

Standox Basecoat

Solvent-based Standox Basecoat System.

- Easy blending.
- Optimal colour accuracy.
- Available in solid, metallic and pearl effect colours.
- Outstanding filling properties.
- Good hiding.
- Standox solvent basecoat system process.

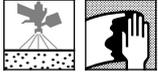


Standex Basecoat

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	Thinner
			MSB
Standard	All colours	100	50-60%



Not applicable



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.4	1.8 - 2 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure
see manufacturer's instructions			



2 - 3 coats
 with intermediate flash-off: 5 min - 10 min
 final flash-off: 10 min - 15 min



Clearcoat

VOC compliant

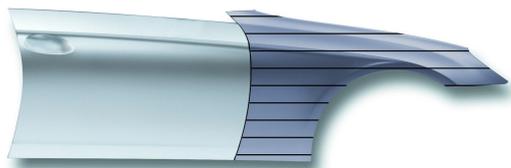
This product mix is not VOC compliant.

Stadox Basecoat

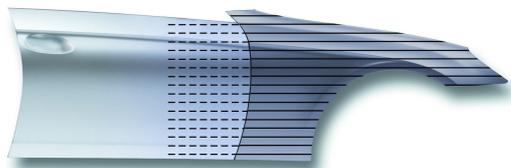
Stadox Basecoat blend-in poster 2-stage colours



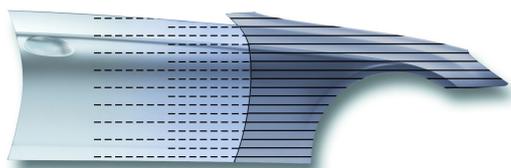
Apply Stadox Basecoat Colorless to adjacent panels. Flash off.



Spray the repaired area with Stadox Basecoat in single coats.



Extend the area of application of each coat



Extend this fade out area and blend, spraying with reduced pressure



After thorough final flash off before applying Standocryl Clear.

Standex Basecoat

Product preparation - application for 3-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

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	Thinner
			MSB
Standard	All colours	100	50-60%



Not applicable



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.4	1.8 - 2 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure
see manufacturer's instructions			



2 - 3 ground coat

with intermediate flash-off: 5 min - 10 min
final flash-off: 10 min - 15 min

2 Effect/midcoat

with intermediate flash-off: 5 min - 10 min
final flash-off: 10 min - 15 min



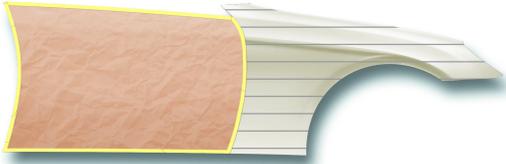
Clearcoat

VOC compliant

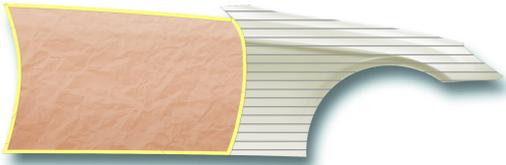
This product mix is not VOC compliant.

Stadox Basecoat

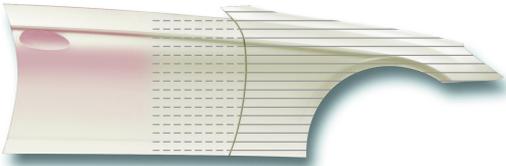
Stadox Basecoat blend-in poster 3-stage colours



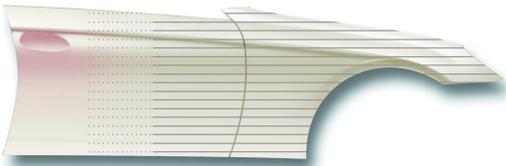
Mask off adjacent panel. Apply the first coat of the ground colour as normal uniform coat. Flash off.



Apply the second coat of the ground colour as a normal uniform coat to achieve final opacity. If full coverage is not obtained, this step can be repeated



Remove masking and reduce spray pressure to 0.5-1.0 bar and fade out into adjoining panel. Flash off and repeat this step, if needed. Finally dry ground colour or allow longer flash off, approx. 20-30 min



Sand blending panel slightly with pad grey to remove overspray, if needed. Apply Stadox Basecoat Colourless to the adjacent panel if desired. Apply effect colour first coat to the ground colour and fade out over the edge of the previous applied ground colour into the adjacent panel. Use droplet technique for fading out. Flash off.



Apply second coat of the effect coat and fade out over the edge of the previous layer into the adjacent panel. Use droplet technique for fading out with reduced pressure.



After thorough final flash off before applying Standocryl Clear.

Standex Basecoat

Product preparation - application 2K Hardened



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	Hardener	Thinner
				MSB
MS Hardened	All colours	100	MS - 20%	30-40%
HS Hardened	All colours	100	HS - 15%	40%
VOC Hardened	All colours	100	VOC - 10%	45%

All amounts are cumulative.



2K Hardened: 1 hr



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.4	1.8 - 2 bar	inlet pressure
HVLP	1.3 - 1.4	0.7 bar	atomisation pressure
see manufacturer's instructions			



2 - 3 coats
 with intermediate flash-off: 5 min - 10 min
 final flash-off: 10 min - 15 min



	MS / HS / VOC
20 °C	2 hr
60 - 65 °C	20 min



Clearcoat

VOC compliant

This product mix is not VOC compliant.

Standex Basecoat

Product preparation - application Basecoat Real Black



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
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	Hardener	Thinner
			MSB
MS Hardened	100	20%	40%
HS Hardened	100	15%	40%
VOC Hardened	100	10%	40%



Activated: 1 hr



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.4	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.4	0.7 bar	atomisation pressure
see manufacturer's instructions			



2 coats
with intermediate flash-off: 5 min - 10 min
final flash-off: 20 min - 30 min



Clearcoat

VOC compliant

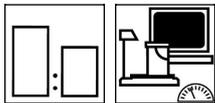
This product mix is not VOC compliant.

Stadox Basecoat

Products

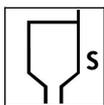
Stadox Basecoat

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.

MSB 10-20	Fast basecoat thinner suitable for Micro Repair, spot and panel repairs. Recommended for cooler application conditions e.g. 10-20°C.
MSB 15-25	Medium basecoat thinner suitable for panel and multi panel repairs. Recommended for application temperature of 15-25°C.
MSB 25-35	Medium-slow basecoat thinner suitable for medium to large size repairs. Recommended also for warm conditions e.g. 25-35°C.
MSB 35-40	Slow basecoat thinner suitable for medium to large size repairs. Recommended for use in hot climates e.g. 30-40°C.
Stadox Basecoat Colorless	Stadox Basecoat Colorless is ideally suited as undercoat when blending in critical metallic or pearl colors, as it neutralizes the substrate and supports the effect particles alignment.



DIN 4: 18 - 22 s at 20°C



15 - 25 µm Effect colours
20 - 40 µm Solid colours

Theoretical coverage

110 - 120 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.



Stadox Basecoat can be overcoated with itself within 24 hours, without intermediate sanding



Clean after use with a suitable solventbased cleaning thinner.

Stadox Basecoat

Remarks

- Material has to be at room temperature (18-25°C) before use.
 - New mixing toners/tints should be adequately stirred before using as part of a colour formulation.
 - 2K Hardened Basecoat is necessary for higher film thicknesses (>40µ) e.g. poor hiding colours, multitonning, underhood painting and 3-stage ground colours.
 - The masking of Stadox Basecoats is possible after 45-60 min/ 18-22°C or after oven drying. Hardened Stadox Basecoats should be masked only after oven drying.
 - If more than 30% of MIX 897 Superdeepblack are included in the formula add only 30% of Stadox MSB-Thinners as MIX 897 has a lower viscosity compared to other mixing toners. There will be a special hint also in the colortools.
 - Do not mix Stadox Basecoat Real Black with other Stadox Basecoats.
 - Any reduction or extension of final flash off times (20-30 min.) may change the colour shade for Stadox Basecoat Real Black.
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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 Stadox 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 Stadox product range, unless explicitly indicated otherwise.

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