
Working Process:**Blending-in with 3-Stage Standohyd Basecoat (Spot Repair)**

Substrate:

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

- Sand the repair area with P1000-P1200 wet and sand the whole panel with an ultra fine pad.



For substrate preparation information see Standox Painting System S1.

Painting:

- Mix Standohyd Basecoat ground colour with 5 % Standohyd Special Additive and then adjust to spray viscosity 22-26 sec. DIN 4mm by adding Standohyd Demineralized Water as usual. Potlife of mixed material maximum 30 min. at 20°C.
- Apply Standohyd Basecoat ground colour until opacity to repair area (patch of filler). 5 - 10 minutes final flash off followed by 15-20 minutes at 60-65°C object temperature. Allow surfaces to cool down to normal temperature.
- Apply Standohyd Basecoat effect colour to repair area and even out the pattern. Spray first coat to the widest area, if needed apply 2nd and 3rd coat with intermediate flash off.
- Work back from the widest area with staggered overlapping effect coats to avoid a strong halo / visible edge and provide a smooth transition. Start from widest area and work towards centre.
- After flashing off until matt remove spray dust carefully from entire area with a tack rag.
- Precoat repair area with 1 spray pass of any Standocryl VOC Clear, after flash off time overcoat the entire area with Standocryl VOC Clears.

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Option:

- As an option of using Standohyd Special Additive, Standocryl VOC clears can be applied, dried and sanded to isolate the ground colour. Follow TDS

Important hint:

- The usage of white or tinted Standox VOC Fillers is recommended.