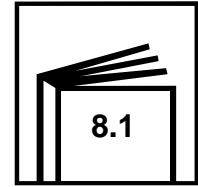


Standex® Charts & Systems

Blending-in and Polishing of 2K Clears



Working Process: Blending-in and Polishing of 2K Clear	
Pretreatment/ Cleaning:	For substrate preparation information, see Standex Painting System S1. Sand the fade out-blend area carefully with a fine, dual action sander and P3000/P4000 (3M Trizact or Abralon) and a soft interface pad. 6 inch disk (150 mm, optional for small areas with 3-inch disk).
Painting:	<ul style="list-style-type: none"> Mix Standocryl® 2K Clear according to the appropriate TDS. Apply mixed clear over Basecoat repair area (1 or 2 passes depending on the area).
Fading Out:	<ul style="list-style-type: none"> Mix hardened clear 1:1 with Standex Smart Blend and apply on fadeout area. Final blend 3 parts Standex Smart Blend with 1 part ready-to-spray clear (over 3000/4000 area).
Drying:	<ul style="list-style-type: none"> Bake 30-35 minutes @ 140-150°F (60-65°C) panel temperature. If polishing the same day, follow by IR (short wave) for at least 15 minutes @ 100%.
Polishing a Blend Area	Removing a Defect
Sand with 3M Trizact P3000 or Mirka Abralon P3000/P4000 over the overspray blend area. Defects may be removed in the solid clearcoat area with P2000 and then followed by Trizact P3000 or Mirka Abralon P3000/P4000.	Remove defect with P1500 and, re-sand area with DA and 3M Trizact P3000.
Farécla	3M
Stage 1: Polish with G4 or Smart Repair & white G mop at low speed <1000 rpm until small amount of residue is visible.	Stage 1: Compound with Finesse-It™ SRC Finishing Material (PN 05927) with wool pad (PN 05703 or 5719). Clean surface and wipe residue and lint with a detailing cloth (PN 06016). If scratches are still visible, repeat stage 1.
Stage 2: Increase speed to approx. 1800-2000 rpm to remove remaining residue & check to see if scratches are removed. Repeat Stage 1 as necessary. If scratches persist, change to a lambs wool mop.	Stage 2: Polish with Finesse-It™ SRC Finishing Material (PN 05927) with black foam pad (PN 5725 or PN 5738). Wipe off residue with Detailing Cloth (PN 06016).
Stage 3: Change to black finishing pad and polish with G4 or Smart Repair at high speed until high gloss is achieved.	Stage 3: Apply Perfect-It 3000 Ultrafin SE to eliminate swirl marks.
Stage 4: Finish with Black top hand glaze to remove any smears or haze.	Stage 4: Optional-Apply Perfect-It™ 3000 Final Glaze (PN 6066) to protect the painted surface.

Important Technical Remarks:

- It is best to polish the next day! For the same day, polish only after proper bake and IR short-wave (100%) for 15 min and cool down for 60 min.
- Note: Other compounds are offered by 3M, Farécla and Meguiar's. These are only examples that have been tested by **Standex** and are not exclusively recommended.
- Blending-in with 2K Clearcoats and 2K Standocryl is not an approved OEM repair, nor is it covered under the **Standex** Lifetime Warranty. All warranty repairs require that clearcoat be applied to a suitable break line, i.e., edge to edge.

Important Legislative Remarks:

- 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.