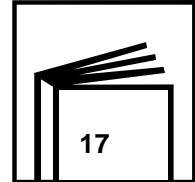


Standex[®] Plastic Painting Systems

Painting Primed Replacement Bumpers

BAAQMD - Rule 45



Pretreatment / Cleaning Option 1	Pretreatment / Cleaning Option 2								
<ul style="list-style-type: none"> If primer fails a solvent test: Thoroughly scuff and de-gloss bumper with a gold scuff pad and Standoflex[®] Low VOC Plastic Cleaner (16010). Avoid break-throughs. 	<ul style="list-style-type: none"> If primer does not fail a solvent test: Thoroughly scuff and de-gloss the bumper with a red or gray scuff pad or appropriate grit sand paper. Clean with Standohyd[®] Cleaner (16176), Standex VOC Cleaner 25 (16178) or Standex Silicone Remover (11654) (refilled in a hand-held spray bottle). 								
Painting Option 1 – Wet-on-Wet	Painting Option 2 – Wet-on-Wet								
<ul style="list-style-type: none"> Mix Standoflex 2K Plastic Primer Surfacer (11816/16192) 1:1 with Standoflex 2K Plastic Hardener (11824). Apply 2 coats. Flash off for 20 minutes at 68°F (20°C). Flash-off 30 minutes when overcoating with Standoblue Basecoat. 	<ul style="list-style-type: none"> Mix Standex PF Sealer (16222/16223) 4+15%:1+30%. <table border="1" data-bbox="771 766 1469 913"> <tr> <td>4 Parts</td> <td>Standex PF Sealer</td> </tr> <tr> <td>15%</td> <td>Standex 2K Plasticiser</td> </tr> <tr> <td>1 Part</td> <td>Standex PF Hardener</td> </tr> <tr> <td>30%</td> <td>Standex Reaction Agent</td> </tr> </table> Apply 1-1.5 coats (1.0 mil). Flash-off hand-slick minimum 20 minutes to maximum 40 minutes at 68°F (20°C). 	4 Parts	Standex PF Sealer	15%	Standex 2K Plasticiser	1 Part	Standex PF Hardener	30%	Standex Reaction Agent
4 Parts	Standex PF Sealer								
15%	Standex 2K Plasticiser								
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30%	Standex Reaction Agent								
<ul style="list-style-type: none"> Basecoat/Clearcoat: Apply Standex Basecoat or Standoblue Basecoat. Mix Standex 2K Clear with 15% 2K Plasticiser (15260). Then, mix according to the appropriate TDS. <p>Note: Up to 30% Standex 2K Plasticiser may be added for extremely flexible plastic parts.</p>									

Important Technical Remarks:

- Allow six weeks to pass before cleaning the finished part with a high-pressure washer.
- Addition of 15% Hardener to **Standex** Basecoat (solvent) will improve chip performance on plastic parts.

Important Legislative Remarks:

- 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. 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.**
- Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.