

# Standofleet 2K VOC Clear K9350



**Standofleet is the modular paint system for commercial vehicles that complies with the strict VOC limits of the European Union. Standofleet 2K VOC Clear K9350 is a 2K, VOC-compliant clearcoat for clear-over-base systems. This high-quality clearcoat meets the highest standards of the bus and commercial vehicle sector. It is ready to use after the hardener has been added. It helps to guarantee easy application under most bodyshop conditions.**

- Lasting high gloss for clear-over-base systems.
- Excellent holdout.
- High mechanical and chemical resistance.

**High-gloss finish for commercial vehicles that complies with the EU Directive.**



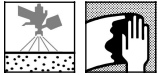
**The Art of Refinishing.**

# Standofleet 2K VOC Clear K9350

## Product preparation - application STANDARD



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



Standoblue Basecoat / Standohyd Plus Basecoat: Surfaces must be dried / flashed-off in accordance with TDS before application

Standofleet 2K Topcoats: Surfaces must be sanded and degreased before application



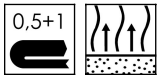
Clear		Hardener	
Volume	Weight	Volume	Weight
3	100	1	37
K9350		4110 (FLEET HS FAST)	
		4120 (FLEET HS) *	
		4130 (FLEET HS SLOW)	

\* Matt gloss levels 4:1

Pot life at 20°C: 4 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.5	1.8 - 2.2 bar	inlet pressure
HVLP	1.3 - 1.5	0.7 bar	atomisation pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.3 bar	material pressure
see manufacturer's instructions			



0.5 + 1

1 operation

1st: thin and closed

2nd: normal

with intermediate flash-off: 0 min - 2 min

final flash-off: 5 min - 10 min

2 coats

with intermediate flash-off: 15 min - 45 min

final flash-off: 10 min



18 - 22 °C

60 - 65 °C

**4120 / 4110 / 4130**

12 hr - 16 hr

30 min - 40 min



Guideline for short wave IR equipment

Half power: 5 min

Full power: 15 - 20 min

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.

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## Products

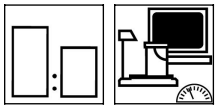
Standofleet 2K VOC Clear K9350

Standofleet 2K HS Hardener 4120

Standofleet 2K HS Hardener Fast 4110

Standofleet 2K HS Hardener Slow 4130

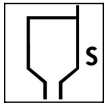
## Product mix



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

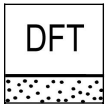
The choice of hardener and Thinner should be made according to application temperature and size of repair.

4110	Accelerated fast hardener for small panels or for design work (stripes) 20-25°C.
4120	Standard hardener for all 2K CV products (20-25°C).
4130	Slow hardener for large surfaces and high temperatures (>30°C).



ISO 4: 45 - 53 s at 20°C

DIN 4: 18 - 20 s at 20°C



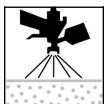
50 - 60 µm

### Theoretical coverage

505 - 510 m<sup>2</sup>/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.



Standofleet 2K VOC Clear K9350 can be overcoated with itself within 24 hours, without intermediate sanding



Clean after use with a suitable solventbased guncleaner.

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## Remarks

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- 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.
  - Close can of hardener tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
  - 15% Standox Plasticiser 5660 can be added to the Clearcoat. Hardener and thinner ratios are unchanged.
  - Standofleet 2K Topcoats: Surfaces must be sanded and degreased before application, also wet on wet application possible after 30 minutes flash-off.
  - Different gloss levels can be created by using Standox Special Matt 5630. Mixing ratios see color tools.
  - In countries without VOC legislation Standox Basecoat can be used as well.
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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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