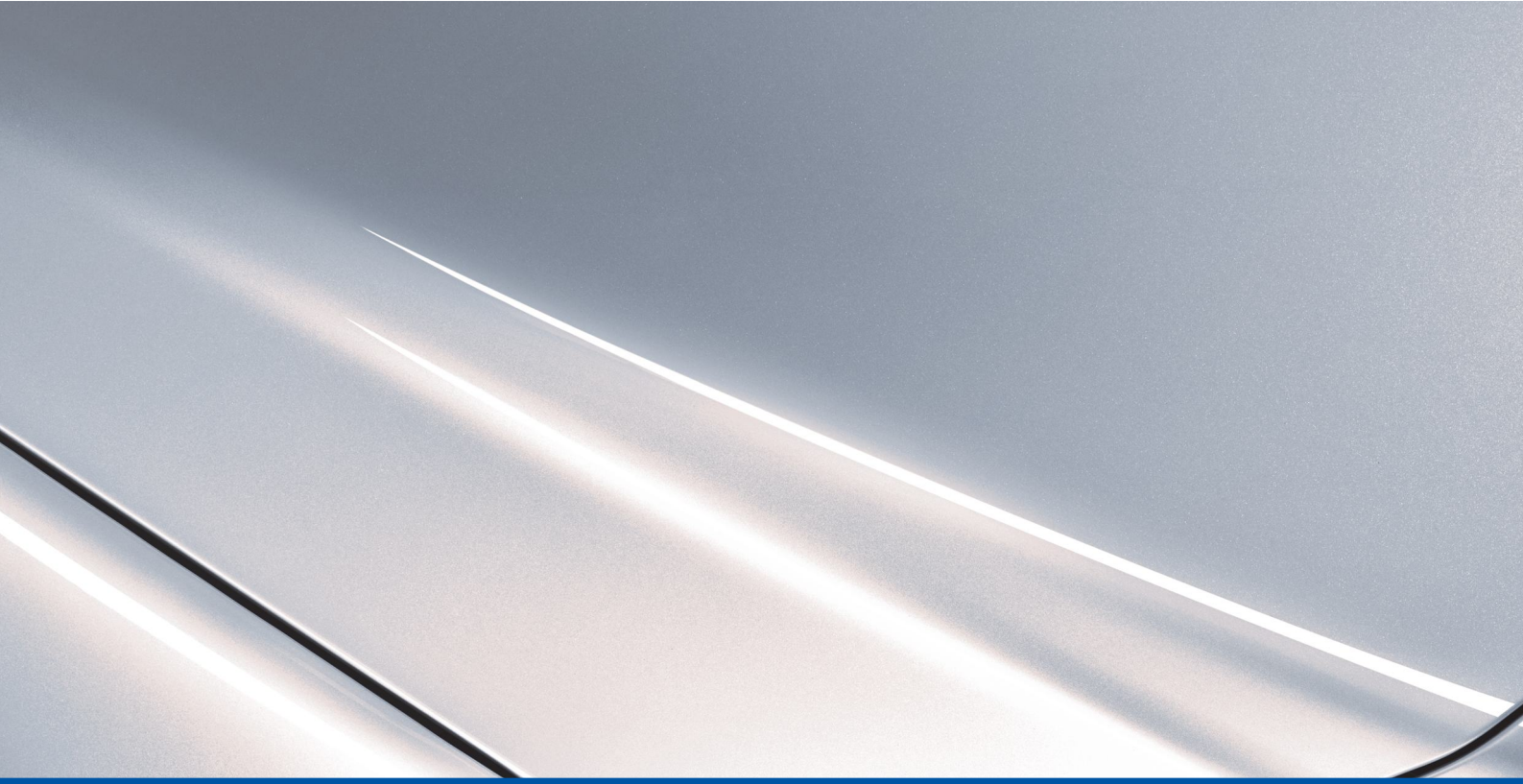


Standoblue Basecoat

Thanks to its continuous development, Standoblue Basecoat gives the highest levels of colour accuracy. That's because colour competence, technological know-how and meeting the highest standards are all in our DNA. Standox helps your bodyshop achieve excellent results, whether for everyday repairs or the most challenging specialist ones.

- Solid and effect colours using state of the art pigment technology.
- Exceptional colour accuracy.
- Excellent mottling control.
- Outstanding flow properties.
- Good blending characteristics for smooth transitions and invisible repairs.
- Flexible in application.
- Fast application in a single spray process.

High quality, premium basecoat system.

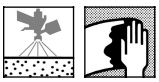
STANDOX

The Art of Refinishing.

Standoblue Basecoat

Product preparation - application for 2-stage colours

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



Old or original paintwork well sanded and cleaned.
Primer-surfacer or Filler, sanded and cleaned
Primer-Surfacer or Filler, unsanded in a wet-on-wet process
Surfaces must be prepared and cleaned correctly before application
Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned

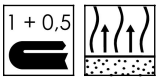
		Basecoat	Viscosity adjuster 8510/8520
Standard	Effect colours	100	20%
Standard	Solid colours	100	10%

Maximum 10% Standox Demineralized Water 8000 can be added in addition. Refer to Standoblue Climate Guide.

For optimum application properties, apply the basecoat immediately after addition of Standoblue Viscosity Adjuster 8510/8520. Use within same working day. Colours should be stored without the addition of the Standoblue Viscosity Adjuster 8510/8520.

	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.3	0.7 bar	atomisation pressure

see manufacturer's instructions



1 + 0.5
Apply a closed coat by wetting the surface sufficiently to achieve 70-80% opacity in the wet film.
This is followed by an effect coat with increased distance to the object with close overlaps into the still wet first layer.
This final ½ (>50%) effect coat achieves the correct effect orientation, completes the hiding and provides the correct colour position.

flash-off until matt

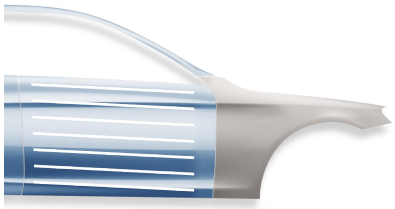
Clearcoat

VOC compliant

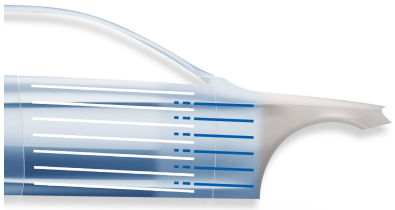
2004/42/IIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

Standoblue Basecoat

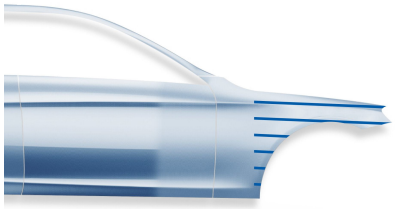
Standoblue blend-in guide
2-stage colours standard



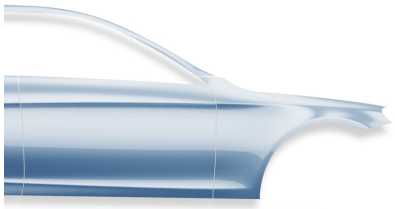
Apply Standoblue Color Blend 8570 / Standoblue Color Blend Slow 8580* to the surrounding fade out area or adjacent panels with thin closed coats. Do not allow Standoblue Color Blend 8570/8580 to flash.



Apply 1 coat of Standoblue Basecoat up to the edge of the Standoblue Color Blend 8570/8580 and extend into adjacent area/panel. Follow by spraying an effect coat to blend-in to the wet Standoblue Color Blend 8570/8580.



Apply Standoblue Basecoat to remaining repaired area (filler) with normal 1.5 coat process. Spray pressure 1.5–2.0 bar.



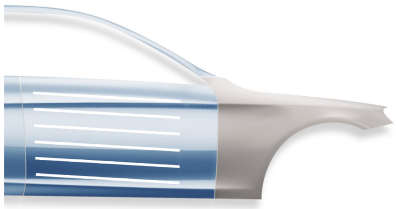
After flash off apply a Standocryl VOC clear.

*Standoblue Color Blend 8570 / Standoblue Color Blend Slow 8580 is not recommended for dark colours.

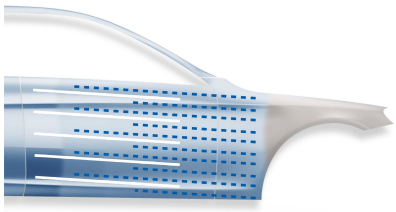
Standoblue Color Blend Slow 8580 is recommended to be used on medium to large size blend-in repairs at lower humidity <30% and/or at temperatures above 30°C.

Standoblue Basecoat

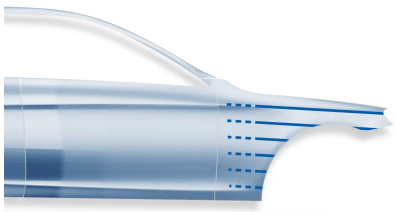
Standoblue blend-in guide
2-stage colours optional



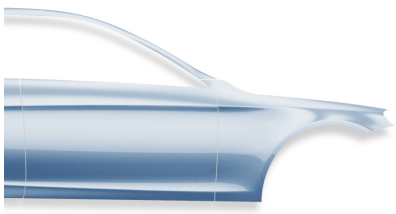
Apply Standoblue Color Blend 8570 / Standoblue Color Blend Slow 8580* to the surrounding fade out area or adjacent panels with thin closed coats. Do not allow Standoblue Color Blend 8570/8580 to flash.



Blend-in the Standoblue Basecoat Colour in one “light”/“effect” coat to the furthest point. Blend-in a second “light”/“effect” coat of the Standoblue Basecoat Colour. Work inside the previous and towards the repaired panel. Keep distance to object while spraying. During the blending, ensure that there is overlap onto the repaired panel.



Finally apply the Standoblue Basecoat Colour in normal 1,5 coat process (one visit) to the new part or repaired area. Avoid spraying over the finished blending area.



Standocryl VOC Clear is applied to finish the repair.

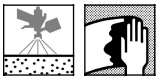
*Standoblue Color Blend 8570 / Standoblue Color Blend Slow 8580 is not recommended for dark colours.

Standoblue Color Blend Slow 8580 is recommended to be used on medium to large size blend-in repairs at lower humidity <30% and/or at temperatures above 30°C.

Standoblue Basecoat

Product preparation - application for 3-stage colours

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



Old or original paintwork well sanded and cleaned.
Primer-surfacer or Filler, sanded and cleaned
Surfaces must be prepared and cleaned correctly before application
Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned

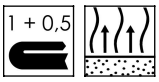
		Basecoat	Hardener 8550	Viscosity adjuster 8510/8520
Standard	Effect colours	100		20%
2K Hardened	Effect colours	100	5%	20%
Standard	Solid colours	100		10%
2K Hardened	Solid colours	100	5%	10%
8570/8580	Ground colours	100	5%	-

All amounts are cumulative.
Maximum 10% Standox Demineralized Water 8000 can be added in addition. Refer to Standoblue Climate Guide.

For optimum application properties, apply the basecoat immediately after addition of Standoblue Hardener 8550 and Standoblue Viscosity Adjuster 8510/8520.
Solid ground colours - 5%: 1 hr 30 min - 2 hr
Effect ground colours - 5%: 45 min - 1 hr
Blender - 5%: 1 hr - 1 hr 30 min

	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.3	0.7 bar	atomisation pressure

see manufacturer's instructions



1.5 - 2 Ground coats (2K Hardened)	flash-off until matt	
1 + 0.5 Effect/midcoat	flash-off until matt	

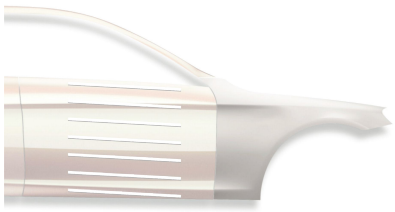
	Bake	Blowing	Ambient
20 °C	-	-	15 min - 25 min
35 - 40 °C	-	8 min - 12 min	-
60 - 65 °C	10 min - 15 min	-	-

Clearcoat

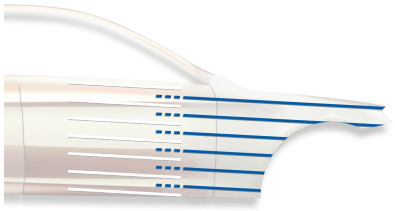
VOC compliant

2004/42/IIB(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.

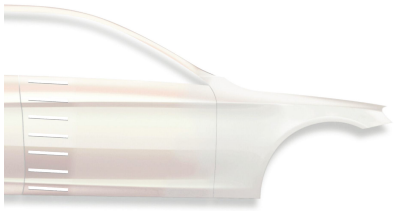
Standoblue blend-in guide
3-stage colours



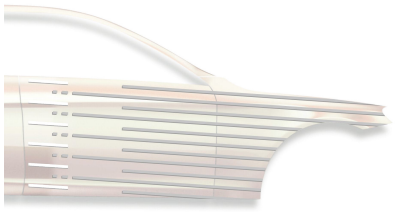
Apply a closed coat of hardened Standoblue Color Blend 8570 / Standoblue Color Blend Slow 8580 (blender +5% Standoblue Hardener 8550) to the adjacent blending areas, avoiding the extreme edges of the panel.



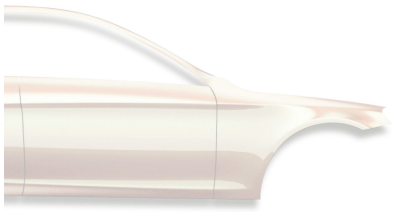
Apply the hardened Standoblue ground colour to the edge of the still wet Standoblue Color Blend 8570 / Standoblue Color Blend Slow 8580, and over the repaired surfaces. Refer to mixing details page for product adjustment and hardening ratios. Flash off and dry as described on previous page.



Apply a closed coat of unhardened Standoblue Color Blend 8570 / Standoblue Color Blend Slow 8580 to adjacent blending areas.



Apply the 1st coat of Standoblue pearl effect colour up the edge of the still wet Standoblue Color Blend 8570 / Standoblue Color Blend Slow 8580. Working from out-to-in from the widest area, further coats should be applied inside the previous layer as needed to complete the repair and match the colour. All application is in wet-on-wet process. Flash-off and dry complete surface as described on previous page.



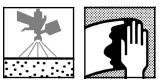
Apply a Standocryl VOC Clear to finish the repair.

Standoblue Color Blend Slow 8580 is recommended to be used on medium to large size blend-in repairs at lower humidity <30% and/or at temperatures above 30°C.

Standoblue Basecoat

Product preparation - application Super High effect Aluminium Colors (containing MIX130)

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



Suitable substrates, undercoats and its preparation can be found in previous pages in this TDS.

- Apply a single layer of 2K Clearcoat on all repaired panels / surfaces

- After drying and cooling, sand the whole panel very carefully with:
  - machine sanding: P1000 – P1200 grade
  - hand sanding for edges and corners: P3000 grade

- For blend-in process, please refer to blend-in page for 2 stage colours

		Basecoat	Viscosity Adjuster Slow 8520
Standard	Effect colours	100	50%

For optimum application properties, apply the basecoat immediately after addition of Standoblue Viscosity Adjuster Slow 8580. Use within same working day. Colours should be stored without the addition of the Standoblue Viscosity Adjuster Slow 8580.

	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.3	0.7 bar	atomisation pressure

see manufacturer's instructions

1 + 0.5
Apply a closed coat by wetting the surface sufficiently to achieve 70-80% opacity in the wet film.
This is followed by an effect coat with increased distance to the object with close overlaps into the still wet first layer.
This final ½ (>50%) effect coat achieves the correct effect orientation, completes the hiding and provides the correct colour position.

flash-off until matt

Clearcoat
Check if a specific clearcoat is required to meet car manufacturer approvals.

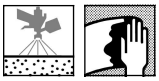
VOC compliant

2004/42/IIB(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.

Standoblue Basecoat

Product preparation - application with Standoblue Hardener

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



Old or original paintwork well sanded and cleaned.
Primer-surfacer or Filler, sanded and cleaned
Primer-Surfacer or Filler, unsanded in a wet-on-wet process
Surfaces must be prepared and cleaned correctly before application
Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned

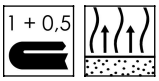
		Basecoat	Hardener 8550	Viscosity adjuster 8510/8520
Standocryl VOC Xtreme Plus Clear K9600	Effect colours	100	5%	20%
Standocryl VOC Xtreme Plus Clear K9600	Solid colours	100	5%	10%
Underhood / interior	Solid colours	100	10%	10%
Underhood / interior	Effect colours	100	10%	20%
8570/8580		100	5%	-

Standoblue Basecoat has the ability to be hardended with Standoblue Hardener 8550 for use in multi-toning, 3-stage ground colors, underhood/interiors and for general application where the basecoat requires to be hardened. The table illustrates the main details, this can also be found in Standowin when preparing the colour ready for use. Standox Demineralized Water 8000 can be added for application in lower humidity and warmer climates.
All amounts are cumulative.
Maximum 10% Standox Demineralized Water 8000 can be added in addition. Refer to Standoblue Climate Guide.
For use of 3-stage colours under K9600 both Ground coat & effect coat need to be activated according the above specifications.
For multi-toning every layer but the last one needs to be activated, except for use under K9600 all layers need to be activated.
When using K9600, the Basecoat blender needs to be activated according the above specifications.

For optimum application properties, apply the basecoat immediately after addition of Standoblue Hardener 8550 and Standoblue Viscosity Adjuster 8510/8520.
Solid colours: 5%: 1 hr 30 min - 2 hr
Solid colours: 10%: 45 min - 1 hr
Effect colours: 5%: 45 min - 1 hr
Effect colours: 10%: 30 min - 1 hr
Blender - 5%: 1 hr - 1 hr 30 min

	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.3	0.7 bar	atomisation pressure

see manufacturer's instructions



1 + 0.5
1 operation
1st: closed uniform coat
2nd: apply immediately an effect coat using an increased distance to the object

flash-off until flat
before clearcoating

	Interior 10% hardener	K9600 5% ambient/bake	K9600 5% Blowing
20 °C	12 hr - 16 hr	15 min - 25 min	-
35 - 40 °C	-	-	8 min - 12 min
60 - 65 °C	15 min - 20 min	10 min - 15 min	-

Clearcoat
Clearcoat not needed for interior use

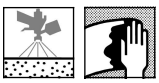
VOC compliant

2004/42/IIB(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.

Standoblue Basecoat

Product preparation - application Special Colours using Standoblue Effect Additive 8540

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



Old or original paintwork well sanded and cleaned.
Primer-surfacer or Filler, sanded and cleaned
Surfaces must be prepared and cleaned correctly before application
Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned

		Basecoat	Hardener 8550	Viscosity Adjuster 8510/8520	Effect Additive 8540
Special Colour	Effect Colours	100		0-20%*	300-600%*
Ground Colour	Effect Colours	100	5%**	20%	
Ground Colour	Solid Colours	100	5%**	10%	
Blender Ground Colour	8570/8580	100	5%**		

*please refer to the "ready-for-use" function in Standowin IQ to select the appropriate product adjustment of the Standoblue Basecoat Colour in use.
All amounts are cumulative.
**limited potlife, please refer to page "application with Standoblue Hardener".

Not applicable

	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3	1.8 - 2 bar	inlet pressure

see manufacturer's instructions

1.5 - 2 Ground coats (2K Hardened)	flash-off until matt Forced drying recommended
3 - 5 Effect Coat (Special Colour) 1.: Close fluid control (material delivery) on spray gun completely. 2.: Open fluid control by 0.75 to 1 turn (SATA RP1.2)***. 3.: Apply initial coats with 25-30 cm distance to the object and close overlap technique. Effect coats should be applied in a closed even film to create a semi wet appearance. 4.:Final coat of effect is applied at approx. 35 cm distance to correct any slight mottling (if needed). Tack rag between coats of effect colour is recommended (non sticky tack cloth). ***fluid control settings (material delivery) might vary depending on spray gun manufacturer	flash-off until matt blow dry between coats

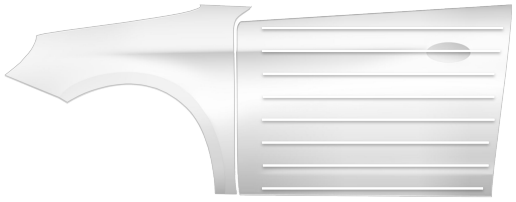
Clearcoat

VOC compliant

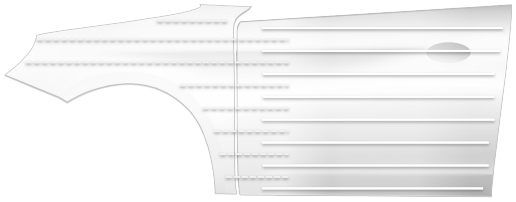
This product mix is not VOC compliant.

Standoblue Basecoat

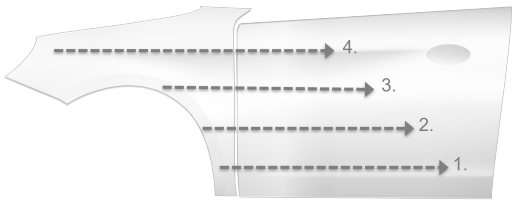
Standoblue blend-in guide Special Colours using Standoblue Effect Additive 8540



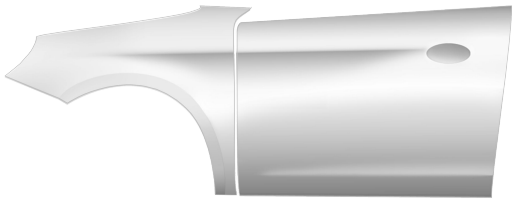
Apply a closed coat of hardened Standoblue Color Blend 8570 / Standoblue Color Blend Slow 8580 (blender +5% Standoblue Hardener 8550) to the adjacent blending area (panel). Do not fade out the blender and apply up to the edge of the panel.



Apply the hardened Standoblue ground colour in 1.5 coats over the repair area (repair panel) and into the still wet Standoblue Color Blend. When using white solid colours, reduced fluid control (material delivery) and fading out towards the repair area will help to avoid the formation of heavy droplets. For appropriate product adjustment, please refer to Standowin IQ ready-for-use information of the colour in use. Flash off and dry (forced drying is recommended - do not use hand blowers at this stage).



Allow panel to cool down completely. Adjust effect colour accordingly to ready-for-use recommendation given in Standowin IQ for the Special Colour in use. 1.: Close fluid control (material delivery) on spray gun completely. 2.: Open fluid control by 0.75 to 1 turn (SATA RP1.2)***. 3.: Apply the first effect coat to the widest area and flash off. Apply subsequent coats using an out-side-in technique, flash off between coats. Ensure a distance to the object of approx. 25-30cm. Effect coats should be applied in a closed even film to create a semi wet appearance. 4.: Final coat of effect is applied at approx. 35 cm distance to correct any slight mottling (if needed). Tack rag between coats of effect colour is recommended (non sticky tack cloth). 5.: Finally flash-off in readiness for clearcoat. ***fluid control settings (material delivery) might vary depending on spray gun manufacturer.

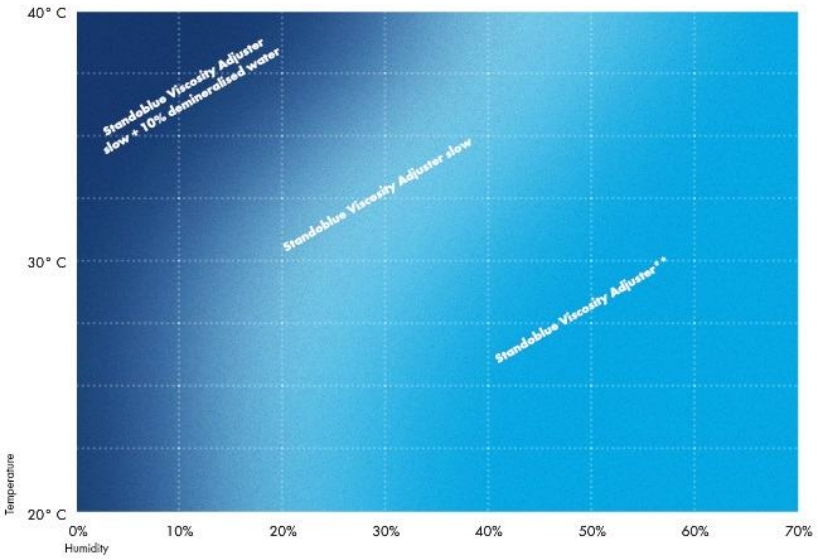


Apply a Standocryl VOC Clear to finish the repair.

Climate guide

Use the climate guide to select the correct Standoblue Viscosity Adjuster 8510/8520. Repair size should also be considered, larger repairs may require a slower adjustment.

Refer to booth temperature on spray cycle, check relative humidity in booth with Hygrometer
Do not leave Hygrometer in booth during bake cycle



**30% Standoblue Viscosity Adjuster 8510 can be added when relative humidity is above 65%, only for Metallic and Pearl colours
Standoblue Viscosity Adjuster 8510:
Standard adjuster for small to medium repairs and for humidity between 30-70%
Standoblue Viscosity Adjuster Slow 8520:
Slower adjuster for lower humidity below 30% and for larger repairs. Also well suited when high temperature and medium to low humidity are combined.
Will also help for 3-stage applications in low humidity conditions.
Standox Demineralized Water 8000:
this can be added in very low humidity together with higher temperature conditions
Will also help on large surface in lower humidity with/without higher temperature, especially for 3-stage applications

Standoblue Basecoat

Products

Standoblue Basecoat

10 - 20 µm Effect Colors
12 - 25 µm Solid Colors

Theoretical coverage

145 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.

Clean after use with a suitable waterborne guncleaner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Standoblue Basecoat has to be filtered through waterproof 125 µm quick sieves before application by cup system (e.g. SATA or 3M).
- All tools and equipment used with this product must be approved for waterborne paint.
- Flash-off time can be reduced by using air blowers, spray booth blower systems or increasing spray booth temperature.
- Allow additional time for preheating up to panel temperature.
- All stated drying and flash-off times are related to relative humidity and type of blowing equipment.
- Best to be used within one working day after addition of the Standoblue Viscosity Adjuster.
- Standoblue basecoat hardened and non hardened has to be overcoated with clearcoat within 72 hours.
- Ready for use, non-activated, Standoblue Basecoat can be used within 6 months, but Viscosity adjuster must be added again in the same ratio before using. We advise to make a colour spray-out card prior to applying on the vehicle. Opacity may be affected by this 2nd addition of Viscosity Adjuster.
- Mixing machine should not exceed 2 x 15 minutes cycles in 24 hour period.
- New unopened cans of toners/tints should be adequately stirred before use.
- Recommended transport and storage between 5 and 35°C (do not expose at temperature below 5°C).

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 Standox 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 Standox product range, unless explicitly indicated otherwise.

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