

Standex Painting System Wet on Wet Process



<p>Standex 2K Nonstop Primer Filler (wet-on-wet filler, MS Hardener)</p> <p>TDS 535</p>	<p>2K-NONSTOP-FÜLLPRIMER 2K NONSTOP PRIMER FILLER</p> <p>STANDOX - WUPPERTAL - GERMANY</p>	<p>2:1 with Standox 2K Hardener MSX potlife 30-60 min/18-22°C</p>	<p>20% Standox 2K Thinners 15-16 s/DIN 4 mm/20°C 33-37 s/ISO 4 mm/20°C</p>	<p>Compliant 1.4 - 1.8 mm 1.5 - 3.0 bar inlet pressure 1 - 2 = 20-40 µm</p>	<p>HVLP 1.4 - 1.8 mm 0.7 bar atomization pressure 1 - 2 = 20-40 µm</p>	<p>20-30 min/18-22°C final flash-off</p>	<p>Standocryl 2K MS Topcoat or Stx Basecoats/ Sthyd Basecoat with Stcryl 2K Clears</p>	
<p>Standex 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/18-22°C intermediate flash-off</p>	<p>10-15 min/18-22°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/18-22°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/18-22°C final flash-off</p>	<p>Air dry overnight /18-22°C or 15-35 min/60-65°C panel temperature</p>	<p>Short wave 8-12 min (see Standox Painting System S10)</p>