

Standoblue Basecoat



Standoblue Basecoat is the latest generation basecoat technology. It offers superior colour matching and outstanding colour accuracy due to the use of specially selected pigments and the finest metallic gradations, regardless of individual application methods.

- Solid and effect colours.
- Application in a single spray process (One Visit Application).
- Can be hardened.
- High coverage.
- Suitable for all climatic conditions.
- VOC compliant basecoat system.
- Outstanding colour accuracy.
- Excellent for blending-in.

High quality, premium basecoat system.



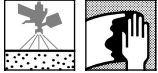
The Art of Refinishing.

Standoblue 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	Viscosity adjuster
Standard	Effect colours	100	20%
Standard	Solid colours	100	10%

Maximum 10% Standox Demineralized Water can be added in addition. Refer to Standoblue Climate Guide.

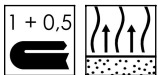


For optimum application properties, apply the basecoat immediately after addition of Standoblue Viscosity Adjuster Slow . Use within same working day. Colours should be stored without the addition of the Viscosity Adjuster.



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3 mm	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.3 mm	0.7 bar	atomisation pressure

see manufacturer's instructions



1 + 0.5
 Apply a closed coat by wetting the surface sufficiently to achieve 70-80% opacity in the wet film. This is followed by an effect coat with increased distance to the object with close overlaps into the still wet first layer. This final ½ (>50%) effect coat achieves the correct effect orientation, completes the hiding and provides the correct colour position.

flash-off until matt



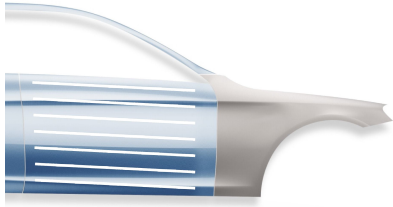
Clearcoat

VOC compliant

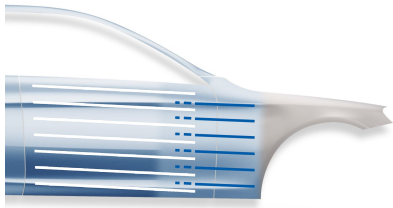
2004/42/IIIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

Standoblue Basecoat

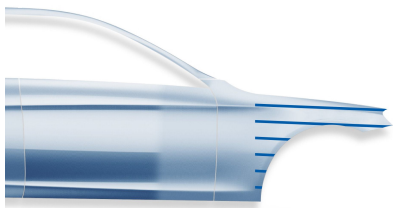
Standoblue blend-in guide 2-stage colours standard



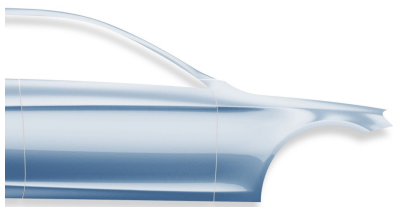
Apply Standoblue Color Blend / Color Blend Slow* to the surrounding fade out area or adjacent panels with thin closed coats.



Apply 1 coat of Standoblue Basecoat up to the edge of the Standoblue Color Blend and extend into adjacent area/panel. Follow by spraying an effect coat to blend-in to the wet Standoblue Color Blend.



Apply Standoblue Basecoat to remaining repaired area (filler) with normal 1.5 coat process. Spray pressure 1.5–2.0 bar.

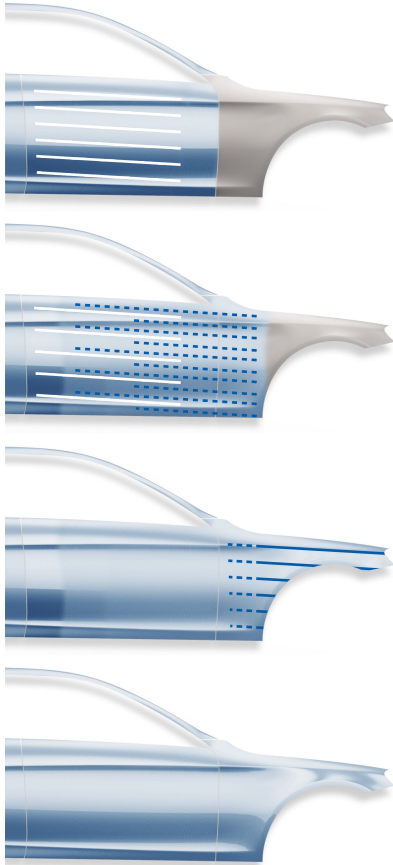


After flash off apply a Standocryl VOC clear.

*Standoblue Color Blend / Color Blend Slow is not recommended for dark colours.

Standoblu Basecoat

Standoblu blend-in guide 2-stage colours optional



Apply Standoblu Color Blend / Color Blend Slow to the surrounding fade out area or adjacent panels with thin closed coats. Do not allow Standoblu Color Blend to flash.

Blend-in the Standoblu Basecoat Colour in one "light"/"effect" coat to the furthest point. Blend-in a second "light"/"effect" coat of the Standoblu Basecoat Colour. Work inside the previous and towards the repaired panel. Keep distance to object while spraying. During the blending, ensure that there is overlap onto the repaired panel.

Finally apply the Standoblu Basecoat Colour in normal 1,5 coat process (one visit) to the new part or repaired area. Avoid spraying over the finished blending area.

Standocryl VOC Clear is applied to finish the repair.

*Standoblu Color Blend / Color Blend Slow is not recommended for dark colours.

Standoblue 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	Hardener	Viscosity adjuster
Standard	Effect colours	100		20%
2K Hardened	Effect colours	100	5%	20%
Standard	Solid colours	100		10%
2K Hardened	Solid colours	100	5%	10%
Color Blend		100	10%	-

All amounts are cumulative.

Maximum 10% Standox Demineralized Water can be added in addition. Refer to Standoblue Climate Guide.



For optimum application properties, apply the basecoat immediately after addition of Standoblue Hardener and Standoblue Viscosity Adjuster Slow.

Solid ground colours - 5%: 1 hr 30 min - 2 hr

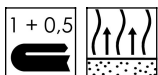
Effect ground colours - 5%: 45 min - 1 hr

Blender - 10%: 1 hr - 1 hr 30 min



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3 mm	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.3 mm	0.7 bar	atomisation pressure

see manufacturer's instructions



1.5 - 2 ground coats (2K Hardened)

flash-off until matt

1 + 0.5 effect/midcoat

flash-off until matt



	Bake	Blowing	Ambient
20 °C	-	-	15 min - 25 min
35 - 40 °C	-	8 min - 12 min	-
60 - 65 °C	10 min - 15 min	-	-



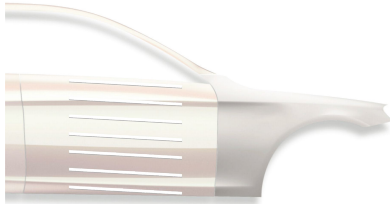
Clearcoat

VOC compliant

2004/42/IIIB(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.

Standoblue Basecoat

Standoblue blend-in guide 3-stage colours



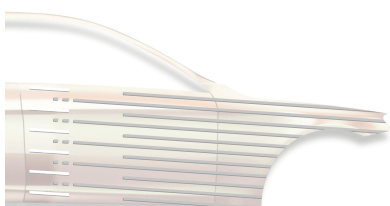
Apply a closed coat of hardened Standoblue Color Blend / Color Blend Slow (blender +10% Standoblue Hardener) to the adjacent blending areas, avoiding the extreme edges of the panel.



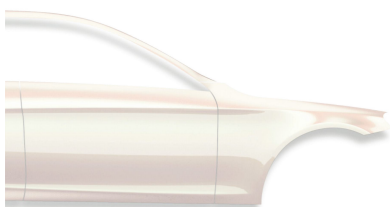
Apply the hardened Standoblue ground colour to the edge of the still wet Standoblue Color Blend / Color Blend Slow, and over the repaired surfaces. Refer to mixing details page for product adjustment and hardening ratios. Flash off and dry as described on previous page.



Apply a closed coat of unhardened Standoblue Color Blend / Color Blend Slow to adjacent blending areas.



Apply the 1st coat of Standoblue pearl effect colour up the edge of the still wet Standoblue Color Blend / Color Blend Slow. Working from out-to-in from the widest area, further coats should be applied inside the previous layer as needed to complete the repair and match the colour. All application is in wet-on-wet process. Flash-off and dry complete surface as described on previous page.



Apply a Standocryl VOC Clear to finish the repair.

Standoblue Basecoat

Product preparation - application Super High effect Aluminium Colors (containing MIX130)



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



Suitable substrates, undercoats and its preparation can be found in previous pages in this TDS.

- Apply a single layer of 2K Clearcoat on all repaired panels / surfaces

- After drying and cooling, sand the whole panel very carefully with:
 - machine sanding: P1000 – P1200 grade
 - hand sanding for edges and corners: P3000 grade

- For blend-in process, please refer to blend-in page for 2 stage colours



		Basecoat	Viscosity Adjuster Slow
Standard	Effect colours	100	50%

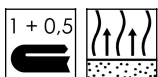


For optimum application properties, apply the basecoat immediately after addition of Standoblue Viscosity Adjuster Slow . Use within same working day. Colours should be stored without the addition of the Viscosity Adjuster.



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3 mm	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.3 mm	0.7 bar	atomisation pressure

see manufacturer's instructions



1 + 0.5
 Apply a closed coat by wetting the surface sufficiently to achieve 70-80% opacity in the wet film. This is followed by an effect coat with increased distance to the object with close overlaps into the still wet first layer.
 This final ½ (>50%) effect coat achieves the correct effect orientation, completes the hiding and provides the correct colour position.

flash-off until matt



Clearcoat
 Check if a specific clearcoat is required to meet car manufacturer approvals.

VOC compliant

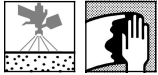
2004/42/IB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

Standoblue Basecoat

Product preparation - application with Standoblue Hardener



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	Viscosity adjuster
Xtreme Clearcoat	Effect colours	100	5%	20%
Xtreme Clearcoat	Solid colours	100	5%	10%
Underhood / interior	Solid colours	100	10%	10%
Underhood / interior	Effect colours	100	10%	20%
Color Blend		100	5%	-

Standoblue Basecoat has the ability to be hardened with Standoblue Hardener for use in multi-toning, 3-stage ground colors, underhood/interiors and for general application where the basecoat requires to be hardened. The table illustrates the main details, this can also be found in Standowin when preparing the colour ready for use. Standox Demineralized Water can be added for application in lower humidity and warmer climates.

All amounts are cumulative.

Maximum 10% Standox Demineralized Water can be added in addition. Refer to Standoblue Climate Guide.

For use of 3-stage colours under Xtreme Clear both ground coat & effect coat need to be activated according the above specifications.

For multi-toning every layer but the last one needs to be activated, except for use under Xtreme Clear all layers need to be activated.

When using Xtreme Clear, the Basecoat blender needs to be activated according the above specifications.



For optimum application properties, apply the basecoat immediately after addition of Standoblue Hardener and Standoblue Viscosity Adjuster Slow.

Solid colours: 5%: 1 hr 30 min - 2 hr

Solid colours: 10%: 45 min - 1 hr

Effect colours: 5%: 45 min - 1 hr

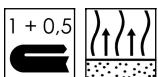
Effect colours: 10%: 30 min - 1 hr

Blender - 5%: 1 hr - 1 hr 30 min



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3 mm	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.3 mm	0.7 bar	atomisation pressure

see manufacturer's instructions



1 + 0.5

1 operation coat

1st: closed uniform coat

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

flash-off until flat before clearcoating



	Interior 10% hardener	Xtreme Clear 5% ambient/bake	Xtreme Clear 5% Blowing
20 °C	12 hr - 16 hr	15 min - 25 min	-
35 - 40 °C	-	-	8 min - 12 min
60 - 65 °C	15 min - 20 min	10 min - 15 min	-



Clearcoat

Clearcoat not needed for interior use

VOC compliant

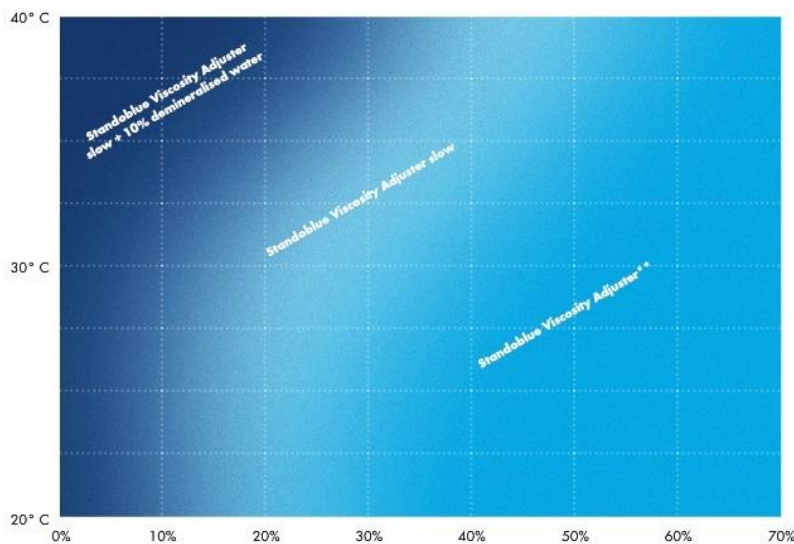
2004/42/IB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

Standoblue Basecoat

Climate guide

Use the climate guide to select the correct Standoblue Viscosity Adjuster. Repair size should also be considered, larger repairs may require a slower adjustment.

Refer to booth temperature on spray cycle, check relative humidity in booth with Hygrometer
Do not leave Hygrometer in booth during bake cycle



****30% Standoblue Viscosity Adjuster can be added when relative humidity is above 65%, only for Metallic and Pearl colours**

Standoblue Viscosity Adjuster:

Standard adjuster for small to medium repairs and for humidity between 30-70%

Standoblue Viscosity Adjuster Slow:

Slower adjuster for lower humidity below 30% and for larger repairs. Also well suited when high temperature and medium to low humidity are combined.

Will also help for 3-stage applications in low humidity conditions.

Standox Demineralized Water:

this can be added in very low humidity together with higher temperature conditions

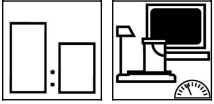
Will also help on large surface in lower humidity with/without higher temperature, especially for 3-stage applications

Standoblue Basecoat

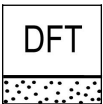
Products

Standoblue Basecoat

Product mix



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



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



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.

Standoblue Basecoat

Remarks

- Mixing machine should not exceed 2 x 15 minutes cycles in 24 hour period.
 - Material has to be at room temperature (18-25°C) before use.
 - New unopened cans of toners/tints should be adequately stirred before use.
 - Standoblue Basecoat has to be filtered through waterproof 125 µm quick sieves before application by cup system (e.g. SATA or 3M).
 - All tools and equipment used with this product must be approved for waterborne paint.
 - Flash-off time can be reduced by using air blowers, spray booth blower systems or increasing spray booth temperature.
 - Allow additional time for preheating up to panel temperature.
 - All stated drying and flash-off times are related to relative humidity and type of blowing equipment.
 - Best to be used within one working day after addition of the Standoblue Viscosity Adjuster.
 - Standoblue basecoat hardened and non hardened has to be overcoated with clearcoat within 72 hours.
 - Ready for use, non-activated, Standoblue Basecoat can be used within 6 months, but Viscosity adjuster must be added again in the same ratio before using. We advise to make a colour spray-out card prior to applying on the vehicle. Opacity may be affected by this 2nd addition of Viscosity Adjuster.
 - Recommended storage temperature at 15°C to 25°C (do not expose at temperatures below 5°C).
 - New unopened cans have shelf life from production date of:
 - Solid toners 48 months
 - Alu tints 24 months
 - Effect/pearl toners 36 months
 - Mix 190/191 24 months
 - Viscosity adjusters 24 months
 - Standoblue Hardener 24 months
 - Standoblue Color Blend 24 months
 - Mix 199 24 months
-

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.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.

