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**Working Process:****2-Stage Plastic Painting System  
Basecoat Textured Finish (Hard Plastics)**

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**Substrate:**

Exterior hard plastic parts,  
e.g. PP/EPDM, ABS, PC, PA, PUR, R-TPU, PPO, PBT, UP-GF, PVC

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**Pretreatment /  
Cleaning:**

- Bake for 60 min / 60 - 65 °C
- Clean several times with plenty of fresh Standoflex Plastic Cleaner antistatic and an ultra fine pad. Reclean with Standoflex Plastic Cleaner antistatic.
- Remove all traces of release agent!
- Dry and prime

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**Application:**

- Standoflex 2K Plastic Primer Surfacer U3200
- For filling small scratches and imperfections, after pre-priming with Standoflex 2K Plastic Primer Surfacer U3200 and drying according to instructions, apply Stadox Fine Stopper U1070. After denibbing the body filler spot should be isolated with Standoflex 2K Plastic Primer Surfacer U3200.
- Choose colour of Standocryl VOC Topcoat for intermediate coats similar to Basecoat. Mix with Standocryl 2K Structure Coarse or Fine according to TDS 597.
- Overcoatable after  
30 min / 18-22 °C, max. 8 h / 18-22 °C
- Mix Stadox Basecoat with 15% Stadox HS Hardener and 40% Stadox MSB Thinner (2 spray passes) or
- Mix Stadox Basecoat with 10% Stadox VOC Hardener and 45% Stadox MSB Thinner (2 spray passes)
- Drying:  
20 min / 60-65 °C or 2 h / 18-22 °C

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**Important remarks:**

- Do not steam clean the finish within 6 weeks of application and drying. Then keep a minimum distance of 30 cm between the jet nozzle and the surface.
- Do not overcoat with clear as the surface texture will be lost.