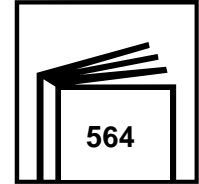


Standocryl[®] 2K HS Clear



Ordering Information:

5 Liter	2K HS Clear	020 14580
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Features:

- ✧ High quality 2K HS Clear
- ✧ Excellent mechanical and chemical resistance
- ✧ High solid, low VOC technology
- ✧ Outstanding vertical hold out

Working Process: HS Clear System (2:1 System)	
Substrates:	
<ul style="list-style-type: none"> ✓ Through-hardened, sanded paintwork ✓ Standex Basecoat ✓ Standohyd Basecoat 	
	For substrate preparation information see Standex Painting System S1!
	2:1 with Standex 2K or 2.1 Hardeners potlife 30-60 min /68°F (20°C)
	Add Standex 2K Thinners to spray viscosity. 2.1 Thinners may be used for California VOC Regulations. (5% max thinner when used with 2K Hardener) 16-18 s/DIN 4 mm/ 68°F (20°C) (2 coat process) 18-20 s/ DIN 4 mm/ 68°F (20°C) (1.5 coat process) 5% Standex 2K Fast Dry Additive may be added to speed up the flash-off and baking process. See appropriate VOC Wallchart for compliancy in your area.
	1.3 - 1.4 mm 1.5-2 coats = 2.0-2.4 mil (50-60 micron) Please refer to gun manufacturer and local legislation for proper spray pressure recommendations. Note: 1.5 coat process= one continuous application to achieve between 2.0- 2.4 mil.
	1.2 - 1.3 mm 1.5-2 coats = 2.0-2.4 mil (50-60 micron) Please refer to gun manufacturer and local legislation for proper spray pressure recommendations. Note: 1.5 coat process= one continuous application to achieve between 2.0- 2.4 mil.
	5-10 min/68°F (20°C) Final flash off
	Bake 30 min/140°F (60°C) panel temperature or Air dry overnight/ 68°F (20°C)
	Short wave 8-12 min Medium wave 12-14 min (see Painting System S9)

Standocryl[®] 2K HS Clear

Important Technical Remarks:

- Fast hardeners and thinners may raise viscosity and shorten pot life.
- **Stadox 2.1** Hardeners must be used for compliancy in 4.5 lbs/gal topcoat and 5.2 lbs/gal tri-stage limitation areas. Please refer to the appropriate VOC wallchart for mixing for your area.
- **Stadox 2.1** Hardener-Fast & **Stadox 2.1** Thinner-Fast/ 2K Rapid Thinner may be used for jamming.
- **Stadox 2K HS Clear** can be matted by mixing with **Standocryl 2K Matt Clear 007**. See TDS 570 in the Plastics Section of this manual.
- **Stadox 2K HS Clear** can be mixed 15% with **Stadox 2K Plasticiser (15260)**. Add **Stadox 2K/2.1 Thinner** or **Stadox 2K Fast Dry Additive** to achieve viscosity. **Flash off and drying times will be longer.** Up to 30% 2K Plasticiser may be added to extremely flexible parts. Mix ratio is:

2K HS Clear Plasticised		Mixing Stick F or J.
2	+15%	:1
2K HS Clear	2K Plasticiser	Hardener

Important Legislative Remarks:

- Please see the appropriate VOC Wallchart for compliance for your area. The wallchart will reflect appropriate VOC for BC/CC methodology. The values depicted below are “as applied regulatory” for the coating alone. 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
Topcoat Clear Coat 2K Hardener 2:1 2:1+5% 2:1+10%	3.8 lbs/gal - 459 g/l 4.0 lbs/gal - 482 g/l 4.2 lbs/gal - 503 g/l	1017 g/l 1013 g/l 855 g/l	45.2% 47.8% 50.2%	0% 0% 0%
Topcoat Clear Coat 2.1 Hardener 2:1 2:1+5% 2:1+10%	3.0 lbs/gal - 357 g/l 3.2 lbs/gal - 385 g/l 3.4 lbs/gal - 410 g/l	1071 g/l 1065 g/l 1059 g/l	46.7% 49.3% 51.6%	13.2% 12.6% 12.0%
Elastomeric Clear Coat 2K Hardener 2:1+10%	4.1 lbs/gal - 488 g/l	1016 g/l	48.6%	0%
Elastomeric Clear Coat 2.1 Hardener 2:1+10%	3.3 lbs/gal - 395 g/l	1064 g/l	50.0%	12.0%
Elastomeric Matt Coating 2K Hardeners 2.1 Hardeners	4.7 lbs/gal - 569 g/l 4.2 lbs/gal - 508 g/l	1010 g/l 1042 g/l	57.1% 58.0%	0% 7.9%

- **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.