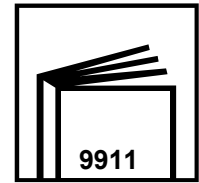


# Standocryl® Specialty Midcoats



## Ordering Information:

1 Liter	Standocryl 2K Crystal Midcoat	020 16240
1 Liter	Standocryl 2K Clear Red Midcoat	020 16241
1 Liter	Standocryl 2K Clear Blue Midcoat	020 16242
5 Liter	Standocryl Clear PFC 20	020 16211
1 Liter	Standocryl Clear PFC 20	020 16217
1 Liter	Standocryl 2K Premium Clear	020 16252

## Features:

- ✧ **Current OEM codes**
  - **Ford colors:** RR, RZ and U6
  - **Mazda color:** 41V
  - **Fiat color:** PWT
  - **Kia color:** BEG
  - **Tesla color:** PPSR
  - **Fisker colors:** B1/BC, N1/NB, S2/ SC, S3/ SD, and SB
  - **Lexus color:** 8X1
- ✧ **Creating custom effect colors**

Working Process:	
Regulated Areas: 2:1 Mixing Ratio Midcoat; U.S. National Rule: 3:2 Mixing Ratio Midcoat	
<b>Substrates:</b>	
<ul style="list-style-type: none"> <li>✓ Standox Basecoats</li> <li>✓ Standoblue Basecoats</li> <li>✓ Through-hardened, sanded paintwork</li> </ul>	
	<p>For substrate preparation information see <b>Standex</b> Painting System S1!                      Keep the surface for priming with Filler as small as possible.                      Sand surrounding blend areas with P1000-P1500 (wet or dry).                      Scuff all edges with gold scuff pad prior to sanding.                      Final clean per <b>Standex</b> Painting System S1.</p>
	<p>In regulated areas, 2:1 with PF Hardeners (16212, 16213, 16214)                      For U.S. National Rule 3:2 with 2K Hardeners                      potlife 1 hour /70°F (21°C)  <b>See mix table below.</b></p>
	<p>15% <b>Standex</b> PF Thinner (16215) 5-15% 2K Thinners for U.S. National Rule  <b>See mix table below.</b></p>
	<p>1.3 - 1.4 mm                      1-3 coats as needed for color                      Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.  <b>See Working Process below.</b></p>
	<p>1.2 - 1.3 mm                      1-3 coats as needed for color                      Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.  <b>See Working Process below.</b></p>

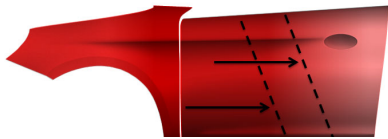
# Standocryl® Specialty Midcoats

## Working Process: Blending-in with 2K Specialty Midcoats

### Painting:

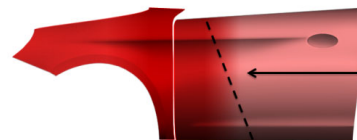
- Prepare let-down panel to verify color match and number of coats of midcoat needed.
  - Apply **Standoblue** Color Blend for **Standoblue** or Basecoat Colorless for **Standox** basecoat to edge of blend panel with a closed coat. Apply Basecoat following the process in either the **Standoblue** TDS S15 or **Standox** Basecoat TDS S6.
  - Mix Standocryl® Specialty Midcoat and **Standox** PFC 20 Clear or **Standox** 2K Premium Clear according to TDS. Use two spray guns or two disposable cups to work effectively and efficiently.
1. Apply the first coat of Standocryl® Specialty Midcoat over the blended basecoat. Extend each coat until color match determined by let-down panel is achieved. Flash off 2 - 5 min/68°F (20°C) between coats. Do not extend the Standocryl® Specialty Midcoat to the end of the blend panel.
  2. Apply PFC 20 Clear or 2K Premium Clear (U.S. National Rule) in a thin closed coat. Apply clear from the end of blend panel to the edge of the blended Standocryl® Specialty Midcoat. Use this application to melt in the overspray transition of the Standocryl® Specialty Midcoat.
  3. Bake blended Standocryl® Specialty Midcoat and PFC 20 Clear or 2K Premium Clear for 15 minutes @ 130°F (55°C). Allow to cool before applying a **Standox** 2K Standocryl® Clearcoat to entire repair panel.
  4. Apply 1.5 coats of **Standox** 2K Standocryl® Clearcoat to complete the repair process.

1.



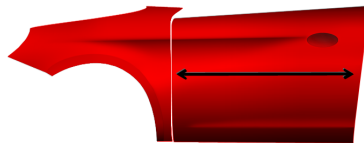
Apply Standocryl® Specialty Midcoat over basecoat. Blend each successive coat past the previous coat. Apply coats pre-determined by let-down panel. Do not extend the midcoat clear to edge of blend panel. Allow 2-5 minutes flash between coats.

2.



Apply PFC 20 Clear or 2K Premium Clear from edge of blend panel back to edge of blended Standocryl® Specialty Midcoat. To melt the blended midcoat into a closed film, apply with a thin, closed coat. Do not extend over the entire blended midcoat. Bake 15 minutes @ 130°F (55°C). Allow to cool.

3.



Complete repair by applying a **Standox** 2K Standocryl® Clear to the repair panel using a 1.5 coat application. Bake per clear TDS.

# Standocryl® Specialty Midcoats

## Important Technical Remarks:

- Prepare a letdown panel to determine the number of coats needed to achieve color match.
- Do not extend the Standocryl® Specialty Midcoat to the end of the blend panel or the color will be dark.
- **Standex** 2K Standocryl® Clearcoat must be applied over 2K Crystal Midcoat, 2K Clear Red Midcoat, or 2K Clear Blue Midcoat.
- 15% **Standex** 2K Plasticiser (15260) may be added to both the Standocryl® Specialty Midcoat and the **Standex** PFC 20 Clear or **Standex** 2K Premium Clear. **Standex** 2K Plasticiser must be mixed with the Standocryl® Specialty Midcoat and PFC 20 Clear or 2K Premium Clear prior to the addition of hardener and thinner. Note: If **Standex** 2K Plasticiser is added to the Standocryl® Specialty Midcoat, it should also be added in the same amount to the PFC 20 Clear or 2K Premium Clear and the final clear coat.
- For a replacement panel where blending is not required, do not apply blending clearcoat. Apply basecoat, allow to flash, and then apply coats of Standocryl® Specialty Midcoat determined by a let-down panel. Bake 15 minutes @130°F (55°C). Allow repair panel(s) to cool down and recoat with a **Standex** 2K Standocryl® Clearcoat.

Mixing Table - with 2K Hardeners and 2K Thinners						
	Pint (Cumulative) 5% Thinner	Pint (Cumulative) 10% Thinner	Pint (Cumulative) 15% Thinner	Quart (Cumulative) 5% Thinner	Quart (Cumulative) 10% Thinner	Quart (Cumulative) 15% Thinner
Standocryl® 2K Crystal Midcoat (16240), Standocryl® 2K Clear Red Midcoat (16241), Standocryl® 2K Clear Blue Midcoat (16242), or Standocryl® Clear PFC 20 (16211 or 16217)	289.6	276.5	264.5	579.3	553.0	528.9
2K Hardeners: 15080, 15013, 15978, 15935, or 16147	472.6	451.1	431.5	945.1	902.1	862.9
2K Thinners: 11182, 11573, 11484, 11921, or 16206	492.9	489.9	487.2	985.8	979.7	974.3

Mixing Table - Plasticised with 2K Hardeners and 2K Thinners						
	Pint (Cumulative) 5% Thinner	Pint (Cumulative) 10% Thinner	Pint (Cumulative) 15% Thinner	Quart (Cumulative) 5% Thinner	Quart (Cumulative) 10% Thinner	Quart (Cumulative) 15% Thinner
Standocryl® 2K Crystal Midcoat (16240), Standocryl® 2K Clear Red Midcoat (16241), Standocryl® 2K Clear Blue Midcoat (16242), or Standocryl® Clear PFC 20 (16211 or 16217)	251.9	240.4	230.0	503.7	480.8	530.9
<b>Standex</b> ® 2K Plasticiser (15260) (15%)	290.7	277.5	265.4	581.4	555.0	530.9
2K Hardeners: 15080, 15013, 15978, 15935, or 16147	473.6	452.1	432.4	947.2	904.2	864.9
2K Thinners: 11182, 11573, 11484, 11921, or 16206	493.9	490.9	488.1	987.9	981.8	976.3

## Important Legislative Remarks:

Please see the appropriate VOC Wallchart for compliance for your area.

All Values Ready To Spray

Max VOC (LE): 473.7 g/L (4.0 lbs./gal)

Max VOC (AP): 417.8 g/L (3.5 lbs./gal)

Avg. Gal. Wt: 8.65 lbs./gal

Avg. Wt.% Volatiles: 54.46%

Avg. Wt.% Exempt Solvent: 14.06%

Avg. Wt.% Water: 0.001%

Avg. Vol.% Exempt solvent: 11.83%

Avg. Vol.% Water: 0.001%

Flash Point: See SDS

Theoretical Coverage: 664.1 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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