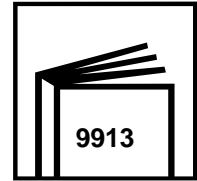


# Standex® 2K Transparent Color Repair Procedure:



Ordering Information:		
0.5 Liter	Standex Additive KA679 Bright Red	020 16679
0.5 Liter	Standex Additive Blue	020 16255
0.5 Liter	Standex Additive Maroon	020 16256
0.5 Liter	Standex Additive Magenta	020 16257
0.25 Liter	Standex Additive KA684 Amethyst	020 16684

## Features:

- ✧ **Current OEM codes:**
  - **Ford colors:** Z9 & R3
  - **Toyota colors:** 3T5 & 3T7
  - **Nissan colors:** NBA
  - **Mazda color:** 46V
- ✧ **Creating custom effect colors**

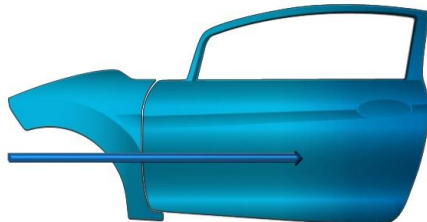
Working Process: Mixing Ratio Standox 2K Transparent Color (TC)	
<b>Substrates:</b>	
<ul style="list-style-type: none"> <li>✓ <b>Standex Basecoats</b></li> <li>✓ <b>Standoblue Basecoats</b></li> </ul>	
	For substrate preparation information see <b>Standex</b> Painting System S1. Keep the surface for priming with Filler as small as possible. Scuff all edges with gold scuff pad prior to sanding. Sand surrounding blend areas with P1000-P1500 (wet or dry). Final clean per <b>Standex</b> Painting System S1
	<b>Use Axalta ColorNet® Color Retrieval System for mixing Standox 2K Transparent Color (TC).</b>
	<b>Use Axalta ColorNet® Color Retrieval System for Standox 2K Transparent Color (TC) reduction instructions.</b>
	1.3 - 1.4 mm 1-4 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. <b>See Working Process below.</b>
	1.2 - 1.3 mm 1-4 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. <b>See Working Process below.</b>

# Standex® 2K Transparent Color Repair Procedure:

## Working Process: Blending-in with Standox 2K Transparent Color

- Painting: 1**
- Prepare let-down panel to verify color match and number of coats of **Standex 2K Transparent Color** needed.
  - Apply **Standoblue** Color Blend for **Standoblue** or Basecoat Colorless for **Standex** basecoat to edge of blend panel with a closed coat. Apply following the process in **Standoblue** TDS S15 or **Standex** Basecoat TDS S6.
  - Mix **Standex 2K Transparent Color (TC)** on scale using Axalta ColorNet® Color Retrieval System. Use two spray guns or two disposable cups to work effectively and efficiently.
1. Blend **Standex 2K Transparent Color (TC)**. Apply the first coat of **Standex 2K Transparent Color (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 **Standex 2K Transparent Color (TC)** to the end of the blend panel.
  2. Apply 1 thin, closed coat of **Standocryl 2K Clear** from the end of the repair panel back into the edge of the blended **Standex 2K Transparent Color (TC)**. This will melt the blended **Standex 2K Transparent Color (TC)** overspray into a continuous film. Bake **Standex 2K Transparent Color (TC)**. Allow panel to cool completely. Nib sand as needed and then apply 1.5 to 2 coats of **Standocryl 2K Clear** over entire repair panel. Bake per **Standocryl 2K Clear** TDS.

Step 1.



Step 2.



## Important Technical Remarks:

- Prepare a let-down panel to determine the number of coats needed to achieve color match.
- Do not extend the **Standex 2K Transparent Color (TC)** to the end of the blend panel or the color will be dark.
- Mix **Standex 2K Transparent Color** prior to adding hardener and thinner.
- **Standex 2K Plasticiser (15260)** may be added to the **Standex 2K Transparent Color (TC)**. **Standex 2K Plasticiser** must be mixed with the **Standex 2K Transparent Color (TC)** prior to the addition of hardener and thinner. When adding Plasticiser to **Standex 2K Transparent Color (TC)**, prepare a let-down panel to check for color accuracy.
- **Standex** Fast Dry Additive or **Standex** PF Fast Dry Agent can be used in place of **Standex 2K Thinner** or **Standex** PF Thinner in temperatures up to 80°F/27°C.
- 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 **Standex 2K Transparent Color (TC)** determined by a let-down panel. Bake prior to topcoating with **Standocryl 2K Clear**.

# Stadox<sup>®</sup> 2K Transparent Color Repair Procedure:

## Important Legislative Remarks:

All Values Ready To Spray

Max VOC (LE): 630g/L (5.2 lbs./gal)

Max VOC (AP): 630 g/L (5.2 lbs./gal)

Avg. Gal. Wt: 8.34 lbs./gal

Avg. Wt.% Volatiles: 50.8%

Avg. Wt.% Exempt Solvent: 0%

Avg. Wt.% Water: 0%

Avg. Vol.% Exempt solvent: 0%

Avg. Vol.% Water: 0%

Flash Point: See SDS

Theoretical Coverage: 711.76 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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