

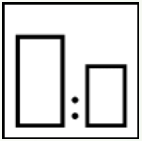
Wet on Wet VOC Topcoat System



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



TDS 535



5:1 with Standox
VHS Hardener
potlife
30-60 min/20°C



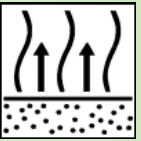
30% Standox
VOC/2K Thinners
15-16 s/DIN 4 mm/20°C
33-37 s/ISO 4 mm/20°C



Compliant
1.6 - 1.8 mm
1.5 - 3.0 bar
inlet pressure
1 - 2 = 20-40µm



HVLP
1.6 - 1.8 mm
0.7 bar
atomization pressure
1 - 2 = 20-40 µm



20-30 min/20°C
final flash-off

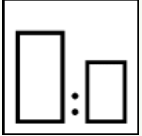


Standocryl
2K/2K VOC Topcoat
or Stx Basecoats/
Sthyd Basecoat with
Stcryl 2K Clears

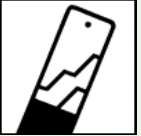
**Standocryl
VOC Topcoat**



TDS 554



3:1 with Standox
VOC/2K Hardener
potlife
1-1,5 h/20°C



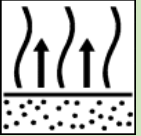
15% Standox
VOC/2K Thinner
18-20 s/DIN 4 mm/20°C
45-53 s/ISO 4 mm/20°C



Compliant
1.3 - 1.4mm
2.0 - 2.5 bar
inlet pressure
0.5 + 1 = 50-60 µm



HVLP
1.3 - 1.4mm
0.7 bar
atomization pressure
0.5 + 1 = 50-60 µm



5-10 min/20°C
final flash-off



Air dry overnight
/20°C or
15-30 min/60-65°C
panel temperature



Short wave
5 min/50% perform.
afterwards
10 min/100% perform.