




Working Process: Blending-in with 3-Stage Standohyd Basecoat	
Substrates:	<ul style="list-style-type: none"> ✓ For preparation of the repair areas, see Painting System S1. Keep the surface for priming with Filler as small as possible.
Substrate Preparation: 	<p>Sand the repair area for application of Standohyd Basecoat with P800. Sand surrounding blend areas with P1200-P1500 (wet or dry). Then, finish the entire surface with a gold scuff pad in conjunction with Standohyd[®] Sanding Paste. (Article No. 14670). Trizact P1000 may also be used.</p> <p>For substrate cleaning, see Standex Painting System S1. Final cleaning must be done with a Standohyd Cleaner.</p>
Painting:	<ul style="list-style-type: none"> ● Apply Standohyd Basecoat ground color over repair area or new replacement panels/parts until opacity is achieved. ● Flash off with blow gun until matt. For high humidity allow 5-10 minutes additional flash off. ● Remove masking over adjacent parts. Apply and blend color to adjacent parts with ground color. ● If necessary, apply Standohyd Color Blend (80045). ● Apply Standohyd midcoat with reduced viscosity (18-22 s/DIN4) and reduced spray pressure (15-25 psi (1-1.5 bar)) with several spray passes and even out spray pattern to achieve opacity. After each spray pass, blow dry with an air gun. Flash-off matt. ● Apply 1 spray pass Standocryl[®] 2K Clear on Standohyd Basecoat blending-in area. After flash-off time, apply Standocryl 2K Clear over the whole panel to achieve 2.0-2.4 mils.

Important Technical Remarks:

- If necessary, mix 1:1 with **Standohyd** Colorblend (80045) to make the final spray passes of the blend-in procedure.
- Remove overspray carefully from entire area with a tack rag after a final flash off to a matt finish.
- Always perform a sprayout/let down panel to confirm proper coverage and flake control, especially for colors such as 3-Stage Pearls.

Important Legislative Remarks:

- **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.**
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