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## Working Process:



## Blending-in with 3-Stage Standohyd Basecoat into adjacent panels

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### Substrate:

- Prepare new panels as usual, see Standox Painting System S3

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### Pretreatment / Cleaning:

- Sand adjacent areas with P1000 - P1200 and an ultra fine pad



For substrate preparation information see Standox Painting System S1.

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### Painting:

- Mix Standohyd Basecoat ground colour with 5 % Standohyd Special Additive and then adjust to spray viscosity 22-26 sec. DIN 4mm by adding Standox Demineralized Water as usual. Potlife of mixed material maximum 30 min. at 20°C.
- Mask adjacent panels. Apply Standohyd Basecoat ground colour to new panels until complete opacity has been reached. Remove masking and extend with ground colour into adjacent panel. 5 - 10 minutes final flash followed by 15-20 minutes at 60-65°C object temperature. Allow surfaces to cool down to normal temperature.
- Apply Standohyd Basecoat effect colour to the complete new part and blend-in to the adjacent parts. Spray first coat to the widest area, if needed apply 2<sup>nd</sup> and 3<sup>rd</sup> coat with intermediate flash off.
- Work back from the widest area with staggered overlapping effect coats to avoid a strong halo / visible edge and provide a smooth transition. Start from widest area and work towards centre.
- After flashing off until matt remove spray dust very carefully from entire area with a tack rag.

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**Painting (continued):**

- Precoat adjacent area with 1 spray pass of any Standocryl VOC Clear, after flash off time overcoat the entire area with Standocryl VOC Clears.

**Option:**

- As an option of using Standohyd Special Additive, Standocryl VOC clears can be applied, dried and sanded to isolate the ground colour. Follow TDS.

**Important hint:**

- The usage of white or tinted Standox Fillers is recommended.