

Standox[®] Plastic Painting Systems

Painting Primed Replacement Bumpers



Pretreatment / Cleaning Option 1	Pretreatment / Cleaning Option 2
If primer fails a solvent test: Thoroughly scuff and de-gloss the bumper with a gold scuff pad and Standoflex Low VOC Plastic Cleaner (16010). Avoid break-throughs. Bare plastic must be pre-primed with Standoflex[®] 2K or 1K Plastic Primer.	If primer does not fail a solvent test: Thoroughly scuff and de-gloss the bumper with a red or gray scuff pad or appropriate grit sand paper.
Painting	
- Apply Standox 2K Nonstop Primer Filler (15331/16153/16154) with 15% Standox 2K Plasticiser (15260). Mix ratio is 3+15%:1+30%. Apply 1-1.5 coats (1.2-1.6 mil). Flash off 20-30 minutes at 68°F (20°C). Basecoat/Clearcoat: Apply Standox Basecoat or Standohyd Basecoat. Mix Standox 2K Clear with 15% 2K Plasticiser (15260). Then, mix according to the appropriate TDS. Single Stage: Mix 2K Standocryl[®] or 2K HS Standocryl with 15% 2K Plasticiser (15260). Then, mix according to the appropriate TDS. Note: Up to 30% Standox 2K Plasticiser may be added for extremely flexible plastic parts.	

Important Technical Remarks:

- For extremely flexible parts and for vehicles subject to extremely high chipping environments, up to 30% **Standox** 2K Plasticiser must be added to **Standox** 2K Nonstop Primer Filler. Use as a sanding system.
- Addition of 15% Hardener to **Standox** Basecoat will improve chip performance on plastic parts.
- Allow six weeks to pass before cleaning the finished part with a high-pressure washer.

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. 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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