

Standohyd Plus Basecoat



Standohyd Plus is one of the most efficient and proven passenger car basecoat systems. It is a water-based low solvent and environmentally-responsible system which offers outstanding colour accuracy and efficient application combined with superior quality for metallic and solid colours.

- Solid, metallic, pearl colours.
- Water-based.
- Application in a single spray process (One Visit Application).
- Easy to blend in.
- Outstanding colour accuracy.
- Good opacity.
- Contains less than 10 % organic solvent.
- High coverage.

Proven basecoat quality.



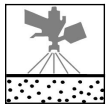
The Art of Refinishing.

Standohyd Plus Basecoat

Product preparation - application for 2-stage colours



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



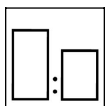
Old or original paintwork well sanded and cleaned.

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



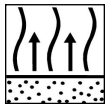
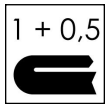
		Basecoat	Demineralised Water
		Standohyd Plus	Standex
Standard	All colours	100	5-10%



Not applicable



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.3	0.7 bar	atomisation pressure
see manufacturer's instructions			



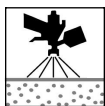
1 + 0.5

1 operation

1st: closed uniform coat

2nd: apply immediately an effect coat using an increased distance to the object

flash-off until matt



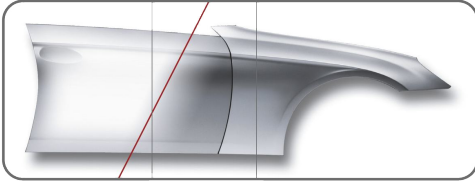
Clearcoat

VOC compliant

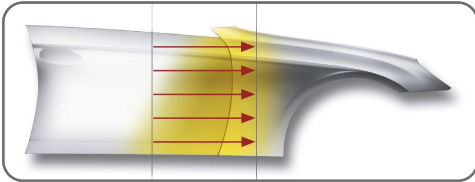
2004/42/IIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

Standohyd Plus Basecoat

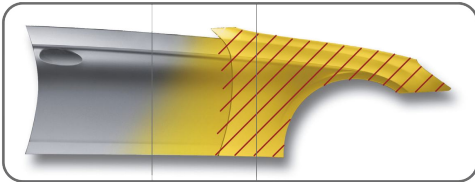
Standohyd Plus Basecoat blend-in poster 2-stage colours



Standohyd Plus Color Blend is applied in a single spray pass in a wedge shape

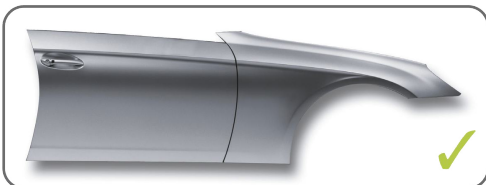


Fade out Standohyd Plus Basecoat with reduced pressure 0.8-1.0 bar, into the wet Standohyd Plus Color Blend (Work in direction of the arrows)



Standohyd Plus Basecoat is applied over the new panel with normal spray pressure to achieve opacity

If required apply a mixture of RFU Standohyd Plus Basecoat + Standohyd Plus Color Blend (1:1) with reduced pressure 0.5-0.8 bar in a light droplet coat over the transition zone to disguise the fade out area



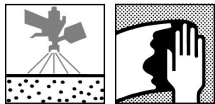
Apply a Standocryl VOC Clear to finish the repair.

Standohyd Plus Basecoat

Product preparation - application for 3-stage colours



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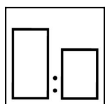


Old or original paintwork well sanded and cleaned.

Primer-surfacer or Filler, sanded and cleaned

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



Ground coat		Basecoat	Special Additive	Demineralised Water
		Standohyd Plus	Standohyd Plus	Standex
2K Hardened	All colours	100	5%	5-10%

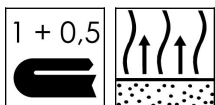
Effect/midcoat		Basecoat	Demineralised Water
		Standohyd Plus	Standex
Standard	All colours	100	5-10%

All amounts are cumulative.

2K Hardened: 30 min



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.3	0.7 bar	atomisation pressure
see manufacturer's instructions			



1 - 2 Ground coats (2K Hardened)	5 - 10 minutes final flash followed by 15-20 minutes at 60 - 65°C object temperature.
1 + 0.5 effect/midcoat	flash-off until matt

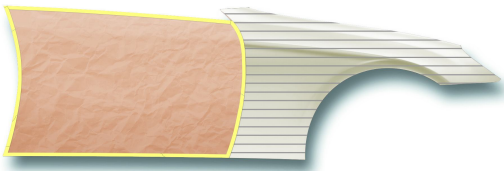
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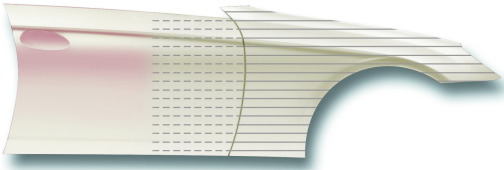
Standohyd Plus Basecoat

Standohyd Plus Basecoat blend-in poster 3-stage colours

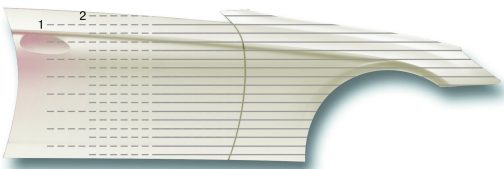
Mix Standohyd Plus Basecoat ground colour with 5 % Standohyd Plus Special Additive and then adjust to spray viscosity 22-26sec. DIN 4mm by adding Standox Demineralized Water as usual. Potlife of mixed material maximum 30 min. at 20°C.



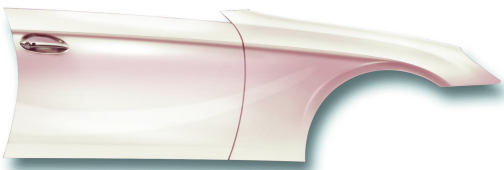
Mask adjacent panels. Apply Standohyd Plus Basecoat ground colour to new panels until complete opacity has been reached.



Remove masking and extend with ground colour into adjacent panel. 5 - 10 minutes final flash followed by 15 - 20 minutes at 60-65°C object temperature. Allow surfaces to cool down to normal temperature.



Apply Standohyd Plus Basecoat effect colour to the complete new part and blend-in to the adjacent parts. Spray first coat to the widest area, if needed apply 2nd and 3rd coat with intermediate flash off. Work back from the widest area with staggered overlapping effect coats to avoid a strong halo / visible edge and provide a smooth transition. Start from widest area and work towards centre.



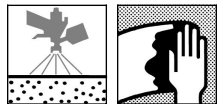
Apply Standocryl VOC Clear to complete the repair process over all surfaces.

Standohyd Plus Basecoat

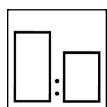
Product preparation - application with Standohyd Plus Special Additive



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



Old or original paintwork well sanded and cleaned.
Primer-surfacer or Filler, sanded and cleaned
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		Basecoat	Special Additive	Demineralised Water
		Standohyd Plus	Standohyd Plus	Standox
K9600	All colours	100	5%	5-10%

Standohyd Plus Basecoat and Standohyd Plus Color Blend must be made ready for use with Standohyd Special Additive if overcoating with Standocryl VOC Xtreme Plus Clear K9600.



2K Hardened: 30 min

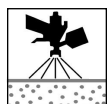


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Clearcoat

VOC compliant

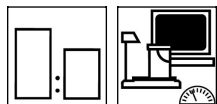
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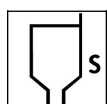
Products

Standohyd Plus Basecoat

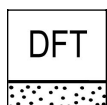
Product mix



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



ISO 4: 61 - 76 s at 20°C
DIN 4: 20 - 26 s at 20°C



10 - 20 µm Effect colours
12 - 25 µm Solid colours

Theoretical coverage

115 - 215 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.



Clean after use with a suitable waterborne guncleaner.

Waste treatment

The polluted waste water can be either handled as chemical waste or it can be treated with coagulant 16.30 that will separate solid from liquid components and reduce your chemical waste by 60% or more. - Procedure Add 1% of 16.30 to the polluted waste water and mix thoroughly (with mixer) for 3-5 min until you see the solid material separating. Filter out the solid chemical waste. The separated solid waste and water have to be treated according to local regulations.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- New mixing toners/tints should be shaken or stirred before use.
- All tools and equipment used with this product must be approved for waterborne paint.
- Allow additional time for preheating up to panel temperature.
- Recommended storage temperature at 15°C to 25°C (do not expose at temperatures below 5°C).
- Flash-off time can be reduced by using air blowers, spray booth blower systems or increasing spray booth temperature.
- Standohyd Plus Basecoat and Standohyd Plus Color Blend must be made ready for use with Standohyd Plus Special Additive if overcoating with Standocryl VOC Xtreme Plus Clear K9600.
- In countries/regions where higher temperatures above 25°C in combination with high relative humidity are experienced, we recommend to reduce the addition of Standox Demineralized Water to 0-5%.
- In hot and dry conditions Standox Demineralized Water can be replaced by Standohyd Plus Hot and Dry Thinner in the same mixing ratio.
- Standohyd Plus Basecoat has to be filtered through waterproof 125 µm quick sieves before application by cup system (e.g. SATA or 3M).

Standohyd Plus Basecoat

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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