

# Standex Painting System Productive Process 1



<p><b>Standex PE Soft Stopper</b></p> <p>TDS 212</p>	<p>STANDOX SOFT SPACHTEL PE SOFT STOPPER</p> <p>STANDOX - WUPPERTAL - GERMANY</p>	<p>2-3% Standox Hardener Paste potlife 4-5 min/18-22°C</p>	<p>Apply stopper</p>	<p>Air dry 15-20 min/18-22°C</p>	<p>Short wave 2-3 min (see Standox Painting System S10)</p>	<p>Coarse sand P80 - P120 Fine sand P180 - P280</p>	<p>Standex Primers and Primer Surfacer</p>	
<p><b>Standex 1K Primer Filler (primer)</b></p> <p>TDS 413</p>	<p>STANDOX 1K-FÜLLPRIMER 1K PRIMER FILLER</p> <p>STANDOX - WUPPERTAL - GERMANY</p>	<p>50% Standox 2K Thinners 18-20 s/DIN 4 mm/20°C 45-53 s/ISO 4 mm/20°C</p>	<p>Compliant 1.4 - 1.5 mm 2.0 - 2.5 bar inlet pressure 1 = 15 µm</p>	<p>HVLP 1.5 - 1.6 mm 2.0 - 2.5 bar atomization pressure 1 = 15 µm</p>	<p>10-15 min/18-22°C</p>	<p>Standex 2K Filler</p>		
<p><b>Standex VOC System Filler HighPro/VOC Hardener Compliant</b></p> <p>TDS 610</p>	<p>STANDOX VOC SYSTEM FÜLLER FILLER</p> <p>STANDOX - WUPPERTAL - GERMANY</p>	<p>7:1 with all VOC Hardeners potlife 90-120 min/20°C</p>	<p>10% Standox 2K Thinner 22-24 s/DIN 4 mm/20°C 61-68 s/ISO 4 mm/20°C</p>	<p>Compliant 1.6 - 1.8 mm 1.5 - 3.0 bar inlet pressure 2 - 3 = max 250 µm</p>	<p>Air dry overnight 20°C or 30-40 min/60-65°C panel temperature</p>	<p>Short wave 10-15 min (see Standox Painting System S10)</p>	<p>P400 - P500 orbital sanding machine</p>	<p>P800</p>
<p><b>Standex Basecoat</b></p> <p>TDS 610</p>	<p>STANDOX BASISLACK BASECOAT</p> <p>STANDOX - WUPPERTAL - GERMANY</p>	<p>50-60% Standox Thinner MSB 20-22 s/DIN 4 mm/20°C 53-61 s/ISO 4 mm/20°C</p>	<p>Compliant 1.3 - 1.4 mm 2.0 - 2.5 bar inlet pressure 2 = 15-25 µm</p>	<p>HVLP 1.3 - 1.4 mm 0.7 bar atomization pressure 2 = 15-25 µm</p>	<p>5 min/20°C intermediate flash-off</p>	<p>10-15 min/20°C final flash-off</p>	<p>Standocryl 2K Clears</p>	
<p><b>Standocryl VOC HighPro Clear</b></p> <p>TDS 583</p>	<p>STANDOX STANDOCRYL VOC-HIGHPRO-KLARLACK CLEAR</p> <p>STANDOX - WUPPERTAL - GERMANY</p>	<p>3:1 with Standox HighPro Hardeners 20/30/40 potlife 80-100 min/20°C</p>	<p>Ready to spray 17-19 s/DIN 4 mm/20°C 41-49 s/ISO 4 mm/20°C</p>	<p>Compliant 1.3 - 1.4 mm 2.0 - 2.5 bar inlet pressure 0.5 + 1 = 45-55 µm</p>	<p>HVLP 1.3 - 1.4mm 0.7 bar atomization pressure 0.5 + 1 = 45-55 µm</p>	<p>5-10 min/20°C final flash-off</p>	<p>Air dry overnight /20°C or 15-35 min/60-65°C panel temperature</p>	<p>Short wave 8-12 min (see Standox Painting System S10)</p>