
Use:

Metal or plastic substrates
Panel repair and total respray
Painting of cars with matt finish

Substrate:

- Bare metal, sanded
 - Galvanised metal, sanded
 - Aluminium, sanded
 - Through-hardened sanded paintwork
 - Plastic substrates
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**Pretreatment /
Cleaning:**

For substrate preparation information see
Standex Painting System S1.

Stopper:

- Standox Soft Stopper U1090
 - Standox Fine Stopper U1070
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Primer:

- Standox Etching Adhesion Primer U3100 or
Standex 1K Primer Filler U3010
 - Do not overcoat with Standox EP Primer Surfacer U7200, if
Standex Etching Adhesion Primer U3100 or Standox 1K Primer
Filler U3010 is used.
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Filler:

- Standox EP Primer Surfacer U7200 or
Standex Fillers
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Basecoat:

- Standohyd Basecoat
 - StandoX Basecoat
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Clearcoat:

- Standox Special Matt
 - Standocryl VOC HS Clear K9520
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Pre-Mixing:

- Depending on desired gloss level the following mixtures are possible by mixing Standox Special Matt and Standocryl VOC HS Clear K9520:
70:30 ratio for OEM surfaces *
75:25 ratio for OEM surfaces *
80:20 for the most Matt surface,
normally not on OEM surfaces **
*Dependant on individual vehicle as OEM finishes vary in gloss level

Shake or stir Standox Special Matt well in the can.
Ensure both components are thoroughly mixed.
Mixture must be re-stirred if left to stand for 30 minutes or longer.

Hardener and thinner should be added directly before application.

Mixing:

4:1 with Standox Hardener VOC 30-40
and 10 % Standox VOC Thinner slow
17-18s/DIN 4mm/20°C
41-45s/ISO 4mm/20°C
Potlife 30 minutes

Application:

* Compliant 1.3-1.4 mm at 2.0-2.5 bar inlet pressure
** SATA HVLP 1.5 mm at 2.0 bar inlet pressure
Apply in two coats with increased distance to the object.
5 - 10 min flash off
2nd coat should be applied after visual flash off when surface begins to turn patchy.

Apply the first and second layer in 90° cross application, if possible.

10-15 min Final flash off

Drying:

Drying time 45-50 min. / 60-65°C object temperature
Air dry is not permitted.

Important remarks:

- Always make test panel to determine desired gloss level.
- Strictly adhere to the specified material adjustments.
- Dust inclusions cannot be removed by polishing. Therefore maximum cleanliness should be respected in the application area.

- Blending not possible
- ** Option:
Depending on the color it is possible to cover Standohyd Basecoat with Standocryl VOC Clears baked and sanded.

This gives more uniform result, especially on very dark colors.

Care of the finish:

Do not wash the car with a high-pressure or steam-jet cleaner.

You can wash the car in an automatic car wash.

Systems with soft brushes are preferred.

Car washes with brushes do not necessarily have a negative impact on the paint surface or on the sensitivity to scratching.

Do not use any paint cleaning compounds, sanding or polishing pastes/compounds, or even gloss preservers (wax) for paintwork care. They may damage the surface.

If, by accident wax gets on the surface, remove it immediately with Standox Silicone Remover. Take care not to exert high pressure on the paint surface.

Do not allow any resinous, greasy or oily substances to get on the paint surface, as these may leave traces.

Tar spots can be removed with a commercial tar remover.

Do not attach any stickers, foils, magnetic labels or similar to the painted surface. They may damage the painted surface.