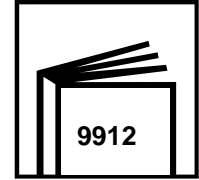


# Standex® Clearcoat Additives



## Ordering Information:

|           |                                     |           |
|-----------|-------------------------------------|-----------|
| 0.5 Liter | Standex Clearcoat Additive Blue     | 020 16255 |
| 0.5 Liter | Standex Clearcoat Additive Maroon   | 020 16256 |
| 0.5 Liter | Standex Clearcoat Additive Burgundy | 020 16257 |

## Features:

- ✧ **Current OEM codes:**
  - **Ford colors:** Z9 & R3
  - **Toyota colors:** 3T5 & 3T7
  - **Nissan colors:** NBA
- ✧ **Creating custom effect colors**

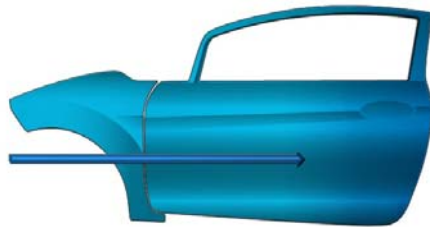
| Working Process: Mixing Ratio Clearcoat Additives  |  |
|--|--|
| <b>Substrates:</b> <ul style="list-style-type: none"> <li>✓ <b>Standex</b> Basecoats</li> <li>✓ <b>Standoblue</b> Basecoats</li> <li>✓ Through-hardened, sanded OEM paintwork</li> </ul> |  |
|  | For substrate preparation information see <b>Standex</b> Painting System S1.<br>Keep the surface for priming with Filler as small as possible.<br>Scuff all edges with gold scuff pad prior to sanding.<br>Sand surrounding blend areas with P1000-P1500 (wet or dry).<br>Final clean per <b>Standex</b> Painting System S1  |
|  | Add 1.0 gram of Standox Clearcoat Additive Blue (16255) to 100 grams of Standocryl 2K Clear.<br><br>or<br><br>Add 2.0 grams of Standox Clearcoat Additive Maroon (16256) to 100 grams of Standocryl 2K Clear.<br><br>or<br><br>Add 3.0 grams of Standox Clearcoat Additive Burgundy (16257) to 100 grams of Standocryl 2K Clear.<br><br><b>See mix table below for mixing tinted clearcoat (TC) with additive. See Standocryl 2K Clear TDS for tinted clearcoat activation ratio or use Axalta ColorNet® Color Retrieval System.</b> |
|  | <b>See Standocryl 2K Clear TDS for tinted clearcoat reduction.</b>   |
|  | 1.3 - 1.4 mm<br>1-2 coats as needed for color. Prepare a let-down panel to determine the number of coats needed to achieve color match. Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.<br><b>See Working Process below.</b>   |
|  | 1.2 - 1.3 mm<br>1-2 coats as needed for color. Prepare a let-down panel to determine the number of coats needed to achieve color match. Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.<br><b>See Working Process below.</b>   |

# Standocryl® Clearcoat Additives

## Working Process: Blending-in with Clearcoat Additives

- Painting: 1**
- Prepare let-down panel to verify color match and number of coats of tinted clear needed.
  - Apply **Standoblue** Color Blend for **Standoblue** or Basecoat Colorless for **Standox** basecoat to edge of blend panel with a closed coat. Apply following the process in **Standoblue** TDS S15 or **Standox** Basecoat TDS S6.
  - Mix tinted Standocryl 2K Clear with additive (TC) per Standocryl 2K Clear TDS or on scale using Axalta ColorNet® Color Retrieval System. Use two spray guns or two disposable cups to work effectively and efficiently.
  - Use the same Standocryl 2K Clear that is used for the tinted Standocryl 2K Clear with additive (TC) to complete the repair.
1. Blend tinted Standocryl 2K Clear with additive (TC). Apply the first coat of tinted Standocryl 2K Clear with additive (TC) onto the blended basecoat. Extend each coat until color match determined by let-down panel is achieved. Allow 2-5 minutes between coats. Do not extend the tinted Standocryl 2K Clear with additive (TC) to the end of the blend panel.
  2. Apply 1 thin, closed coat of normal Standocryl 2K Clear from the end of the repair panel back into the edge of the blended Standocryl 2K Clear with additive (TC). This will melt the blended Standocryl 2K Clear with additive (TC) overspray into a continuous film. If defect polishing is necessary, bake repair per the Standocryl 2K Clear TDS recommendations being used with additive. Allow panel to cool completely. Nib sand, apply 1.5 to 2 coats of Standocryl 2K Clear over entire repair panel. Bake per Standocryl 2K Clear TDS.

Step 1.



1. Apply tinted Standocryl 2K Clear with additive (TC) over blended basecoat. Blend each successive coat past the previous coat. Apply coats pre-determined by let-down panel. Allow 2-5 minutes flash between coats. Do not extend the tinted Standocryl 2K Clear with additive (TC) to the edge of the blend panel. Proceed to step 2.

Step 2.



2. Apply normal Standocryl 2K Clear from edge of blend panel back to edge of blended basecoat to melt the blended Standocryl 2K Clear with additive (TC) into a closed film. Apply with a closed coat. Do not extend over the entire blended Standocryl 2K Clear with additive (TC). If defect or nib sanding is necessary, bake per TDS, allow to cool. Correct defects. Apply 1.5 to 2 coats of clear over entire repair panel. Bake per clear TDS. Ford Z9 Standocryl 2K Clear with additive (TC) does not require but may be over coated with normal clear. Toyota 3T5 and 3T7, Ford R3, or Nissan NBA Standocryl 2K Clear with additive (TC) will require over coating with normal clear.

# Standocryl® Clearcoat Additives

## Important Technical Remarks:

- Prepare a let-down panel to determine the number of coats needed to achieve color match.
- Do not extend the tinted Standocryl 2K Clear with additive (TC) to the end of the blend panel or the color will be dark.
- Standox Clearcoat Additive Blue (16255), Standox Clearcoat Additive Maroon (16256), Standox Clearcoat Additive Burgundy (16257) should be added to the Standocryl 2K Clear prior to the addition of hardener and thinner.
- 15% **Standox** 2K Plasticiser (15260) may be added to the tinted Standocryl 2K Clear with additive (TC). **Standox** 2K Plasticiser must be mixed with the tinted Standocryl 2K Clear with additive (TC) prior to the addition of hardener and thinner. When adding 15% Plasticiser to 2K Clear with additive (TC), prepare a let-down panel to check for color accuracy.
- For a replacement panel where blending is not required, do not apply blending clearcoat. Apply basecoat, allow flash, and then apply number of coats of tinted Standocryl 2K Clear with additive (TC) determined by a let-down panel. Bake per Standocryl 2K Clear TDS.

| Mixing Table - with Clearcoat Additive |  |   |   |  |   |   |
|--|--|---|---|--|---|---|
| Standocryl®<br>2K<br>Clearcoats        | Standocryl®<br>2K<br>Clearcoats<br>by weight | Standox®<br>Clearcoat<br>Additive<br>Blue<br>(16255)<br>by weight | Standox®<br>Clearcoat<br>Additive<br>Maroon<br>(16256) by<br>weight | Standox®<br>Clearcoat<br>Additive<br>Burgundy<br>(16257)<br>by<br>weight | Mixing Ratio<br>per Standocryl®<br>2K Clear TDS | Important<br>Remarks  |
| Standocryl®<br>2K Clear 15-<br>60 PLUS | 100 grams                                    | 1 gram  | 2.0 grams   | 3.0 grams  | 2:1 + Up to 5%                                  | Complaint only<br>when tinted clear<br>is used over<br>waterborne<br>basecoat. With<br>2K Hardener and<br>2K Thinner. |
| Standocryl®<br>2K<br>Premium<br>Clear  | 100 grams                                    | 1 gram  | 2.0 grams   | 3.0 grams  | 2:1 + Up to 5%                                  | With 2K<br>Hardener and 2K<br>Thinner.  |
| Standocryl®<br>2K HS Clear             | 100 grams                                    | 1 gram  | 2.0 grams   | 3.0 grams  | 2:1 + 5%  | With 2K<br>Hardener and 2K<br>Thinner.  |
| Standocryl®<br>Clear PFC<br>20         | 100 grams                                    | 1 gram  | 2.0 grams   | 3.0 grams  | 3:2 + 5%  | With 2K<br>Hardener and 2K<br>Thinner.  |
| Standocryl®<br>Clear PFC<br>20         | 100 grams                                    | 1 gram  | 2.0 grams   | 3.0 grams  | 2:1 + 15%                                       | With PF<br>Hardener and PF<br>Thinner.  |
| Standocryl®<br>Clear PFC<br>30         | 100 grams                                    | 1 gram  | 2.0 grams   | 3.0 grams  | 2:1 + 5%  | With PF<br>Hardener and PF<br>Thinner.  |

**Mix Standox® Standocryl® 2K Clearcoat with additive prior to adding hardener and thinner.**

## Important Legislative Remarks:

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

Clear Coating (w/ 2K Hardeners)

Max. VOC (AP): 479 g/l; 4.0 lbs/gal

Max. VOC (LE): 479 g/l; 4.0 lbs/gal

Avg. Gallon Weight: 1001.7 g/l; 8.36 lbs/gal

Avg. Weight % Volatiles: 47.7 %

Avg. Weight % Water: 0.0%

Avg. Weight % Exempt Solvent: 0.0%

Avg. Volume % Water: 0.0%

Avg. Volume % Exempt Solvent: 0.0%

Theoretical Coverage: 752.4sq. ft @ 1 mil

Clear Coating (w/ Low VOC Hardeners)

Max. VOC (AP): 156 g/l; 1.3 lbs/gal

Max. VOC (LE): 240 g/l; 2.0 lbs/gal

Avg. Gallon Weight: 1148.4 g/l; 9.58 lbs/gal

Avg. Weight % Volatiles: 55.2%

Avg. Weight % Water: 0.0 %

Avg. Weight % Exempt Solvent: 41.6%

Avg. Volume % Water: 0.0%

Avg. Volume % Exempt Solvent: 36.2 %

Theoretical Coverage: 717.6 sq. ft @ 1 mil

- **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.**
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Author: IT Dept.  
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