
Working Process:**3-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 Plastic Primer U3060
- Plasticised Standox Fillers
- Choose colour of Standocryl VOC Topcoat for intermediate coats similar to Basecoat. Mix with Standocryl 2K Structure Additive 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)

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.