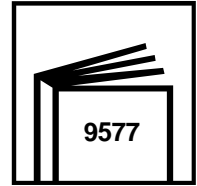


Standocryl[®] Clear PFC 20



Ordering Information:

5 Liter	Standocryl Clear PFC 20	020 16211
1 Liter	Standocryl Clear PFC 20	020 16217

Features:

- ✧ 2.1 Clear for VOC compliant paint systems
- ✧ Production repair clear
- ✧ Easy application with excellent flow and gloss
- ✧ Short bake cycle
- ✧ Low temperature bake or air dry
- ✧ One visit application

Working Process: 2:1 Mixing Ratio Clear	
Substrates:	
<ul style="list-style-type: none"> ✓ Standox Basecoats ✓ Standoblue Basecoats ✓ Through-hardened, sanded paintwork 	
	For substrate preparation information see Standex Painting System S1!
	2:1 with Standex PF Hardeners (PFH 15-25, PFH 25-30, PFH 30-35) potlife 4-6 hours /68°F (20°C) For U. S. National Rule; Standox PFC 20 can be mixed with Standox 2K Hardeners 3:2
	15% Standex PF Thinner (16215) or Standex PF Fast Dry Agent (16219) For U. S. National Rule; Standox PFC 20 can be mixed with Standox 2K Thinners 5-15%
	1.3 - 1.4 mm 1.5 coats = 2.0-2.4 mil (50-60 micron) Please refer to gun manufacturer and local legislation for proper spray pressure recommendations. Note: 1.5 coat process= one continuous application to achieve between 2.0- 2.4 mil.
	1.2 - 1.3 mm 1.5 coats = 2.0-2.4 mil (50-60 micron) Please refer to gun manufacturer and local legislation for proper spray pressure recommendations. Note: 1.5 coat process= one continuous application to achieve between 2.0- 2.4 mil.
	Flash off 3-5 min/68°F (20°C) when applying in 2 coats Allow 0-5 minutes prior to bake cycle
	Bake 20 min/130°F (55°C) panel temperature when using PF Thinner, bake 10 min/130°F (55°C) panel temperature when using PF Fast Dry Agent, or Air dry overnight/ 68°F (20°C)

Standocryl® Clear PFC 20

Important Technical Remarks:

- **Stadox 2K Plasticiser** may be added at 10-15% with **Standocryl Clear PFC 20**. Mix ratio is:

Standocryl Clear PFC 20 Plasticised		Mixing Stick, AS11-060-N.	
2	+10-15%	:1	+15%
Standocryl Clear PFC 20	2K Plasticiser	PF Hardener	PF Thinner

Flash off and drying times will be longer

- This clear may also be used in a 2-coat process. Allow 3-5 minute flash between coats.
- Do not use 2.1 Hardeners or 2.1 Thinners in this clear. Must use PFC components only.
- May be mixed 3:2 with 2K Hardeners and 5-15% 2K Thinner in US National Rule areas.
- When baking at 130°F (panel temperature) for 20 minutes, this clear can be polished after a 2-4 hour cool down at 68°F (20°C).
- When using **Stadox PF Fast Dry Agent**, bake time is reduced to 10 min/130°F (55°C) panel temperature.
- May be used as a blending clear with **Stadox Standocryl tinted midcoats**.

Mixing Table - with 2K Hardeners and 2K Thinners

	Pint (Cumulative) 5% Thinner	Pint (Cumulative) 10% Thinner	Pint (Cumulative) 15% Thinner	Quart (Cumulative) 5% Thinner	Quart (Cumulative) 10% Thinner	Quart (Cumulative) 15% Thinner
Standocryl® Clear PFC 20 16211 or 16217	289.6	276.5	264.5	579.3	553.0	528.9
2K Hardeners: 15080, 15013, 15978, 15935, or 16147	472.6	451.1	431.5	945.1	902.1	862.9
2K Thinners: 11182, 11573, 11484, 11921, or 16206	492.9	489.9	487.2	985.8	979.7	974.3

Mixing Table - Plasticised with 2K Hardeners and 2K Thinners

	Pint (Cumulative) 5% Thinner	Pint (Cumulative) 10% Thinner	Pint (Cumulative) 15% Thinner	Quart (Cumulative) 5% Thinner	Quart (Cumulative) 10% Thinner	Quart (Cumulative) 15% Thinner
Standocryl® Clear PFC 20 16211 or 16217	251.9	240.4	230.0	503.7	480.8	459.9
Stadox® 2K Plasticiser (15260) (15%)	290.7	277.5	265.4	581.4	555.0	530.9
2K Hardeners: 15080, 15013, 15978, 15935, or 16147	473.6	452.1	432.4	947.2	904.2	864.9
2K Thinners: 11182, 11573, 11484, 11921, or 16206	493.9	490.9	488.1	987.9	981.8	976.3

Important Legislative Remarks:

- Please see the appropriate VOC Wallchart for compliance for your area. The values depicted below are ready to spray.

VOC Category	VOC (ap/le)	Wt% Volatiles, Water & Exempts	Vol % Solids	Gallon Weight
Topcoat Clear Coat w/ PF Hardeners	166/239 g/l	49.3%, 0.001%, 34.4%	45.7%	9.3 lbs/gal
Elastomeric Clear Coat w/ PF Hardeners	152/235 g/l	53%, 0.001%, 39.7%	47.5%	9.5 lbs/gal
Topcoat Clear Coat w/ 2K Hardeners	391/454 g/l	53.7%, 0.002%, 16.1%	42.4%	8.68 lbs/gal
Elastomeric Clear Coat w/ 2K Hardeners	392/446 g/l	51.5%, 0.003%, 13.9%	44.2%	8.7 lbs/gal

- **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. Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates. 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.**
- Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.