
<td></td>
<td>Standofleet 2K-HS-Klarlack</td>
</tr>
</tbody>
</table>
## Plastic – Quality Refinishing System K4 for Mercedes-Benz

<table>
<thead>
<tr>
<th>Application:</th>
<th>Plastic painting with structure</th>
</tr>
</thead>
<tbody>
<tr>
<td>Substrate:</td>
<td>Exterior hard plastic parts PP/EPDM, ABS, PC, PA, PUR, R-TPU, PPO, PBT, UP-GF</td>
</tr>
<tr>
<td>Pretreatment / Cleaning:</td>
<td>Temper for 60 min / 60 - 65°C Clean several times with plenty of fresh Standoflex Plastic Cleaner Antistatic and ultra fine pad. Reclean with Standoflex Plastic Cleaner Antistatic. Temper for 20 min / 60 - 65°C Dry and prime</td>
</tr>
<tr>
<td>Remove all traces of release agent!</td>
<td></td>
</tr>
<tr>
<td>Application:</td>
<td>Standoflex 2K Plastic Primer Surfacer For filling small scratches and imperfections, after pre-priming with Standoflex 2K Plastic Primer Surfacer and drying according to instructions, apply Standox PE Fine Stopper.</td>
</tr>
<tr>
<td>Important remark:</td>
<td>After denibbing the body filler spot should be isolated with Standoflex 2K Plastic Primer Surfacer.</td>
</tr>
<tr>
<td>Do not steam clean the finish within 6 weeks of application and drying. Then keep a minimum distance of 30 cm between the jet nozzle and the surface.</td>
<td>Choose colour of Standofleet 2K HS Topcoat for intermediate coats similar to Basecoat. Standofleet 2K HS Topcoat structured to be hardened 5:1 with Standofleet 2K HS Hardener (1 spray pass). Overcoatable after 30 min / 18-22°C, max. 8 h / 18-22°C Standohyd Basecoat and Standofleet 2K HS Clear with 15% Standox 2K Plasticiser Solid painting: Standofleet 2K HS Topcoat structured to be hardened 5:1 with Standofleet 2K HS Hardener (1,5 spray passes).</td>
</tr>
</tbody>
</table>
Standox Painting Systems

Working Process: Substrate Pretreatment

<table>
<thead>
<tr>
<th>Substrates:</th>
<th>First Cleaning</th>
<th>Mechanical Pretreatment</th>
<th>Final Cleaning</th>
</tr>
</thead>
<tbody>
<tr>
<td>Bare</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Steel</td>
<td>Standox Silicone Remover or Standohyd Degreaser TB 50</td>
<td>Dry sand P80 - P220</td>
<td>Standox Silicone Remover or Standohyd Degreaser TB 50</td>
</tr>
<tr>
<td>Soft Aluminium</td>
<td>Standox Silicone Remover or Standohyd Degreaser TB 50</td>
<td>Dry sand P180 or Pad very fine</td>
<td>Standox Silicone Remover or Standohyd Degreaser TB 50</td>
</tr>
<tr>
<td>Galvanised Substrates</td>
<td>Standox Silicone Remover or Standohyd Degreaser TB 50</td>
<td>Pad ultra fine</td>
<td>Standox Silicone Remover or Standohyd Degreaser TB 50</td>
</tr>
<tr>
<td>Old Paintwork</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Through-hardened Paintwork</td>
<td>Standox Silicone Remover</td>
<td>Dry sand P320 - P400 Wet sand P600 - P800</td>
<td>Standox Silicone Remover or Standohyd Cleaner</td>
</tr>
<tr>
<td>Through-hardened 2K Paintwork</td>
<td>Standox Silicone Remover</td>
<td>Dry sand P320 - P400 Wet sand P600 - P800</td>
<td>Standox Silicone Remover or Standohyd Cleaner</td>
</tr>
<tr>
<td>Through-hardened VOC Paintwork</td>
<td>Standox Silicone Remover</td>
<td>Dry sand P320 - P400 Wet sand P600 - P800</td>
<td>Standox Silicone Remover or Standohyd Cleaner</td>
</tr>
<tr>
<td>Through-hardened Synthetic Paintwork</td>
<td>Standox Silicone Remover</td>
<td>Dry sand P320 - P400 Wet sand P600 - P800</td>
<td>Standox Silicone Remover or Standohyd Cleaner</td>
</tr>
<tr>
<td>TPA Paintwork</td>
<td>Standox Silicone Remover</td>
<td>Wet sand P600 - P800</td>
<td>Standox Silicone Remover</td>
</tr>
<tr>
<td>Cellulose Paintwork</td>
<td>Standox Silicone Remover</td>
<td>Wet sand P600 - P800</td>
<td>Standox Silicone Remover</td>
</tr>
<tr>
<td>Powder Coated Paintwork</td>
<td>Standox Silicone Remover</td>
<td>Dry sand P320 - P400 Wet sand P600 - P800</td>
<td>Standox Silicone Remover or Standohyd Cleaner</td>
</tr>
<tr>
<td>Soft Shop Paintwork</td>
<td>Standox Silicone Remover or Standohyd Cleaner</td>
<td>Dry sand P400 - P500 Wet sand P800</td>
<td>Standox Silicone Remover or Standohyd Cleaner</td>
</tr>
</tbody>
</table>
## Substrate Pretreatment

**Standox Painting Systems**

### Working Process:

#### Substrate Pretreatment

<table>
<thead>
<tr>
<th>Substrates</th>
<th>First Cleaning</th>
<th>Mechanical Pretreatment</th>
<th>Final Cleaning</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Pre-primed Substrates</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>EDP primed</td>
<td>if necessary Standox Primer</td>
<td>wet sand P600</td>
<td>standox Primer</td>
</tr>
<tr>
<td>1K Primer / Acid Primer</td>
<td>if necessary Standox Primer</td>
<td>wet sand P800</td>
<td>standox Primer</td>
</tr>
<tr>
<td>1K Cellulose Filler</td>
<td>if necessary Standox Primer</td>
<td>wet sand P800</td>
<td>standox Primer</td>
</tr>
<tr>
<td>2K Primer Surfacer / 2K / VOC Filler</td>
<td>if necessary Standox Primer</td>
<td>dry sand P400 - P500</td>
<td>Standohyd Cleaner</td>
</tr>
<tr>
<td>Synthetic Primer / Synthetic Filler</td>
<td>if necessary Standox Primer</td>
<td>wet sand P800</td>
<td>standox Primer</td>
</tr>
<tr>
<td>TPA Filler</td>
<td>if necessary Standox Primer</td>
<td>wet sand P800</td>
<td>standox Primer</td>
</tr>
<tr>
<td>Powder Primer</td>
<td>if necessary Standox Primer</td>
<td>wet sand P600 - P800</td>
<td>standox Primer</td>
</tr>
</tbody>
</table>

*) First cleaning as recommended is sufficient if the substrate is a perfect EDP primer coat.
## Substrate Pretreatment

### Working Process:

#### Substrate Pretreatment

<table>
<thead>
<tr>
<th>Substrates</th>
<th>Tempering</th>
<th>First cleaning Mechanical Pretreatment</th>
<th>Final Cleaning</th>
<th>Ventilation of the Solvents</th>
</tr>
</thead>
<tbody>
<tr>
<td>Plastics</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>PC</td>
<td>60 min / 60-65°C</td>
<td>Use a Pad ultra fine soaked in Standoflex Plastic Cleaner antistatic</td>
<td>Use a cloth moistened with Standoflex Plastic Cleaner antistatic</td>
<td>Air dry overnight/ 18-22°C or 20 min/ 60-65°C panel temperature</td>
</tr>
<tr>
<td>PP / EPDM</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>PVC</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>ABS and SAN</td>
<td></td>
<td></td>
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</tr>
<tr>
<td>UP-GF (former GRP)</td>
<td></td>
<td></td>
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<td></td>
</tr>
<tr>
<td>PU-RIM</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>RTPU</td>
<td></td>
<td></td>
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<tr>
<td>PUR</td>
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<td>PA 1)</td>
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<tr>
<td>PPO</td>
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<td>PBTP</td>
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<td>PS (Polystyrene) 2)</td>
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</tr>
<tr>
<td>PE (Polyethylene)</td>
<td>cannot be (re)finished at bodyshops</td>
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</tr>
<tr>
<td>POM (Polyoxymethyl)</td>
<td>cannot be (re)finished</td>
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</tbody>
</table>

1) PA parts which have been tempered and oven-dried after painting should not be assembled immediately (risk of fracture).

2) Further treatment see Standohyd Stone Chip Primer.

Depending on the heat resistance of the plastic, suitable supports must be used for the add-on parts to avoid deformation.
Standox Painting Systems

Working Process:  Blending-in with Basecoat (Spot Repair)

Substrate:  
- For preparation of repair areas see Standox Painting System S3. Keep surface for priming with filler as small as possible.

Pretreatment / Cleaning:  
- Sand the repair area with P800 and an ultra fine pad

For substrate preparation information see Standox Painting System S1.

Painting:  
- Apply Standox Basecoat Colourless

- Thin Standox Basecoat to 18-20 s / DIN 4mm / 20°C (45-53 s / ISO 4mm / 20°C) and reduce spray pressure by 0.5 - 1.0 bar.

- Overcoat the repair area and overlap each spray pass over a larger area.

- Apply Standocryl 2K Clear to entire repair panel.
# STANDOX PAINTING SYSTEMS

## WORKING PROCESS:

<table>
<thead>
<tr>
<th>Why choose Infrared drying?</th>
<th>Infrared drying</th>
</tr>
</thead>
<tbody>
<tr>
<td>➢ Greater shop throughput with excellent through-drying</td>
<td></td>
</tr>
<tr>
<td>➢ Time savings</td>
<td></td>
</tr>
<tr>
<td>➢ Lower energy consumption</td>
<td></td>
</tr>
<tr>
<td>➢ Greater economy</td>
<td></td>
</tr>
</tbody>
</table>

## How to use Infrared drying:

- The distance between the panel and Infrared emitter depends on the equipment used. Refer to manufacturer's instructions.
- Observe safety rules and regulations.

## Important remarks:

- Drying times may vary due to different models and different heating elements.
- If infrared drying is used, each film layer should be individually infrared-dried to prevent peeling and solvent popping.
# STANDOX PAINTING SYSTEMS

## WORKING PROCESS:

**Infrared drying**

<table>
<thead>
<tr>
<th>Standox Products</th>
<th>Medium wave radiator</th>
<th>Short wave radiator</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Flash off time</td>
<td>100% Power</td>
</tr>
<tr>
<td>Ground materials:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>PE Stopper</td>
<td>5 min.</td>
<td>5 - 7 min.</td>
</tr>
<tr>
<td>PE Fillers</td>
<td>5 min.</td>
<td>15 min.</td>
</tr>
<tr>
<td>2K Fillers</td>
<td>10 - 12 min.</td>
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</tr>
<tr>
<td><strong>Standohyd</strong> Basecoat:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>dark colours</td>
<td>3 min.</td>
<td>2 min.</td>
</tr>
<tr>
<td>bright colours</td>
<td>4 - 6 min.</td>
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<tr>
<td><strong>Standocryl 2K Autolack:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>dark colours</td>
<td>5 min.</td>
<td>12 min.</td>
</tr>
<tr>
<td>bright colours</td>
<td>5 min.</td>
<td>14 min.</td>
</tr>
<tr>
<td><strong>Standocryl 2K Clears:</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>with dark Basecoat</td>
<td>5 min.</td>
<td>13 - 16 min.</td>
</tr>
<tr>
<td>with bright Basecoat</td>
<td>5 min.</td>
<td>15 - 18 min.</td>
</tr>
</tbody>
</table>

*1 = If too hot solvent boil

This guide for drying times is based on:

- **Medium wave** = Infrared Type: SH 4 (Manufacturer: Fa. Heraeus)
- **Short wave** = Infrared Type: IRT 202 (Manufacturer: Fa. IRT)

(Infrared distance 80 - 100 cm. Observe manufacturer’s distance guidelines.)
# Conversion Table

## 1. Air Pressure

1 PSI (1 lb/sq.inch) = 0.0689 bar

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<thead>
<tr>
<th>bar</th>
<th>PSI</th>
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<tr>
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<td>3.0</td>
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<td>6.0</td>
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## 2. Temperature

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<th>°F</th>
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<td>90</td>
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### Conversion Table

#### 3. Viscosity

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<tr>
<th>DIN 4 mm/s</th>
<th>FORD 4 mm/s</th>
<th>BSB 4 mm/s</th>
<th>ISO 3 mm/s</th>
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<th>ISO 5 mm/s</th>
<th>AFNOR /s</th>
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## 4. Liquid Measure

<table>
<thead>
<tr>
<th>Unit (UK)</th>
<th>Conversion</th>
</tr>
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<tbody>
<tr>
<td>1 oz. (ounce)</td>
<td>28.41 ml</td>
</tr>
<tr>
<td>1 pt. (pint)</td>
<td>0.568 l</td>
</tr>
<tr>
<td>1 qt. (quart)</td>
<td>1.137 l</td>
</tr>
<tr>
<td>1 gal. (gallon)</td>
<td>4.546 l</td>
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</tbody>
</table>

<table>
<thead>
<tr>
<th>Unit (USA)</th>
<th>Conversion</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 oz. (ounce)</td>
<td>29.57 ml</td>
</tr>
<tr>
<td>1 qt. (quart)</td>
<td>0.946 l</td>
</tr>
<tr>
<td>1 gal. (gallon)</td>
<td>3.785 l</td>
</tr>
</tbody>
</table>

## 5. Weight

<table>
<thead>
<tr>
<th>Unit (UK)</th>
<th>Conversion</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 oz. (ounce)</td>
<td>28.35 g</td>
</tr>
<tr>
<td>1 lb. (pound)</td>
<td>453.59 g</td>
</tr>
<tr>
<td>1.0 kg (kilogramme)</td>
<td>2.205 lb.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Unit (USA)</th>
<th>Conversion</th>
</tr>
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<tbody>
<tr>
<td>1 oz. (ounce)</td>
<td>28.35 g</td>
</tr>
<tr>
<td>1 lb. (pound)</td>
<td>453.59 g</td>
</tr>
<tr>
<td>1.0 kg (kilogramme)</td>
<td>2.205 lb.</td>
</tr>
</tbody>
</table>
## Standox Painting Systems

### Conversion Table

#### 6. Linear Measure

- 1 in. (inch) = 2.54 cm
- 1 ft. (foot) = 30.48 cm
- 1 yd. (yard) = 91.44 cm

  - 1.0 mm (millimetre) = 0.0394 in.
  - 1.0 cm (centimetre) = 0.394 in.
  - 1.0 m (metre) = 39.4 in

(1.09 yds.)

#### 7. Coverage

- 1,0 m² = 10.7639 ft²

#### 8. Film Thickness

<table>
<thead>
<tr>
<th>micron</th>
<th>mill</th>
</tr>
</thead>
<tbody>
<tr>
<td>(1 micron = 0.0394 mills)</td>
<td>(1 mill = 25.4 micron)</td>
</tr>
<tr>
<td>10</td>
<td>0.4</td>
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<tr>
<td>20</td>
<td>0.8</td>
</tr>
<tr>
<td>30</td>
<td>1.2</td>
</tr>
<tr>
<td>40</td>
<td>1.6</td>
</tr>
<tr>
<td>50</td>
<td>2</td>
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<td>75</td>
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</tr>
<tr>
<td>100</td>
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</table>
Pictograms

1. Preparation

1.1 Cleaning

2. Mixing

2.1.1 Mixing ratio 2 components
2.1.2 Mixing ratio 3 components
2.1.3 Mixing ratio 1:1 2 components
2.2 Use mixing stick
2.3 Addition of hardener

3. Viscosity

3.1 Application viscosity

4. Application

4.1 Gravity feed spray gun
4.2 Suction feed
4.3 Underseal spray gun
4.4 Spray passes Gravity feed Compliant
4.4.1 Spray passes Suction feed
**Pictograms**

4.4.2  
Spray passes  
Gravity feed  
HVLP

4.4.3  
0,5 + 1  
One visit application

4.4.4  
1 + 0,5  
One visit application

4.4.5  
1 + 1  
One visit application

4.5  
Application of stopper

4.6  
Application with brush

4.7  
Application with roller

4.8  
Aerosol

4.9  
Airless spray

5.1  
Flash off

5.2  
Drying time

5.3  
Infrared drying time

5.4  
UV flash

6.1  
Sanding by hand, wet

6.2  
Sanding by Hand, dry

6.2.1  
Denibbing

6.3  
Orbital sander, wet (compressed air)

6.4  
Orbital sander, dry

6.5  
Flat bed sander, wet (compressed air)

6.6  
Flat bed sander, dry

6.7  
Polishing
7. Technical Information

7.1 See Technical Data Sheet

7.2 Use fresh air mask

8. Storage

8.1 Store free from frost

8.2 Store in a cool place

8.3 Protect from humidity

8.4 Close tin

8.5 Shelf life

9. Miscellaneous

9.1 Stirring

9.2 Stirring on the mixing machine

9.3 Check colour

9.4 Poor opacity

9.5 Three-coat process

9.6 Shaking
## Technical Data Sheets CV

<table>
<thead>
<tr>
<th>Product Group</th>
<th>Product Description</th>
<th>TDS No.</th>
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<tbody>
<tr>
<td><strong>Pre-materials</strong></td>
<td>Wash Primer 1:1 U2530</td>
<td>6.10</td>
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<tr>
<td></td>
<td>1K Welding Primer Red Brown U2120</td>
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<td>2K Primer Surfacer U2510</td>
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<td>2K Non-Sanding Filler U2500</td>
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<td>2K Sealer Transparent U2020</td>
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<td>Standofleet Activator U2540</td>
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<td>Standox EP Primer Surfacer U7200</td>
<td>932 MB</td>
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<td><strong>Clearcoats</strong></td>
<td>Standofleet 2K HS Plus Clear K9360</td>
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<td>Standofleet Silicone Remover</td>
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<td>Standofleet Degreaser</td>
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<td>Standofleet 2K MS Clear K9310</td>
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</tr>
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</table>
2K-Grundierfüller U2510
2K Primer Surfacer U2510

- For all purposes
- Good filling properties
- Good vertical stability

Technical Description:
- Mix
  3:1 with Standofleet 2K MS Hardener
  6:1 with Standofleet 2K HS Hardener

- Wet-on-wet or sanding filler
- Adhesion promoter for Chassis painting
- Air dry overnight/18-22°C
- Force drying possible
STANDOFLEET 2K-Grundierfüller U2510

**Substrate:**
- Through-hardened sanded paintwork
- Standofleet Primer U2530, U2550
- Standox Polyester substrates, sanded
- UP-GF, sanded
- Original primed repair panels
- Primed metal substrates
- Coil Coating

**Application:**

**Wet-on-wet filler**

- 3:1 with Standofleet 2K MS Hardener
  - Potlife 2h/18 - 22°C
- 15% Standofleet 2K Thinner
  - 17-18 s/DIN 4 mm/20°C
  - 41-45 s/ISO 4 mm/20°C
- Compliant 1.4 - 1.5 mm
  - Spray pressure 2.5 - 3 bar
  - 1 Spray pass = 20 - 30 micron
- HVLP 1.4 - 1.5 mm
  - Atomising pressure 0.7 bar
  - 1 Spray pass = 20 - 30 micron
- Membrane pump 1.1 mm
  - Atomising pressure 2.5 - 3 bar
  - Material pressure 0.8 - 1.8 bar
  - 1 Spray pass = 20 - 30 micron
- Airmix 0.23 - 0.28 mm
  - Material pressure 50 - 120 bar
  - 1 Spray pass = 20 - 30 micron
- 30 - 60 min/18-22°C Flash off

**6:1 with**

- Standofleet 2K HS Hardener
- 30-35% Standofleet 2K Thinner
  - 17 - 18 s/DIN 4 mm/20°C
  - 41 - 45 s/ISO 4 mm/20°C

For substrate preparation see Standox Painting System S1

Use air fed respirator. Refer to relevant Health and Safety Data Sheets.

Standofleet 2K Topcoat, Standox Basecoat or Standoxyd Basecoat with Standofleet 2K HS Plus Clear K9360 / Standofleet 2K VOC Clear K9350
## Substrate:
- Through-hardened sanded paintwork
- Standofleet Primer U2530, U2550
- Standox Polyester substrates, sanded
- UP-GF, sanded
- Original primed repair panels
- Primed metal substrates
- Coil Coating

## Application:
### 2K Sanding Filler

<table>
<thead>
<tr>
<th>Material</th>
<th>Description</th>
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<tbody>
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<td>Potlife 2h/18 - 22°C</td>
</tr>
<tr>
<td>10% Standofleet 2K Thinner</td>
<td>20-22 s/DIN 4 mm/20°C</td>
</tr>
<tr>
<td>Compliant 1.4 - 1.6 mm</td>
<td>Spray pressure 2.5 - 3 bar</td>
</tr>
<tr>
<td>HVLP 1.4 - 1.6 mm</td>
<td>Atomising pressure 0.7 bar</td>
</tr>
<tr>
<td>Membrane pump 0.8 - 1.2 mm</td>
<td>Atomising pressure 2.5 - 3 bar</td>
</tr>
<tr>
<td>Airmix 0.23 - 0.28 mm</td>
<td>Material pressure 0.8 - 1.8 bar</td>
</tr>
<tr>
<td>Standofleet Primer U2530, U2550</td>
<td>Dry sand P360 - P500</td>
</tr>
<tr>
<td>Standox Polyester substrates, sanded</td>
<td>Wet sand P400 - P800</td>
</tr>
</tbody>
</table>

### Pretreatment / Cleaning:
- For substrate preparation see Standox Painting System S1
- Use air fed respirator. Refer to relevant Health and Safety Data Sheets.

### 6:1 with
- Standofleet 2K HS Hardener
- 25-30% Standofleet 2K Thinner
- 18 - 20 s/DIN 4 mm/20°C
- 45 - 53 s/ISO 4 mm/20°C

- Standofleet 2K Topcoat, Standox Basecoat or Standohyd Basecoat with
- Standofleet 2K HS Plus Clear K9360 /
- Standofleet 2K VOC Clear K9350
STANDOFLEET 2K-Grundierfüller U2510

**Substrate:**
Solvent test:

If the paintwork softens with Standofleet 2K Thinner the paintability must be tested.

- Painted Chassis
- Coil Coating

---

**Pretreatment / Cleaning:**

For substrate preparation see Standox Painting System S1

Use air fed respirator. Refer to relevant Health and Safety Data Sheets.

---

**Application: Adhesion promoter for Chassis painting**

**6:1 with**

Standofleet 2K HS Hardener

30% Standox Smart Blend

17 s/DIN 4 mm/20°C

41 s/ISO 4 mm/20°C

3:1 with Standofleet 2K MS Hardener

Potlife 2h/18 - 22°C

20% Standox Smart Blend

15 s / DIN 4mm / 20°C

33 s / ISO 4mm / 20°C

Compliant 1.4 mm

Spray pressure 2.5 - 3 bar

1 Spray pass = 20 micron

HVLP 1.4 - 1.6 mm

Atomising pressure 0.7 bar

1 Spray pass = 20 micron

Membrane pump 0.8 mm

Atomising pressure 2.5 - 3 bar

Material pressure 0.8 - 1.8 bar

1 Spray pass = 20 micron

Airmix 0.23 - 0.28 mm

Material pressure 50 - 120 bar

1 Spray pass = 20 micron

30 - 60 min/18-22°C Flash off

Standofleet 2K Topcoats
<table>
<thead>
<tr>
<th><strong>Flash point:</strong></th>
<th><strong>Cleaning of equipment:</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>• 25 - 26 °C / 77 - 78.8 °F</td>
<td>Clean immediately after use with Standox Cleaning Thinner.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>Specific Gravity:</strong></th>
<th><strong>Important remarks:</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>• 1.47 g/cm³</td>
<td>• For a Nonstop process the topcoat must be applied within 24 hours or drying and sanding is necessary.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>Solid Content (without thinner added):</strong></th>
<th><strong>• Filler is tintable up to 10% with Standofleet / Standomix mixing enamels or up to 20% with Standofleet Topcoat.</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>• 68.7 Weight %</td>
<td>Drying and sanding can be affected.</td>
</tr>
<tr>
<td>• 47.4 Volume %</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>Theoretical Coverage:</strong></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>• 15.7 m²/l at 30 micron dry film thickness</td>
<td></td>
</tr>
</tbody>
</table>

2K Paints react with moisture. Therefore all equipment must be kept moisture free. Ready to use paint materials containing isocyanates can cause irritation of the mucous membranes - and of the respiratory organs, in particular - and cause hypersensitive reactions. There is a risk of hypersensitization if the vapour or spray mist is inhaled. When using materials containing isocyanates, all precautions relating to the handling of solvents should be carefully followed. In particular, care should be taken not to inhale spray mist or vapour. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

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2K-Nass-in-Nass-Füller
U2500
2K Non-Sanding Filler
U2500

• Specially developed for economical wet-on-wet painting

• Excellent hold out

• 20% tinting capability with Standofleet Topcoat

Technical Description:

• Mix
  2:1 with Standofleet 2K MS Hardener or
  4:1 with Standofleet 2K HS Hardener

• 1 working spray pass

• Potlife up to 3 h/18 - 22°C
STANDOFLEET 2K-Nass-in-Nass-Füller U2500

Substrate:
- Repair panel, primed and sanded
- Through-hardened sanded paintwork
- Standofleet Primer U2530, U2550
- Standox Polyester substrates, sanded
- Primed metal substrates
- UP.GF
- Coil Coating

Application:

Wet-on-wet filler

1 spray pass = 25 - 30 micron

Pretreatment / Cleaning:
For substrate preparation see Standox Painting System S1

Use air fed respirator. Refer to relevant Health and Safety Data Sheets.

4:1 with
Standofleet 2K HS Hardener
35% Standofleet 2K Thinner
17 s/DIN 4 mm/20°C
41 s/ISO 4 mm/20°C
**STANDOFLEET 2K-Nass-in-Nass-Füller U2500**

**Flash point:**
- 26°C / 78.8°F

**Specific Gravity:**
- 1.30 - 1.35 g/cm³

**Solid Content (without thinner added):**
- 66.1 - 66.9 Weight %
- 48.5 - 53.2 Volume %

**Theoretical Coverage:**
- 16.6 m²/l at 30 micron dry film thickness

**Cleaning of equipment:**
Clean immediately after use with Standox Cleaning Thinner.

**Important remarks:**
- After drying from more than 24h/20°C the filler has to be sanded or recoated with itself (1.5 s/DIN 4 mm/20°C/33 s/ISO 4 mm/20°C) before being overcoated with topcoat.

- Filler is tintable up to 10% with Standofleet / Standomix mixing enamels or up to 20% with Standofleet Topcoat.

Drying and sanding can be affected.

---

2K Paints react with moisture. Therefore all equipment must be kept moisture free. Ready to use paint materials containing isocyanates can cause irritation of the mucous membranes - and of the respiratory organs, in particular - and cause hypersensitive reactions. There is a risk of hypersensitization if the vapour or spray mist is inhaled. When using materials containing isocyanates, all precautions relating to the handling of solvents should be carefully followed. In particular, care should be taken not to inhale spray mist or vapour. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

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Technical Description:

• Mix
  1:1 with Standofleet Activator U2540

• Potlife 8 h/18 - 22°C

• 2 spray passes

• Passivating Acid Primer

• Excellent adhesion

• For 3-stage systems

• Outstanding corrosion protection
**Substrate:**
- Bare metal, sanded
- Aluminium, sanded
- Galvanised metal, sanded
- Trough-sanded bare steel areas
- Stainless steel, sanded

**Application:**

1:1 mit Standofleet Activator U2540
Ready to spray
Potlife 8 h/18 - 22°C

Compliant 1.3 - 1.5 mm
Spray pressure 2.5 - 3 bar
2 spray passes = 8 - 10 micron

HVLP 1.3 - 1.5 mm
Atomising pressure 0.7 bar
2 spray passes = 8 - 10 micron

Membrane pump 1.1 mm
Atomising pressure 2.5 - 3 bar
Material pressure 0.8 - 1.8 bar
2 spray passes = 8 - 10 micron

Airmix 0.23 - 0.28 mm
Material pressure 50 - 120 bar
1 Spray pass = 8 - 10 micron

10 - 15 min/18-22°C Flash off between coats
30-60 min / 18-22°C final flash-off

Standofleet 2K Filler / 2K VOC Filler

---

**Pretreatment / Cleaning:**

For substrate preparation see
Standox Painting System S1

Use air fed respirator. Refer to
relevant Health and Safety
Data Sheets.
**STANDOFLEET Wash-Primer 1:1 U2530**

<table>
<thead>
<tr>
<th><strong>Flash point:</strong></th>
<th><strong>Cleaning of equipment:</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>• 26°C / 78.8°F</td>
<td>Clean immediately after use with Standox Cleaning Thinner.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>Specific Gravity:</strong></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>• 0.98 g/cm³</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>Solid Content</strong></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>(without thinner added):</td>
<td></td>
</tr>
<tr>
<td>• 28.6 Weight %</td>
<td></td>
</tr>
<tr>
<td>• 16.4 Volume %</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>VOC (2004/42/EC):</strong></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>2004/42/IIB(c)(780)780</td>
<td></td>
</tr>
<tr>
<td>The EU limit value for this product [productcategory IIB.c] in ready to use form is max 780 g/l VOC. The VOC content of this product in ready for use form is max. 780 g/l.</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>Theoretical Coverage:</strong></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>• 18 m²/l at 8 micron dry film thickness</td>
<td></td>
</tr>
</tbody>
</table>

**Important remarks:**

- Standofleet Wash Primer 1:1 U2530 must be applied in combination with Standofleet 2K Filler / VOC Filler in a 3-stage system.

- Do not overcoat with PE, EP, Standohyd and Standoblue products.

- Lifetime of mixed material is 1 day. For Aluminium and zinc coated panels use freshly mixed material.

- Must be overcoated to provide weather resistance.

- On sanded and cleaned aluminium, prime immediately with Standofleet CR Wash Primer U2530 to prevent oxidation of the aluminium and to avoid further problems due to absorption.

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1K-Schweißprimer rotbraun
U2120
1K Welding Primer Red Brown
U2120

- 1K acid primer

- Outstanding corrosion protection

- Welding certificate

- Unlimited potlife

- 2- and 3-stage system

Technical Description:

- Add 30 - 50% Thinner

- 1 Spray pass after 15 min/18-22°C flash off
overcoatable with Standofleet 2K Filler / 2K VOC Filler
STANDOFLEET 1K-Schweißprimer rotbraun U2120

Substrate:

- Bare steel, sanded
- Aluminium frames, sanded
- Electroplated or hot dip galvanized (sendzimir process) add-on parts, sanded

Pretreatment / Cleaning:

For substrate preparation see Standox Painting System S1

Use air fed respirator. Refer to relevant Health and Safety Data Sheets.

Application:

Primer / 2-stage build-up

- 30-50% Standofleet 2K Thinner
- 20-30 s/DIN 4 mm/20°C
- 53-91 s/ISO 4 mm/20°C
- Compliant 1.4 - 1.6 mm
- Spray pressure 2.5 - 3 bar
- 2 - 3 spray passes = 30 - 40 micron
- HVLP 1.3 - 1.5 mm
- Atomising pressure 0.7 bar
- 2 - 3 spray passes = 30 - 40 micron
- Membrane pump 1.1 mm
- Atomising pressure 2.5 - 3 bar
- Material pressure 0.8 - 1.8 bar
- 2 - 3 spray passes = 30 - 40 micron
- Airmix 0.28 - 0.33 mm
- Material pressure 50 - 120 bar
- 1 - 2 spray passes = 30 - 40 micron
- 30-60 min / 18-22°C final flash-off

Standofleet 2K Topcoats
STANDOFLEET 1K-Schweißprimer rotbraun U2120

**Substrate:**

- Bare steel, sanded
- Aluminium, sanded
- Galvanized steel, sanded

**Pretreatment / Cleaning:**

For substrate preparation see Standox Painting System S1

Use air fed respirator. Refer to relevant Health and Safety Data Sheets.

**Application:**

**Primer / 3-stage build-up**

- 50% Standofleet 2K Thinner
  - 18-20 s/DIN 4 mm/20°C
  - 45-53 s/ISO 4 mm/20°C

- Compliant 1.4 - 1.6 mm
  - Spray pressure 2.5 - 3 bar
  - 1 Spray pass = 15 micron

- HVLP 1.3 - 1.5 mm
  - Atomising pressure 0.7 bar
  - 1 Spray pass = 15 micron

- Membrane pump 1.1 mm
  - Atomising pressure 2.5 - 3 bar
  - Material pressure 0.8 - 1.8 bar
  - 1 Spray pass = 15 micron

- Airmix 0.23 - 0.28 mm
  - Material pressure 50 - 120 bar
  - 1 Spray pass = 15 micron

- 15-30 min / 18-22°C final flash-off

- Standofleet 2K Filler / 2K VOC Filler

Use air fed respirator. Refer to relevant Health and Safety Data Sheets.

For substrate preparation see Standox Painting System S1
Standofleet 1K Welding Primer Red Brown U2120 gives steel 3 months weather resistance with a dry film thickness of 50 micron.

On sandblasted substrates the roughness of the surface has to be filled.

Do not overcoat with PE, EP, Standohyd and Standoblue products.

Standofleet 1K Welding Primer Red Brown U2120 gives steel 3 months weather resistance with a dry film thickness of 50 micron.

On sandblasted substrates the roughness of the surface has to be filled.

Important remarks:

• Do not overcoat with PE, EP, Standohyd and Standoblue products.

• Standofleet 1K Welding Primer Red Brown U2120 gives steel 3 months weather resistance with a dry film thickness of 50 micron.

• On sandblasted substrates the roughness of the surface has to be filled.

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2K-Sealer Transparent
U2020

2K Sealer Transparent
U2020

• Transparent 2K adhesion promoter

• Especially suitable for an economical overall repaint

• Can be used as a transparent filler

Technical Description:

• Mix
  2:1 with Standofleet 2K MS Hardener
  4:1 with Standofleet 2K HS Hardener

• Potlife up to 2 - 3 h/18 - 22°C
STANDOFLEET 2K-Sealer Transparent U2020

**Substrate:**
Bare metal substrates and sanded polyester substrates must be pre-primed with acid primer.

- Through-hardened paintwork
- Primed metal substrates

**Pretreatment / Cleaning:**

For substrate preparation see Standox Painting System S1

Use air fed respirator. Refer to relevant Health and Safety Data Sheets.

**Application:**

<table>
<thead>
<tr>
<th>Material</th>
<th>Specifications</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 Spray pass = 15 micron</td>
<td></td>
</tr>
<tr>
<td>2:1 with Standofleet 2K MS Hardener</td>
<td>Potlife 2 - 3 h/18 - 22°C</td>
</tr>
<tr>
<td>20% Standofleet 2K Thinner</td>
<td>15 - 16 s/DIN 4mm/20°C</td>
</tr>
<tr>
<td></td>
<td>33 - 37 s/ISO 4mm/20°C</td>
</tr>
<tr>
<td>Compliant 1.4 - 1.5 mm</td>
<td>Spray pressure 2.5 - 3 bar</td>
</tr>
<tr>
<td></td>
<td>1 Spray pass = 15 micron</td>
</tr>
<tr>
<td>HVLP 1.4 - 1.6 mm</td>
<td>Atomising pressure 0.7 bar</td>
</tr>
<tr>
<td></td>
<td>1 Spray pass = 15 micron</td>
</tr>
<tr>
<td>Membrane pump 0.8 mm</td>
<td>Atomising pressure 2.5 - 3 bar</td>
</tr>
<tr>
<td></td>
<td>Material pressure 0.8 - 1.8 bar</td>
</tr>
<tr>
<td></td>
<td>1 Spray pass = 15 micron</td>
</tr>
<tr>
<td>Airmix 0.18 - 0.23 mm</td>
<td>Material pressure 50 - 120 bar</td>
</tr>
<tr>
<td></td>
<td>1 Spray pass = 15 micron</td>
</tr>
<tr>
<td>30 min/18-22°C Flash off</td>
<td></td>
</tr>
</tbody>
</table>

**4:1 with**

Standofleet 2K HS Hardener
40% Standofleet 2K Thinner
15-16 s/DIN 4 mm/20°C
33 - 37 s/ISO 4 mm/20°C

In Non-VOC countries the material can also be overcoated with Standofleet MS Topcoat or Standox Basecoat with Standofleet 2K MS Clear K9310.
STANDOFLEET 2K-Sealer Transparent U2020

Flash point:
• 25°C / 77°F

Specific Gravity:
• 1.40 g/cm³

Solid Content (without thinner added):
• 67.3 Weight %
• 47.9 Volume %

Theoretical Coverage:
• 31.8 m²/l at 15 micron dry film thickness

Cleaning of equipment:
Clean immediately after use with Standox Cleaning Thinner.

Important remarks:
• If not overcoated within 24 h sand slightly and apply topcoat.

• After preliminary tests: Can be used as an adhesion promoter on hard, unsanded substrates with the addition of Standox Smart Blend.

• Standofleet Multitoning Additive reduces potlife to 30 min/18-22°C.

• Filler is tintable up to 10% with Standofleet / Standomix mixing enamels or up to 20% with Standofleet Topcoat.

• Flash off time can be affected.

• For stripes, lettering and small areas Standofleet Multitoning Additive can be used instead of Standofleet 2K Thinner.

2K Paints react with moisture. Therefore all equipment must be kept moisture free. Ready to use paint materials containing isocyanates can cause irritation of the mucous membranes - and of the respiratory organs, in particular - and cause hypersensitive reactions. There is a risk of hypersensitization if the vapour or spray mist is inhaled. When using materials containing isocyanates, all precautions relating to the handling of solvents should be carefully followed. In particular, care should be taken not to inhale spray mist or vapour. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

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Standox
EP-Grundierfüller U7200
EP Primer Surfacer U7200

- Epoxy-based universal primer surfacer
- Good isolating properties
- Good infrared drying
- Primer for Standox Spray Filler U1100 on zinc
- Good weather-resistant properties

Technical Description:
- Mix 3:1 with Standox EP Hardener U7210
- Potlife 3 h / 18-22°C
- 2 - 3 spray coats
- Force drying possible
- Air dry overnight / 18-22°C
### Standox EP-Grundierfüller U7200

#### Substrate:
- Through-hardened sanded paintwork
- Bare metal, sanded
- Galvanised metal, sanded
- Aluminium, sanded
- Standox Polyester substrates, sanded
- UP.GF, sanded

Substrates must be carefully sanded and cleaned.

#### Application: Sanding filler

- 3:1 with Standox EP Hardener U7210
- Potlife 3 h / 18-22°C

- 25% Standox VOC Thinner or 20% Standox 2K Thinners
- 17-19 s / DIN 4mm / 20°C
- 41-49 s / ISO 4mm / 20°C

- Compliant 1.3 - 1.6 mm
- 2.0 - 2.5 bar inlet pressure
- 2 - 3 = 60 - 90 micron

- HVLP 1.3 - 1.6 mm
- 0.7 bar atomization pressure
- 2 - 3 = 60 - 90 micron

#### Pretreatment / Cleaning:

For substrate preparation information see Standox Painting System S1

Use air fed respirator. Refer to relevant Health and Safety Data Sheets.
Standox EP-Grundierfüller U7200

Flashpoint:
- 28°C / 82.4°F

Specific Gravity:
- 1.62 g/cm³

Solid Content (without thinner added):
- 74.1 Weight %
- 53.7 Volume %

VOC (2004/42/EC):
2004/42/IIB(c)(540)540
The EU limit value for this product (productcategory IIB.c) in ready to use form is max 540 g/l VOC. The VOC content of this product in ready for use form is max. 540 g/l.

Theoretical Coverage:
- 8.1 m²/l at 55 micron dry film thickness

Cleaning of equipment:
Clean after use with Standox Cleaning Thinner.

Important remarks:
- Do not use Standox EP Primer Surfacer U7200 on acid etch primers.
- Standox EP Primer Surfacer U7200 gives steel 3 months weather resistance at a dry film thickness of 50 micron.
- If Standox EP Primer Surfacer U7200 is used as primer for galvanised metal, it has to be dried 30 min/60-65°C panel temperature or air dry overnight/18-22°C and lightly denibbed before overcoating with Standox PE Spray Filler U1100.
- Standox EP Primer Surfacer U7200 can be mixed with max. 10% Standocryl VOC Topcoat. Drying and sanding properties will change.
- In countries without VOC legislation Standox Basecoat / Standocryl 2K Topcoat / Standocryl 2K Topcoat NEW can be used as well.
2K-HS-Plus-Klarlack K9360
2K HS Plus Clear K9360

- 2K HS clear for commercial vehicles
- High mechanical and chemical resistance
- Excellent vertical stability
- Good anti-graffiti properties

Technical Description:
- Shake well before use
- Mixing
  3:1 with Standofleet 2K HS Hardener (standard)
  5:3 with Standofleet 2K HS Hardener (anti-graffiti)
- 1 working pass or
  2 spray passes
- Air dry overnight / 18-22°C
- Force drying possible
Substrate:

- Standohyd Basecoat
- Standoblue Fleet Basecoat
- Standofleet 2K HS/2K HS High Build Topcoat

Pretreatment / Cleaning:

For substrate preparation see Standox Painting System S1

Use air fed respirator. Refer to relevant Health and Safety Data Sheets.

Or:
Application in two spray passes with 10 - 15 min flash-off between coats

Application:

Shake well before the addition of hardener

Standard process:
3:1 with Standofleet 2K HS Hardener

Anti-graffiti process:
5:3 with Standofleet 2K HS Hardener
By weight: mix 100 parts of clear with 65 parts of hardener
Potlife: 1.5 h / 18-22°C

10-15% Standofleet 2K Thinner
20-23 s/DIN 4 mm/20°C
53-65 s/ISO 4 mm/20°C

0.5 + 1 = 50 - 60 micron

Compliant 1.4 - 1.6 mm
Spray pressure 2 - 2.5 bar

0.5 + 1 = 50 - 60 micron

HVLP 1.3 - 1.5 mm
Atomising pressure 0.7 bar
0.5 + 1 = 50 - 60 micron

Pressure pot 1.1 mm
Atomising pressure 2 - 2.5 bar
Material pressure 0.8 - 1.3 bar
0.5 + 1 = 50 - 60 micron

10-15 min / 18-22°C final flash-off

30-40 min. / 60-65°C object temperature or air dry over night / 18-22°C
STANDOFLEET 2K-HS-Plus-Klarlack K9360

Flash point:
- 35°C / 95°F

Specific Gravity:
- 0.98 g/cm³

Solid Content (without thinner added):
- 58.6 Weight %
- 52.9 Volume %

VOC (2004/42/EC):
2004/42/IIB(d)(420)420
The EU limit value for this product (product category: IIB.d) in ready for use form is max 420 g/litre of VOC. The VOC content of this product in ready for use form is max. 420 g/l.

Theoretical Coverage:
- 10 m²/l at 50 micron dry film thickness

Cleaning of equipment:
Clean immediately after use with Standox Cleaning Thinner.

Important remarks:
- Can be elastified with 15% Standox Plasticiser.
- Avoid too high filmbuild, especially with dark colours, as slight mottling may occur.
- Shake can before opening and shake each and any time before mixing with hardener.
- After overndrying at 30-40 min / 60-65°C and airdry over night Standofleet 2K HS / 2K HS High Build Topcoat has to get slightly denibbed with pad before overcoating with Standofleet 2K HS Plus Clear K9360.
- After shortened overndrying at 20-25 min./ 60-65°C or airdry over night Standofleet 2K HS / 2K HS High Build Topcoat can be immediately overcoated with Standofleet 2K HS Plus Clear K9360.

2K Paints react with moisture. Therefore all equipment must be kept moisture free. Ready to use paint materials containing isocyanates can cause irritation of the mucous membranes - and of the respiratory organs, in particular - and cause hypersensitive reactions. There is a risk of hypersensitization if the vapour or spray mist is inhaled. When using materials containing isocyanates, all precautions relating to the handling of solvents should be carefully followed. In particular, care should be taken not to inhale spray mist or vapour. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

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STANDOFLIGHT

2K-HS-Decklack
2K HS Topcoat

- VOC-compliant 2K High Solid Topcoat with optimum gloss- and high colour retention
- High mechanical and chemical resistance
- Low material consumption
- High profitability
- High opacity

Technical Description:

- Mix
  3:1 with Standofleet 2K HS Hardener

- 1 working pass or
  2 spray passes

- Potlife up to 2 - 3 h/18 - 22°C

- Air dry overnight/18-22°C

- Force drying possible
**Substrate:**
Isolate sensitive substrates.
- Through-hardened sanded paintwork
- Standofleet 1K/2K Primers
- Standofleet 2K Filler

**Application:**

3:1 with Standofleet 2K HS Hardener
Potlife 2 - 3 h/18 - 22°C

**Matt colours 5:1 and 10% Thinner**

10 - 15% Standofleet 2K Thinner
20 - 23 s/DIN 4mm/20°C
53 - 65 s/ISO 4mm/20°C

Compliant 1.4 - 1.6 mm
Spray pressure 2.5 - 3 bar
0.5 + 1 = 40 - 60 micron

HVLP 1.3 - 1.6 mm
Atomising pressure 0.7 bar
0.5 + 1 = 40 - 60 micron

Membrane pump 1.1 mm
Atomising pressure 2.5 - 3 bar
Material pressure 0.8 - 1.3 bar
0.5 + 1 = 40 - 60 micron

Airless 0.23 - 0.33 mm
Material pressure 50 - 120 bar
0.5 + 1 = 50 - 60 micron

5 - 15 min/18 - 22°C final flash-off

25-30 min. / 60-65°C object temperature or air dry over night / 18-22°C

---

**Pretreatment / Cleaning:**

For substrate preparation information see Standox Painting System S1.

Use air fed respirator. Refer to relevant Health and Safety Data Sheets.

Application in two spray passes with 5 - 10 min flash-off between coats
## STANDOFLEET 2K-HS-Decklack

<table>
<thead>
<tr>
<th>Flash point:</th>
<th>• 25 - 26°C / 77.0 - 78.8°F</th>
</tr>
</thead>
</table>

<table>
<thead>
<tr>
<th>Specific Gravity:</th>
<th>• 1.01 - 1.41 g/cm³</th>
</tr>
</thead>
</table>

| Solid Content (without thinner added): | • 63.1 - 74.0 Weight %  
• 57.6 - 58.01 Volume % |
|----------------------------------------|------------------------|

The EU limit value for this product (product category: IIB.d) in ready for use form is max 420 g/litre of VOC. The VOC content of this product in ready for use form is max. 420 g/l. |
|------------------|--------------------------|

<table>
<thead>
<tr>
<th>Theoretical Coverage:</th>
<th>• 10.2 m²/l at 50 micron dry film thickness</th>
</tr>
</thead>
</table>

<table>
<thead>
<tr>
<th>Cleaning of equipment:</th>
<th>Clean immediately after use with Standox Cleaning Thinner.</th>
</tr>
</thead>
</table>

| Important remarks: | • Can be elastified with 15% Standox Plasticiser.  
• Colours must be homogenised immediately after mixing and before application.  
• Suitable for electrostatic application. Film thickness of max. 60 micron and flash off need to be observed.  
• For small repairs (through sanded areas) Standofleet 1K Primer U2010 can be used. |
|-------------------|----------------------------------------------------------|

2K Paints react with moisture. Therefore all equipment must be kept moisture free. Ready to use paint materials containing isocyanates can cause irritation of the mucous membranes - and of the respiratory organs, in particular - and cause hypersensitive reactions. There is a risk of hypersensitization if the vapour or spray mist is inhaled. When using materials containing isocyanates, all precautions relating to the handling of solvents should be carefully followed. In particular, care should be taken not to inhale spray mist or vapour. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

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2K-HS-Dickschicht-Decklack
2K HS High Build Topcoat

- VOC - compliant 2K High Build Topcoat
- Good gloss- and colour retention
- High mechanical and chemical resistance
- High profitability
- Good filling properties and high film thickness

Technical Description:

- Mix 3:1 with Standofleet 2K HS Hardener
- 1 working spray pass
- Potlife 2 - 3 h/18 - 22°C
- Air dry overnight/18-22°C
- Force drying possible
- Airless application
**STANDOFLEET 2K-HS-Dickschicht-Decklack**

**Substrate:**
- Isolate sensitive substrates.
- Through-hardened sanded paintwork
- Standofleet 1K/2K Primers
- Standofleet 2K Filler

**Application:**
- 3:1 with Standofleet 2K HS Hardener
  - Potlife 2 - 3 h / 18 - 22°C
- **Matt colours 5:1 and 10% Thinner**
  - 10 - 15% Standofleet 2K Thinner
  - 20 - 25 s / DIN 4mm / 20°C
  - 53 - 72 s / ISO 4mm / 20°C

**Pretreatment / Cleaning:**
- For substrate preparation see Standox Painting System S1
- Use air fed respirator. Refer to relevant Health and Safety Data Sheets.

- **Compliant 1.4 - 1.6 mm**
  - Spray pressure 2.5 - 3 bar
  - 0.5 + 1 = 50 - 60 micron

- **HVLP 1.4 - 1.6 mm**
  - Atomising pressure 0.7 bar
  - 0.5 + 1 = 50 - 60 micron

- **Membrane pump 1.1 mm**
  - Atomising pressure 2.5 - 3 bar
  - Material pressure 0.8 - 1.3 bar
  - 0.5 + 1 = 50 - 60 micron

- **Airless 0.23 - 0.28 mm**
  - Material pressure 50 - 120 bar
  - 0.5 + 1 = 50 - 60 micron

- 10 - 15 min / 18 - 22°C final flash-off

- 25-30 min / 60-65°C object temperature or air dry over night / 18-22°C
STANDOFLEET 2K-HS-Dickschicht-Decklack

**Flash point:**
- 25 - 26°C / 77.0 - 78.8°F

**Specific Gravity:**
- 1.01 - 1.41 g/cm³

**Solid Content (without thinner added):**
- 63.2 - 74.0 Weight %
  - 57.8 - 58.1 Volume %

**VOC (2004/42/EC):**
2004/42/IIB(d)(420)420
The EU limit value for this product (product category: IIB.d) in ready for use form is max 420 g/litre of VOC. The VOC content of this product in ready for use form is max. 420 g/l.

**Theoretical Coverage:**
- 10.2 m²/l at 50 micron dry film thickness

**Cleaning of equipment:**
Clean immediately after use with Standox Cleaning Thinner.

**Important remarks:**
- With Airless/Airmix/Elektrostatic – application we recommend to use Standofleet 2K HS High Build Topcoat with Standofleet 2K Special Thinner.
- Colours must be homogenised immediately after mixing and before application.
- With low opacity colours it may be necessary to apply one more spray coat after 10 min flash off.
- Suitable for electrostatic application. Film thickness of max. 60 micron and flash off need to be observed.

2K Paints react with moisture. Therefore all equipment must be kept moisture free. Ready to use paint materials containing isocyanates can cause irritation of the mucous membranes - and of the respiratory organs, in particular - and cause hypersensitive reactions. There is a risk of hypersensitization if the vapour or spray mist is inhaled. When using materials containing isocyanates, all precautions relating to the handling of solvents should be carefully followed. In particular, care should be taken not to inhale spray mist or vapour. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

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Silikon-Entferner
Silicone Remover

- Pre-treatment agent

Technical Description:

- Substrate pre-treatment of sanded paintwork and filled substrates
**STANDOFLEET Silikon-Entferner**

**Flash point:**
- 24°C / 75.2°F

**Specific Gravity:**
- 0.80 g/cm³

**VOC (2004/42/EC):**
2004/42/IIB(a)(850)820
The EU limit value for this product (productcategory IIB.a) in ready to use form is max 850 g/l VOC. The VOC content of this product in ready for use form is max. 820 g/l.
Entfettungsmittel
Degreaser / Grease remover

Technical Description:

- Agent to degrease metal substrates
Flash point:
• 24°C / 75.2°F

Specific Gravity:
• 0.84 g/cm³

VOC (2004/42/EC):
2004/42/IIB(a)(850)850
The EU limit value for this product (productcategory IIB.a) in ready to use form is max 850 g/l VOC. The VOC content of this product in ready for use form is max. 850 g/l.
2K-MS-Decklack
2K MS Topcoat

- 2K MS Topcoat with optimum gloss- and high colour retention
- High mechanical and chemical resistance
- High opacity
- Fast drying

Technical Description:
- Mix 2:1 with Standofleet 2K MS Hardener
- Air dry overnight/18-22°C
- Force drying possible
**STANDOFLEET 2K-MS-Decklack**

**Substrate:**
Isolate sensitive substrates.

- Through-hardened sanded paintwork
- Standofleet 1K/2K Primers
- Standofleet 2K Filler

**Application:**

2:1 with Standofleet 2K MS Hardener
Potlife 3 - 4 h/18 - 22°C

0 - 5% Standofleet 2K Thinner
20 - 25 s/DIN 4mm/20°C
53 - 72 s/ISO 4mm/20°C

Compliant 1.4 - 1.6 mm
Spray pressure 2.5 - 3 bar
2 spray passes = 40 - 60 micron

HVLP 1.4 - 1.6 mm
Atomising pressure 0.7 bar
2 spray passes = 40 - 60 micron

Membrane pump 1.1 mm
Atomising pressure 2.5 - 3 bar
Material pressure 0.8 - 1.3 bar
2 spray passes = 40 - 60 micron

Airless 0.23 - 0.33 mm
Material pressure 50 - 120 bar
2 spray passes = 40 - 60 micron

5 - 10 min/18-22°C flash off between coats

25-30 min. / 60-65°C object temperature or air dry over night / 18-22°C

**Pretreatment / Cleaning:**

For substrate preparation information see Standox Painting System S1.

Use air fed respirator. Refer to relevant Health and Safety Data Sheets.
Flash point:
- 24 - 25°C / 75.2 - 77.0°F

Specific Gravity:
- 1.00 - 1.28 g/cm³

Solid Content (without thinner added):
- 53.6 - 65.8 Weight %
- 46.9 - 49.7 Volume %

Theoretical Coverage:
- 8.6 m²/l at 50 micron dry film thickness

Cleaning of equipment:
Clean immediately after use with Standox Cleaning Thinner.

Important remarks:
- With Airless/Airmix/Elektrostatic - application we recommend to use Standofleet 2K MS Topcoat with Standofleet 2K Special Thinner.
- Colours must be homogenised immediately after mixing and before application.
- With low opacity colours it may be necessary to apply one more spray coat after 10 min flash off.
- Suitable for electrostatic application. Film thickness of max. 60 micron and flash off need to be observed.

2K Paints react with moisture. Therefore all equipment must be kept moisture free. Ready to use paint materials containing isocyanates can cause irritation of the mucous membranes - and of the respiratory organs, in particular - and cause hypersensitive reactions. There is a risk of hypersensitization if the vapour or spray mist is inhaled. When using materials containing isocyanates, all precautions relating to the handling of solvents should be carefully followed. In particular, care should be taken not to inhale spray mist or vapour. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

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2K-MS-Klarlack K9310
2K MS Clear K9310

- Special 2K Clear for commercial vehicles
- Outstanding mechanical and chemical resistance
- Durable high gloss for 2-stage finishes

Technical Description:

- Mix
  2:1 with Standofleet 2K MS Hardener
- Air dry overnight/18-22°C
- Force drying possible
STANDOFLEET 2K-MS-Klarlack K9310

Substrate:

- Standofleet 2K Topcoats
- Standox Basecoat
- Standohyd Basecoat

Application:

2:1 with Standofleet 2K MS Hardener
Potlife 6 h/18 - 22°C

5 - 10% Standofleet 2K Thinner
17-19 s/DIN 4 mm/20°C
41-49 s/ISO 4 mm/20°C

Compliant 1.3 - 1.4 mm
Spray pressure 2.5 - 3 bar
2 spray passes = 50 - 60 micron

HVLP 1.3 - 1.4 mm
Atomising pressure 0.7 bar
2 spray passes = 50 - 60 micron

Membrane pump 1.1 mm
Atomising pressure 2.5 - 3 bar
Material pressure 0.8 - 1.8 bar
2 spray passes = 50 - 60 micron

5 - 15 min/18 - 22°C
Intermediate and final flash-off

40 min. / 60-65°C object temperature or
air dry over night / 18-22°C

Pretreatment / Cleaning:

For substrate preparation see
Standox Painting System S1

Use air fed respirator. Refer to
relevant Health and Safety
Data Sheets.
2K Paints react with moisture. Therefore all equipment must be kept moisture free. Ready to use paint materials containing isocyanates can cause irritation of the mucous membranes and of the respiratory organs, in particular, and cause hypersensitive reactions. There is a risk of hypersensitization if the vapour or spray mist is inhaled. When using materials containing isocyanates, all precautions relating to the handling of solvents should be carefully followed. In particular, care should be taken not to inhale spray mist or vapour. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

### STANDOFLEET 2K-MS-Klarlack K9310

<table>
<thead>
<tr>
<th>Flash point:</th>
<th>Cleaning of equipment:</th>
</tr>
</thead>
<tbody>
<tr>
<td>• 29°C / 84.2°F</td>
<td>Clean immediately after use with Standox Cleaning Thinner.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Specific Gravity:</th>
</tr>
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<tbody>
<tr>
<td>• 0.98 g/cm³</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Solid Content (without thinner added):</th>
</tr>
</thead>
<tbody>
<tr>
<td>• 45.7 Weight %</td>
</tr>
<tr>
<td>• 39.7 Volume %</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Theoretical Coverage:</th>
</tr>
</thead>
<tbody>
<tr>
<td>• 7.7 m²/l at 50 micron dry film thickness</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Important remarks:</th>
</tr>
</thead>
<tbody>
<tr>
<td>• Can be elastified with 15% Standox Plasticiser.</td>
</tr>
<tr>
<td>• Matting with Standox Special Matt</td>
</tr>
</tbody>
</table>

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