

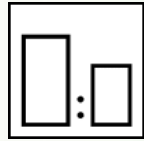
# High Quality Wet on Wet Process



**Standex  
2K Nonstop  
Primer Filler (wet-  
on-wet filler, HS  
Hardener)**



TDS 535



3:1 with Standox  
2K Hardener HS  
potlife  
30-60 min/20°C



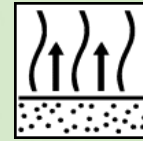
30% Standox  
2K Thinners  
15-16 s/DIN 4 mm/20°C  
33-37 s/ISO 4 mm/20°C



Compliant  
1.3 - 1.4 mm  
1.5 - 3.0 bar  
inlet pressure  
1 - 2 = 20-40µm



HVLP  
1.3 - 1.4 mm  
0.7 bar  
atomization pressure  
1 - 2 = 20-40 µm



20-30 min/20°C  
final flash-off

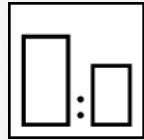


Standocryl  
2K/2K HS Topcoat  
or Stx Basecoats/  
Sthyd Basecoat with  
Stcryl 2K Clears

**Standex  
Basecoat**



TDS 610



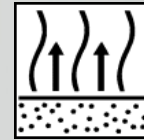
50-60% Standox  
Thinner MSB  
20-22 s/DIN 4 mm/20°C  
53-61 s/ISO 4 mm/20°C



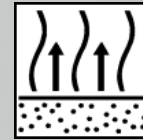
Compliant  
1.3 - 1.4 mm  
2.0 - 2.5 bar  
inlet pressure  
2 = 15-25 µm



HVLP  
1.3 - 1.4 mm  
0.7 bar  
atomization pressure  
2 = 15-25 µm



5 min/20°C  
intermediate flash-off



10-15 min/20°C  
final flash-off

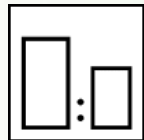


Standocryl  
2K Clears

**Standocryl  
Express  
Premium Clear  
HS Hardener**



TDS 585



2:1 with all  
Standex 2K Hardeners  
HS  
potlife  
60-90 min/20°C



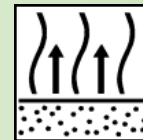
10% Standox  
2K Thinners  
17-19 s/DIN 4 mm/20°C  
41-49 s/ISO 4 mm/20°C



Compliant  
1.3 - 1.4mm  
2.0 - 2.5 bar  
inlet pressure  
2 = 50-60 µm



HVLP  
1.3 - 1.4mm  
0.7 bar  
atomization pressure  
2 = 50-60 µm



5-10 min/20°C  
intermediate and  
final flash-off



Air dry overnight  
/20°C  
or  
20-30 min/60-65°C  
panel temperature



Short wave 8-12 min  
(see Standox  
Painting System S10)