

Standox Painting System Quality Repair Process 1



<p>Standox PE Soft Stopper</p> <p>TDS 212</p>	<p>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>Standox Primers and Primer Surfacer</p>	
<p>Standox Etching Adhesion Primer</p> <p>TDS 312</p>	<p>REAKTIV-HAFTPRIMER ETCHING ADHESION PRIMER</p> <p>STANDOX - WUPPERTAL - GERMANY</p>	<p>1:1 with Standox Etching Adhesion Activator potlife 8-10 h/20°C</p>	<p>Compliant 1.3 - 1.4 mm 2.0 - 2.5 bar inlet pressure 2 = 8-10 µm</p>	<p>HVLP 1.3 - 1.6 mm 0.7 bar atomization pressure 2 = 8-10 µm</p>	<p>30 min/20°C</p>	<p>Standox 2K Filler</p>		
<p>Standox VOC System Filler HighPro/VOC Hardener Compliant</p>	<p>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>Standox Basecoat</p> <p>TDS 610</p>	<p>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>Standocryl VOC HighPro Clear</p> <p>TDS 583</p>	<p>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 - 1.4 mm 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>