

Standofleet HS Topcoat

Standofleet HS Topcoat is a VOC compliant, highly efficient topcoat system for the commercial vehicle sector that meets the highest demand for quality.



Standofleet HS Topcoat

Product preparation - application Standard



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Surfaces must be prepared and cleaned correctly before application

Primer, Primer-surfacer or Filler, sanded and cleaned

Old or original paintwork well sanded and cleaned.

Primer-Surfacer or Filler, unsanded in a wet-on-wet process

Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned



Standard		
Topcoat	Hardener	Thinner
3	1	10 -15%
Standofleet HS Topcoat	4110 (Fleet HS Fast)	5110 (Fleet Fast)
	4120 (Fleet HS)	5120 (Fleet Thinner)
	4130 (Fleet HS Slow)	5130 (Fleet Slow)
		5140 (Fleet Extra Slow)
		5150 (Fleet Special)

Matt colours 5:1 and 10% Thinner

*5100 can be used for multi-toning.

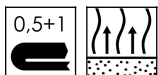
Mixing Ratio for 2K Mixing Machine		
Topcoat	Hardener	Thinner
2	1	0-5%
Standofleet HS Topcoat	4220 (Fleet Standard)	5110 (Fleet Fast)
	4230 (Fleet Slow)	5120 (Fleet Thinner)
	4240 (Fleet Extra Slow)	5130 (Fleet Slow)
		5140 (Fleet Extra Slow)
		5150 (Fleet Special)

Pot life at 20°C: 2 hr - 3 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.3 bar	material pressure
Airmix	0.23 - 0.28	2 - 2.5 bar	atomisation pressure
Airmix	0.23 - 0.28	90 - 120 bar	material pressure

see manufacturer's instructions



0.5 + 1

1 operation

1st: thin and closed

2nd: normal

final flash-off: 5 min - 15 min

2 coats

with intermediate flash-off: 10 min - 15 min

final flash-off: 5 min - 15 min



	4110 / 4120 / 4130
20 °C	12 hr - 16 hr
60 - 65 °C	30 min - 45 min

VOC compliant

2004/42/IIIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

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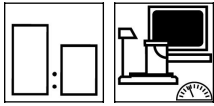
Products

Standofleet HS Topcoat

Standofleet 2K HS Hardener 4120
Standofleet 2K HS Hardener Fast 4110
Standofleet 2K HS Hardener Slow 4130
Standofleet Hardener Extra Slow 4240
Standofleet Hardener Fast 4210
Standofleet Hardener Slow 4230
Standofleet Hardener Standard 4220

Standofleet 2K Special Thinner 5150
Standofleet 2K Thinner 5120
Standofleet 2K Thinner Extra Slow 5140
Standofleet 2K Thinner Fast 5110
Standofleet 2K Thinner Slow 5130

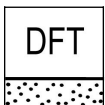
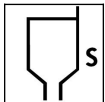
Product mix



Mixing ratios with special agents are available in the productmix table on Standowin IQ and in the specific TDS. The choice of hardener and Thinner should be made according to application temperature and size of repair.

4110	Accelerated fast hardener for small panels or for design work (stripes) 20-25°C.
4120	Standard hardener for all 2K CV products (20-25°C).
4130	Slow hardener for large surfaces and high temperatures (>30°C).
5110	Fast thinner only for small panels/areas (15-20°C).
5120	Standard CV thinner for all CV products. (20 -25°C).
5130	Slow thinner for large surfaces and high temp. (25-30°C), to avoid overspray problems.
5140	Extra slow thinner for large surfaces and extra high temp. (>35°C) , to avoid overspray problems.
5150	Special thinner only for airless or airmix application.

DIN 4: 20 - 25 s at 20°C



40 - 80 µm

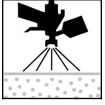
Theoretical coverage

590 - 600 m²/l at 1 micron dry film thickness

Due to different hardener characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.

Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.

Standofleet HS Topcoat



Standofleet HS Topcoat can be overcoated with itself within 24 hours, without intermediate sanding



Clean after use with a suitable solventbased guncleaner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Surplus ready for use material should not be returned to original can.
- Application for RAL9006: Apply 1 full coat, flash 15 minutes. Apply 1 full coat, immediately followed by a light coat with 0-5 minutes flash between coats.
- Fleet Thinner can be replaced 1:1 by Standofleet Multitoning Additive 5100 (add 5 to max 15%) for multitoning.
- 15% Stadox Plasticiser 5660 can be added to the product. Hardener ratio is unchanged, thinner amount is 15%.
- Colours must be homogenised immediately after mixing and before application.
- Suitable for electrostatic application. Film thickness of max. 60 micron and flash off need to be observed.
- Close can of hardener tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Scuff sanding is required:
 - when a topcoat layer, accelerated with Standofleet Multitoning Additive 5100, has been force dried and kept overnight.
 - when a topcoat layer, accelerated with Standofleet Multitoning Additive 5100, has been force dried more than once.
- Different gloss levels can be created by using Standofleet Mix 705 Binder HS matt. Mixing ratios see colour tools.

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our Stadox product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Stadox product range, unless explicitly indicated otherwise.

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