
Working Process:**Blending-in with Standoblue Basecoat
Mercedes Alubeam 047**

Substrate:

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

**Pretreatment /
Cleaning:**

- All panels with repaired filler areas must be clearcoated with a Standocryl VOC Clear in accordance to relevant TDS.
- Repaired and clearcoated panels are sanded with orbital sanding machine and P1000-P1500, edges and corners with P3000 handsanding. Blending area should be prepared with P3000 machine sanding.



For substrate preparation see Standox Painting System S1

Painting:

- Apply Standoblue Color Blend to surrounding fade out area or adjacent panels with closed coats.
- Blending-in transition areas:
Mix Standoblue Basecoat Mercedes Alubeam 047 with 50% Standoblue Viscosity Adjuster Slow "New", apply over repaired area and up to the edge of previously applied and still wet Standoblue Color Blend film.
- Apply effect coat with increased distance over repaired area and blend into the Standoblue Color Blend.
- Repaired panels areas:
Mix Standoblue Basecoat Mercedes Alubeam 047 with 50% Standoblue Viscosity Adjuster Slow "New", apply in 1.5 coat process and fade into adjacent areas.

Working Process:



**Blending-in with Standoblue Basecoat
Mercedes Alubeam 047**

**Painting
(continued):**

- Spray at 1.5-2.0 bar pressure for effect coat.
- Ensure spraygun is used with full trigger.
- Do not allow Standoblue Color Blend to flash off before applying the Standoblue Mercedes Alubeam 047 colour.
- Avoid overwetting the Standoblue Mercedes Alubeam 047 colour over the wet Standoblue Color Blend.
- Apply Standocryl VOC Platinum Clear K9570.