

Standocryl 2K Topcoat

Standocryl 2K Topcoat medium solids topcoat with optimal gloss and colour durability.

- High mechanical and chemical resistance.
- 2K MS topcoat with outstanding gloss and colour fastness.



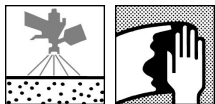
The Art of Refinishing.

Standocryl 2K Topcoat

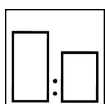
Product preparation - application Standard - HS



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Primer-surfacer or Filler, sanded and cleaned
Primer-Surfacer or Filler, unsanded in a wet-on-wet process
Surfaces must be prepared and cleaned correctly before application
Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned



Topcoat	Hardener	Thinner
3	1	10%
Standocryl Topcoat	HS 5-15 HS 15-25 HS 20-30 HS 25-40	2K 15-25 2K 20-25 2K 25-35 2K 35-40



Pot life at 20°C: 5 hr - 6 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.4	1.8 - 2.2 bar	inlet pressure
HVLP	1.3 - 1.5	0.7 bar	atomisation pressure
see manufacturer's instructions			



2 coats intermediate and final flash-off: 5 min - 10 min



	HS5-15/HS15-25/HS20-30/HS25-40
20 °C	12 hr - 16 hr
60 - 65 °C	25 min - 30 min



Guideline for short wave IR equipment
Half power: 5 min
Full power: 8 - 12 min

VOC compliant

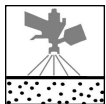
This product mix is not VOC compliant.

Standocryl 2K Topcoat

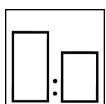
Product preparation - application Standard - MS



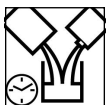
It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



1K primer, Primer-surfacer or Filler, sanded and cleaned
Primer-Surfacer or Filler, unsanded in a wet-on-wet process
Surfaces must be prepared and cleaned correctly before application
Repair areas should be sanded with P500-P600 (by machine) or P800-P1000 (by hand) and cleaned



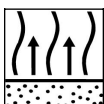
Topcoat	Hardener	Thinner
2	1	5%
Standocryl Topcoat	MS 5-15 MS X 5-25 MS X 15-30 MS 25-40	2K 10-20 2K 15-25 2K 20-25 2K 25-35 2K 35-40



Pot life at 20°C: 4 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.4	1.8 - 2.2 bar	inlet pressure
HVLP	1.3 - 1.5	0.7 bar	atomisation pressure
see manufacturer's instructions			



2 coats intermediate and final flash-off: 5 min - 10 min



	MS5-15/MSX5-25/MSX15-30/MS25-40
20 °C	12 hr - 16 hr
60 - 65 °C	25 min - 30 min



Guideline for short wave IR equipment
Half power: 5 min
Full power: 8 - 12 min

VOC compliant

This product mix is not VOC compliant.

Standocryl 2K Topcoat

Products

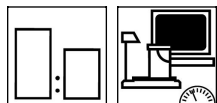
Standocryl 2K Topcoat

Standox Hardener HS 15-25
Standox Hardener HS 20-30
Standox Hardener HS 25-40
Standox Hardener HS 5-15
Standox Hardener MS 25-40
Standox Hardener MS 5-15
Standox Hardener MS X 15-30
Standox Hardener MS X 5-25

Standox Thinner 2K 10-20
Standox Thinner 2K 15-25
Standox Thinner 2K 20-25
Standox Thinner 2K 25-35
Standox Thinner 2K 35-40

Standocryl 2K Topcoat

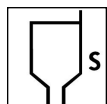
Product mix



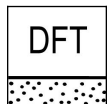
Mixing ratios with special agents are available in the productmix table on Standowin IQ and in the specific TDS.

The choice of hardener and Thinner should be made according to application temperature and size of repair.

MS 5-15	Accelerated fast hardener suitable for Micro and Spot repairs. Recommended for cooler application conditions. Suitable for Stadox Fillers for air drying at lower temperatures.
MS X 5-25	Fast hardener suitable for Micro Repair, Spot and panel repairs. Recommended for application temperature up to 25°C.
MS X 15-30	Accelerated fast hardener for small panels or for design work (stripes) 20-25°C.
MS 25-40	Non-accelerated slow hardener suitable for medium to large size repairs. Recommended for use in hot climates e.g. 25-40°C.
HS 5-15	Accelerated fast hardener for small panels or for design work (stripes) 20-25°C.
HS 15-25	Medium hardener suitable for panel and multi panel repairs. Recommended for application temperature of 15-25°C.
HS 20-30	Medium-slow hardener suitable for medium to large size repairs. Recommended also for warm conditions e.g. 20-30°C.
HS 25-40	Non-accelerated slow hardener suitable for medium to large size repairs. Recommended for use in hot climates e.g. 25-40°C.
2K 10-20	Accelerated fast thinner suitable for Micro Repair, spot and panel repairs. Recommended for cooler application conditions e.g. 10-20°C.
2K 15-25	Fast thinner suitable for Micro Repair, Spot and panel repairs. Recommended for temperature of 15-25°C.
2K 20-25	Medium thinner suitable for panel and multi panel repairs. Recommended for application temperature of 20-25°C.
2K 25-35	Medium-slow thinner suitable for medium to large size repairs. Recommended also for warm conditions e.g. 25-35°C.
2K 35-40	Slow thinner suitable for medium to large size repairs. Recommended for use in hot climates e.g. 35-40°C.



ISO 4: 41 - 49 s at 20°C
DIN 4: 17 - 19 s at 20°C



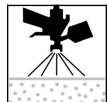
50 - 60 µm

Theoretical coverage

380 - 410 m²/l at 1 micron dry film thickness

Due to different hardener characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.

Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.



Standocryl 2K Topcoat can be overcoated with itself within 24 hours, with scuff sanding

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Clean after use with a suitable solventbased guncleaner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
 - Allow additional time for preheating up to panel temperature.
 - Surplus ready for use material should not be returned to original can.
 - Standocryl 2K Topcoat can be used with Standocryl 2K Structure MIX 603 Coarse / MIX 602 Fine or Standox Plasticiser 5660.
 - 15% Standox Plasticiser 5660 can be added to the topcoat. Mixing ratios are unchanged.
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Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our Standox product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Standox product range, unless explicitly indicated otherwise.

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