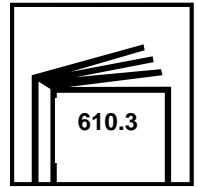


Standex® Basecoat – Specialty White Color Repair Process Example: Mazda 51K Rhodium White Premium



Ordering Information:

Please see the price list for ordering information



Features:

- ❖ Special U.S. National Rule Repair Procedure for Mazda Rhodium White Premium, 51K.

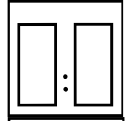
Working Process: MSB System

Substrates:

- ✓ Through-hardened, sanded paintwork
- ✓ **Standex** 1K/2K Fillers
- ✓ **Standex** 2K Sealers



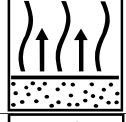
For substrate preparation information see **Standex** Painting System S1!



Mix **Standex** Basecoat Colorless with 0–10% **Standex** MSB Thinner BC 25-40 (75-95F).



Apply wet bed over entire panel.



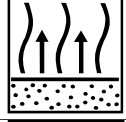
Flash off 10-15 min/ 68°F (20°C).



Ground Coat: 50% **Standex** MSB Thinner BC 15-25 (59-75F), **Standex** MSB Thinner BC 20-30 (70-85F), or **Standex** MSB Thinner BC 25-40 (75-90F)
(See important remarks regarding VOC compliance.)
12-19 s/DIN 4 mm/68°F (20°C)



Apply ground coat and blend ground coat color over repair area.
HVL P: 1.3 - 1.4 mm; Approved Transfer Efficiency: 1.2 - 1.3 mm
Apply 2-4 coats.
2 coats = 0.6-0.8 mil (15-21 micron) / 4 coats = 0.8-1.7 mil (20-44 micron)



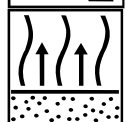
Flash off 5-10 min/ 68°F (20°C)
Flash off hand slick between coats
Approx 15-20 min/ 68°F (20°C) prior to applying midcoat



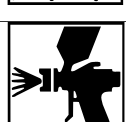
Midcoat: 200% **Standex** MSB Thinner BC 15-25 (59-75F), **Standex** MSB Thinner BC 20-30 (70-85F), or **Standex** MSB Thinner BC 25-40 (75-90F)
(See important remarks regarding VOC compliance.)
12-19 s/DIN 4 mm/68°F (20°C)



Apply mid coat color to panel and blend as necessary.
HVL P: 1.3 - 1.4 mm; Approved Transfer Efficiency: 1.2 - 1.3 mm
✓ Lower atomizing air (20 psi in a compliant, 13 psi in a low-pressure HVLP gun).
✓ Apply 3 to 4 uniform non-wetted drop coats, tapering each coat past the previous.



Flash off each coat completely.
5-10 min/ 68°F (20°C)
Final flash off
10-15 min /68°F (20°C)



Topcoat with **Standex Standocryl** PFC 20 (16211 or 16217), PFC 30 (16216), or PFC Air Dry Clear (16218). See TDS 9577, 9578, or 9502 for mix recommendations with either 2K or PF Hardeners.

Standex[®] Basecoat – Specialty White Color Repair Process Example: Mazda 51K Rhodium White Premium

Important Technical Remarks:

- Do not use Standox MSB Thinner BC 30-45 (>90°F).
- For OEM Approvals and for film thickness above 1.6 mil (40 micron) (multi-stage systems), mix with 15% Standox 2K Hardeners. Thin 30-40% with Standox MSB Thinners. Allow longer flash off times. Potlife 8 hours @ 68°F (20°C).
- Hardened Basecoat should be overcoated within 8 hours @ 68°F (20°C) for maximum adhesion.
- Any orange peel or dirt nibs that are not sanded out of the ground coat may show up in the final finish. Blend areas may show scratches that are not P3000 or finer.
- Always perform a sprayout of the Basecoat with the Clearcoat to verify the color match prior to the application and to confirm required number of drop coats.
- **Apply midcoat using uniform non-wetted drop coats. Do not over apply drop coats, wetting will create sparkle and mottle.**
- **Prior to applying midcoat check for fan uniformity, adjust fan pattern and air pressure as needed.**
- **Complete flash between mist coats is critical.**
- Verify BC/CC VOC Compliance before use. Refer to **Standex** VOC Wallcharts and local legislation.

Important Legislative Remarks:

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

All Values Ready To Spray

Max VOC (LE): 621.7 g/L (5.2 lbs./gal)

Max VOC (AP): 577.5 g/L (4.8 lbs./gal)

Avg. Gal. Wt: 8.38 lbs./gal

Avg. Wt.% Volatiles: 66.2%

Avg. Wt.% Exempt Solvent: 8.6%

Avg. Wt.% Water: 0.1%

Avg. Vol.% Exempt solvent: 7.1%

Avg. Vol.% Water: 0.1%

Flash Point: See SDS

Theoretical Coverage: 432 Sq Ft/Gal at 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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