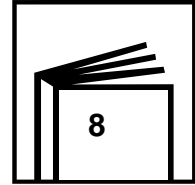


Standex® Charts & Systems

Blending-in and Polishing of 2K Clears



Working Process: Blending-in and Polishing of 2K Clear	
Pretreatment/ Cleaning:	For substrate preparation information, see Standex Painting System S1. Sand the fade out-blend area carefully with a fine, dual action sander and P3000/P4000 (3M Trizact or Abralon) and a soft interface pad. 6 inch disk (150 mm, optional for small areas with 3-inch disk).
Painting:	<ul style="list-style-type: none"> Mix Standocryl® 2K Clear according to the appropriate TDS. Apply mixed clear over Basecoat repair area (1 or 2 passes depending on the area).
Fading Out:	<ul style="list-style-type: none"> Spray repair/blend areas with Standocryl® 2K Clears. Tapering each coat. Final Blend: Wet blend edge with light coats of 2K Standex Smart Blend Plus until smooth. Blending-in with 2K Clearcoats and 2K Standocryl is not an approved OEM repair, nor is it covered under the Standex Lifetime Warranty. All warranty repairs require that clearcoat be applied to a suitable break line, i.e., edge to edge.
Drying:	<ul style="list-style-type: none"> Bake 30-35 minutes @ 140-150°F (60-65°C) panel temperature. If polishing the same day, follow by IR (short wave) for at least 15 minutes @ 100%.
Polishing a Blend Area	Removing a Defect
Sand with 3M Trizact P3000 or Mirka Abralon P3000/P4000 over the overspray blend area. Defects may be removed in the solid clearcoat area with P2000 and then followed by Trizact P3000 or Mirka Abralon P3000/P4000.	Remove defect with P1500 and, re-sand area with DA and 3M Trizact P3000.
Farécla	3M
Stage 1: Polish with G4 or Smart Repair & white G mop at low speed <1000 rpm until small amount of residue is visible.	Stage 1: Compound with Finesse-It™ SRC Finishing Material (PN 05927) with wool pad (PN 05703 or 5719). Clean surface and wipe residue and lint with a detailing cloth (PN 06016). If scratches are still visible, repeat stage 1.
Stage 2: Increase speed to approx. 1800-2000 rpm to remove remaining residue & check to see if scratches are removed. Repeat Stage 1 as necessary. If scratches persist, change to a lambs wool mop.	Stage 2: Polish with Finesse-It™ SRC Finishing Material (PN 05927) with black foam pad (PN 5725 or PN 5738). Wipe off residue with Detailing Cloth (PN 06016).
Stage 3: Change to black finishing pad and polish with G4 or Smart Repair at high speed until high gloss is achieved.	Stage 3: Apply Perfect-It 3000 Ultrafin SE to eliminate swirl marks.
Stage 4: Finish with Black top hand glaze to remove any smears or haze.	Stage 4: Optional-Apply Perfect-It™ 3000 Final Glaze (PN 6066) to protect the painted surface.

Important Technical Remarks:

- It is best to polish the next day! For the same day, polish only after proper bake and IR short-wave (100%) for 15 min and cool down for 60 min.
- Note: Other compounds are offered by 3M, Farécla and Meguiar's. These are only examples that have been tested by **Standex** and are not exclusively recommended.

Important Legislative Remarks:

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