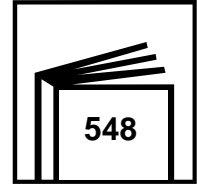


# Standex<sup>®</sup> 2K HS System Filler


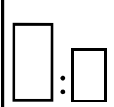









## Ordering Information:

3.5 Liter	2K HS System Filler Light Gray	020 15161
3.5 Liter	2K HS System Filler Dark Gray	020 16170

## Features:

- ✧ Excellent vertical hold-out
- ✧ Chromate free
- ✧ Excellent filling properties

Working Process: 4:1 HS Priming System	
<b>Substrates:</b>	
<ul style="list-style-type: none"> <li>✓ Through-hardened, sanded paintwork</li> <li>✓ Sanded, solvent resistant OEM primers used on replacement parts</li> <li>✓ TPA and critical substrates</li> <li>✓ <b>Standex</b> Polyesters, sanded</li> </ul>	
	For substrate preparation information see <b>Standex</b> Painting System S1!
	4:1 with <b>Standex</b> 2K Hardeners (05-15, 15-25, 20-30, 25-40, 30-45) potlife 60-90 min/68°F (20°C)
	If necessary, add <b>Standex</b> 2K Thinner. 24-26 s/DIN 4 mm/68°F (20°C)
	1.5 - 1.8 mm 2-3 coats = up to 8.0 mil (200 micron) Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.
	1.4 - 1.8 mm 2-3 coats = up to 8.0 mil (200 micron) Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.
	Air dry 3 hours @ 80°F (27°C) or Flash off 5-15 min/ 68°F (20°C), then Bake 30 min 140°F (60°C) panel temperature
	Short wave 12-15 min Medium wave 18-22 min (see Painting System S9) For higher film builds overnight dry.
	Orbital sand P400-P500 Wet Sand P600-P800
	<b>Standocryl</b> 2K Paints or <b>Standex</b> Basecoat/ <b>Standohyd</b> Basecoat with <b>Standocryl</b> 2K Clears

# Standex<sup>®</sup> 2K HS System Filler

## Important Technical Remarks:

- Unsanded replacement parts primed with solvent-resistant E-coat primer can be directly coated with this product after **thoroughly** cleaning with **Standex** Silicone Remover Antistatic/**Standohyd**<sup>®</sup> Silicone Remover 0.4/**Standohyd** Cleaner and a scuff pad.
- For better control of the sanding process, spray the filler and allow to dry. Apply a guide coat before sanding.
- Small imperfections can be reworked with Standox Polyester Stopper. Spot Polyester must be re-primed.
- Use a **Standex** Etch Primer on all bare metal for Warranty compliance and adhesion.
- Apply a maximum of 2 coats (approx 3.0 mil) before sanding. Increase flash off times before baking. If plasticized, do not store on mixing bank. Mix only before use.
- For plastic refinishing, best results are achieved when using **Standex** 2K Nonstop Primer Filler. When **Standex** 2K HS System Filler is used for plastic refinishing, mix with 30% **Standex** 2K Plasticiser (2+30%:1). Raw plastic must be pre-primed with **Standoflex**<sup>®</sup> 1K Plastic Primer (14408/12065). Mix ratio is: (Mixing Stick G or K).

Repairing Plastic Parts (See Plastics Pg 3.) Mixing Stick G or K.		
2	+30%	:1
2K HS System Filler	2K Plasticiser	Hardener

## Important Legislative Remarks:

- Please see the appropriate VOC Wallchart for compliance for your area. The values depicted below are “as applied regulatory” for the coating. Values have been determined using EPA Test Method 24. Please see the Master Values List for information for information on individual components.

VOC Category	VOC Regulatory	Density g/l	Wt% Volatiles, Water & Exempts	Vol% Water & Exempts
Primer Surfacer	4.2 lbs/gal - 502 g/l	1395 g/l	39.4%	0.3%
Elastomeric Coating	3.9 lbs/gal - 467 g/l	1268 g/l	32.2%	0.2%

- **For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components. Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates. Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.**
- Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.