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

Substrate:

- PUR hard foam

**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.
- Bake for 20 min / 60 - 65 °C
- Remove all traces of release agent!
- If necessary apply 3M EP 5900
- Apply Standoflex Pore Filler U3080

Application:

- Finally, clean with Standoflex Plastic Cleaner antistatic applied with a cloth.
- 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 Standox Basecoat with 15% Standox HS Hardener and 40% Standox MSB Thinner (2 spray passes) or
- Mix Standox Basecoat with 10% Standox VOC Hardener and 45% Standox MSB Thinner (2 spray passes)
- Drying:
20 min / 60-65 °C or 2 h / 18-22 °C

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.