Standoblue® Basecoat

GENERAL

DESCRIPTION

A waterborne basecoat that delivers excellent coverage, outstanding color accuracy and rapid dry times, all in a one visit application.

FEATURES

Excellent for coverage and blending
Outstanding color accuracy
One visit application
May be hardened
Suitable for all climate conditions

The products referenced herein may not be available for sale in your market. Please consult your distributor for product availability.

MIXING

COMPONENTS

Standoblue® Basecoat
Standoblue® Viscosity Adjuster Normal, 19302
Standoblue® Viscosity Adjuster Slow / Low Humidity, 19303
Standoblue® Viscosity Adjuster High Humidity, 19304
Standoblue® Hardener, 17400
Standox® VE Water, 80188

COMPONENT SHELF LIFE (20°C/68°F)

Products	Packages	Shelf Life
Standoblue® Solid Mixing Colors	0.5-1 Liter	4 years
Standoblue® Mix Copper, Mix 162	0.5 Liter	2 years
Standoblue® Mix 180 Fac Pac Deep Black	1.0 Liter	2 years
Standoblue® Pearl Mixing Colors	0.5 Liter	3 years
Standoblue® Aluminum Metallic Mixing Colors	0.5-1 Liter	2 years
Standoblue® Mix 190 Special Additive	3.5 Liter	2 years
Standoblue® Mix 191Tranparent	3.5 Liter	2 years
Standoblue® Viscosity Adjuster Normal, 19302	3.5 Liter	2 years
Standoblue® Viscosity Adjuster Slow, 19303	3.5 Liter	2 years
Standoblue® Viscosity Adjuster High Humidity, 19304	3.5 Liter	2 years
Standox® Color Blend, 19310	3.5 Liter	2 years
Standox® Color Blend Slow, 19311	3.5 Liter	2 years
Standox® Color Blend Additive, 18316	1.0 Liter	5 years
Standoblue® Hardener, 17400	0.5 Liter	2 years
Standoblue® Special Effect LUT	0.5 Liter	2 years
Standox® VE Water, 80188	5.0 liter	3 years

- Shelf life is a guide and products may be used beyond suggested shelf life
- Mixed colors (With no Viscosity Adjuster) may be stored for 6 months in the proper container

MIX RATIO

Prior to placing on mix machine shake Standoblue® Mix 151 for a minimum of 10 minutes and all other solid toners shake 2-3 minutes. Pearls and metallic tints do not require shaking. Run mix machine twice daily for 2 minutes. Stir Standoblue® Basecoat and Standoblue® Hardener before addition of Standoblue® Viscosity Adjuster. Hand shake Viscosity Adjuster prior to adding to basecoat. Do not put mixed colors on mechanical shaker.

Solid Colors	**Volume**
Standoblue® Basecoat	1
Viscosity Adjuster	10-20%

Effect Colors	**Volume**
Standoblue® Basecoat	1
Viscosity Adjuster	20-30%

Effect Blending	**Volume**
Standoblue® Basecoat	4
Standox® Color Blend	1
Viscosity Adjuster	20-30%

Multi-Stage / Two-Toning – Solid Colors	**Volume**
Standoblue® Basecoat	1
Standoblue® Hardener	5%
Viscosity Adjuster	10-20%

Multi-Stage / Two-Toning – Effect Colors	**Volume**
Standoblue® Basecoat	1
Standoblue® Hardener	5%
Viscosity Adjuster	20-30%

POTLIFE

Metallic colors must be used within 4 hours after addition of Standoblue® Viscosity Adjuster. They may be re-adjusted one additional time. With solids and pearls, there is no need to readjust following the addition of viscosity adjuster. Standoblue® that has not been adjusted may be stored up to 6 months in a sealed and properly labeled Standox mix cup or approved container.

Pot life with the addition of Standoblue® Hardener: 45 minutes @ 20º C / 68º F

APPLICATION

SUBSTRATES

Through-hardened, sanded paintwork
Standox® 2K Fillers
Standoflex® 2K Plastic Primer Surfacer
Standox® 2K Sealers
Standox® 1K Waterborne Primer Surfacer

For substrate preparation information see Standox® Painting System S1!

GUN SETUP

HVLP designed for waterborne application:	1.2-1.4 mm
Approved Transfer Efficiency:	1.1-1.4 mm

Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.

APPLICATION

- 1 closed coat to achieve 85% coverage followed by a closed effect coat with increased distance of 50%. Use full trigger and 70 - 85% overlap for all applications.
- Flash until completely matt. Flash off times can be reduced by the use of air jets, spray booth systems or infrared drying.
- In high humidity conditions use 10% additional Standoblue® Viscosity Adjuster High Humidity (20% solids, 30% effects), allow 45-90 second flash time between coats. Add 5-10% Standoblue® Viscosity Adjuster to Standoblue® Color Blend when using as a wet bed. Smaller fluid tip and increased gun distance will be beneficial as well.
- In extreme low humidity add up to 10% Standohyd® VE Water with 20% Viscosity Adjuster Slow/Low Humidity. In non-regulated markets up to 3% Standoblue® Color Blend Additive may be added. Apply Standoblue® Basecoat from bottom to top to help overspray melt-in. Use of a larger fluid tip will help.
- Please refer to charts for Viscosity Adjuster and Color Blend recommendations.

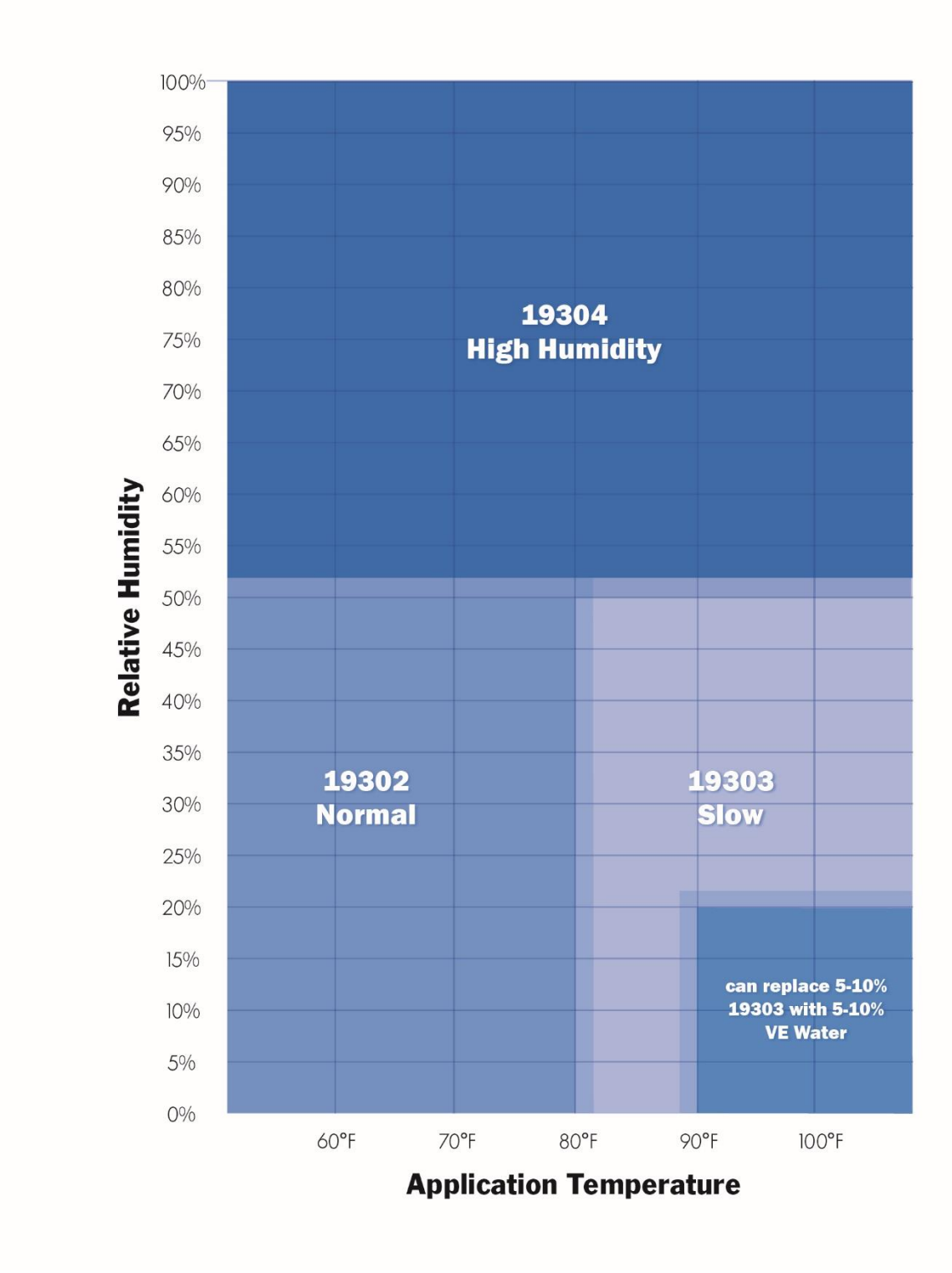
Interior and under hood application:

- For under hood and interior solid colors, add 10% Standoblue® Hardener to Standoblue® basecoat and stir thoroughly, then add 10-20% Standoblue® Viscosity Adjuster and stir thoroughly.
- For under hood and interior metallic colors, add 10% Standoblue® Hardener to Standoblue® basecoat and stir thoroughly, then add 20-30% Standoblue® Viscosity Adjuster and stir thoroughly.
- Please refer to charts for Viscosity Adjuster and Color Blend recommendations.

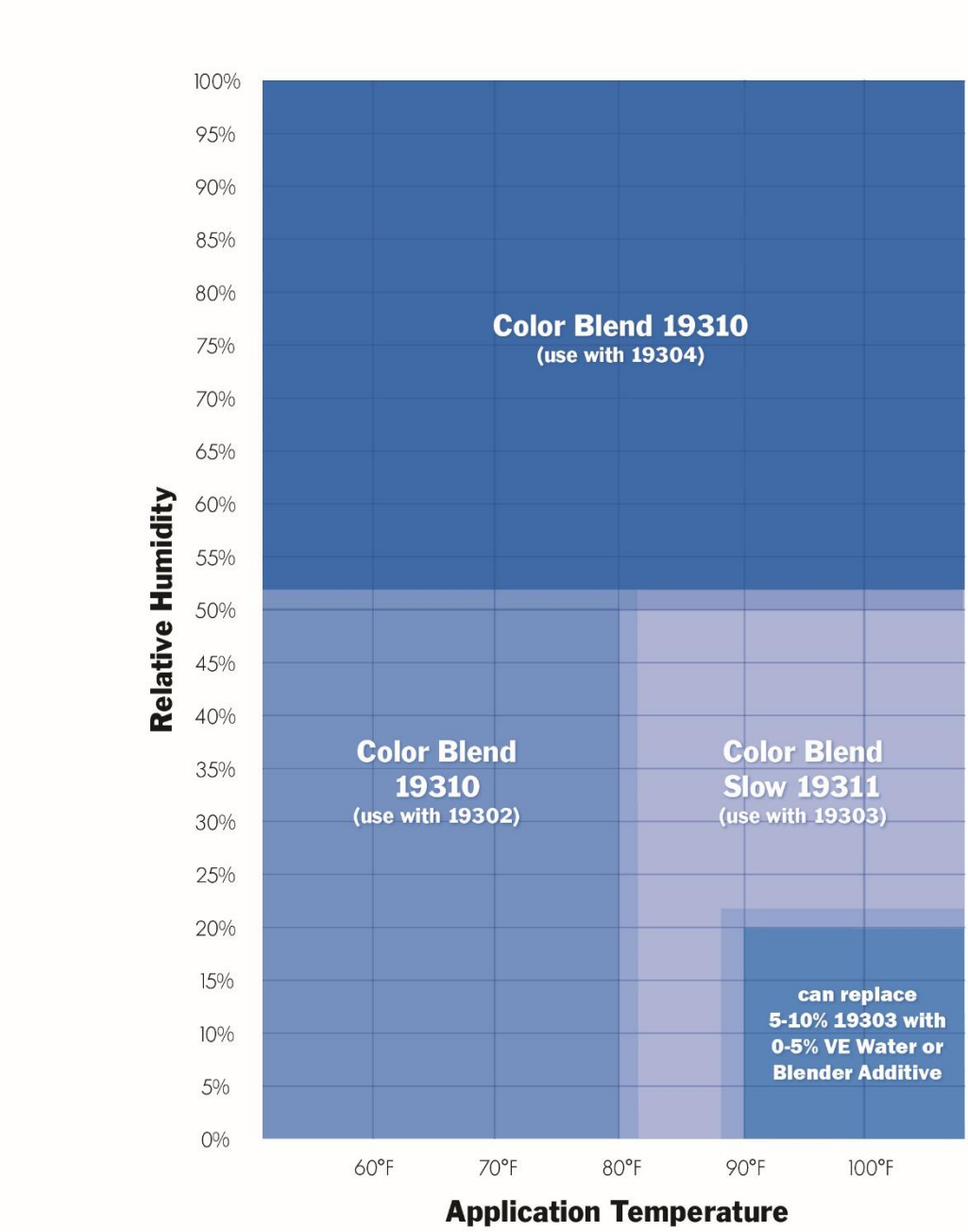
Multi-stage ground coats and two-toning

- For solid colors add 5% Standoblue® Hardener, stir thoroughly, then add 10-20% Standoblue® Viscosity Adjuster and stir thoroughly.
- For metallic colors, add 5% Standoblue® Hardener to Standoblue® basecoat and stir thoroughly, then add 20-30% Standoblue® Viscosity Adjuster and stir thoroughly.
- Bake the ground coat 10-15 minutes at 50-60°C / 120-140°F
- Please refer to charts for Viscosity Adjuster and Color Blend recommendations.

Viscosity Adjuster Selection Chart



Color Blend Selection Chart



DRY TIMES

FLASH
Final flash until completely matt. Flash times can be reduced by the use of air jets, spray booth systems or infrared drying.

BAKE OPTION
5-10 minutes at 115°F / 45°C. Allow to cool 5 minutes.

RECOAT WITH STANDOCRYL® 2K CLEARCOATS
Standoblue® Basecoat should be over-coated within 72 hours@ (20°C/68°F) for optimum results and to minimize surface contamination.

CLEANING
Dispose of paint and cleaning water properly. Do not dispose of cleaning water into drains.

PHYSICAL PROPERTIES

Coating Category: Color Coating (Solid w/ 20% Viscosity Adjuster)
Max. VOC (AP): 69 g/l; 0.6 lbs/gal
Max. VOC (LE): 236 g/l; 2.0 lbs/gal
Avg. Gallon Weight: 1086 g/l; 9.0 lbs/gal
Avg. Weight % Volatiles: 75.3%
Avg. Weight % Water 68.7%
Avg. Weight % Exempt Solvent: 0.9%
Avg. Volume % Water: 74.0%
Avg. Volume % Exempt Solvent: 1.2%

Coating Category: Color Coating (Effect w/ 30% Viscosity Adjuster)
Max. VOC (AP): 132 g/l; 1.1 lbs/gal
Max. VOC (LE): 416 g/l; 3.5 lbs/gal
Avg. Gallon Weight: 1031 g/l; 8.6 lbs/gal
Avg. Weight % Volatiles: 80.1%
Avg. Weight % Water 70.1%
Avg. Weight % Exempt Solvent: 1.2%
Avg. Volume % Water: 72.1%
Avg. Volume % Exempt Solvent: 1.5%

Coating Category: Color Coating (Multi- Stage 10% Hardener/ 20% Viscosity Adjuster)
Max. VOC (AP): 89 g/l; 0.7 lbs/gal
Max. VOC (LE): 259 g/l; 2.2 lbs/gal
Avg. Gallon Weight: 1086 g/l; 9.1 lbs/gal
Avg. Weight % Volatiles: 71.6%
Avg. Weight % Water: 63.7%
Avg. Weight % Exempt Solvent: 1.1%
Avg. Volume % Water: 68.3%
Avg. Volume % Exempt Solvent: 1.1%

Coating Category: Color Coating (Multi- Stage 10% Hardener/ 30% Viscosity Adjuster)
Max. VOC (AP): 146 g/l; 1.2 lbs/gal
Max. VOC (LE): 397 g/l; 3.3 lbs/gal
Avg. Gallon Weight: 1083 g/l; 8.6 lbs/gal
Avg. Weight % Volatiles: 76.3%
Avg. Weight % Water: 64.9%
Avg. Weight % Exempt Solvent: 1.1%
Avg. Volume % Water: 67.0%

Avg. Volume % Exempt Solvent: 1.1%

Coating Category: Uniform Finish Coating (Effect Blending 30% Viscosity Adjuster)
Max. VOC (AP): 360 g/l; 3.0 lbs/gal
Max. VOC (LE): 493 g/l; 4.1 lbs/gal
Avg. Gallon Weight: 1036.8 g/l; 8.6 lbs/gal
Avg. Weight % Volatiles: 61.4%
Avg. Weight % Water: 26.3%
Avg. Weight % Exempt Solvent: 0.3%
Avg. Volume % Water: 26.6%
Avg. Volume % Exempt Solvent: 0.4%

Theoretical Coverage:

	Rec. Film Build	Coverage at Recommended Film Build
Solids	1.0-1.5 mil	300-500 square feet per gallon
Pearls	0.5 – 0.8 mil	400-600 square feet per gallon
Metallics	0.4-0.6 mil	450-650 square feet per gallon

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

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.

Revised: August 2015