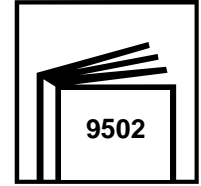


Standocryl® Clear PFC Air Dry


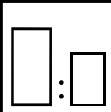





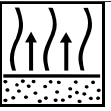
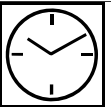


Ordering Information:

5 Liter	Standocryl Clear PFC Air Dry	020 16218
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Features:

- ✧ Production repair clear
- ✧ Easy application with excellent flow and gloss
- ✧ Air dry or short bake cycle
- ✧ Easily mixed with PF or 2K Hardeners and 2K Thinners for use in both regulated areas and the US National Rule

Working Process: Regulated Areas: 4:1 Clear System; US National Rule: 3:1 Clear System	
Substrates:	<ul style="list-style-type: none"> ✓ Standox Basecoats ✓ Standoblue Basecoats ✓ Through-hardened, sanded paintwork
	For substrate preparation information see Standox Painting System S1!
	4:1 with Standox PF Hardeners (PFH 15-25, PFH 25-30, PFH 30-35) potlife 1 hour /68°F (20°C)
	For U. S. National Rule, Standocryl Clear PFC Air Dry can be mixed with Standox 2K Hardeners 3:1
	20% Standox PF Thinner (16215) or Standox PF Fast Dry Agent (16219)
	For U. S. National Rule; Standocryl Clear PFC Air Dry can be mixed with Standox 2K Thinner or Standox 2K Fast Dry Additive (16169) 20%
	1.3 - 1.4 mm 2.0 coats = 2.0-2.4 mil (50-60 micron) Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.
	1.3 - 1.4 mm 2.0 coats = 2.0-2.4 mil (50-60 micron) Please refer to gun manufacturer and local legislation for proper spray pressure recommendations. Lower air pressure will result in better application and appearance.
	1 - 3 minutes flash between coats Allow 0-5 minutes prior to bake cycle
	Air dry 2.5 - 3 hours/ 68°F (20°C) when using Standox PF Thinner or Air dry 1 – 1.5 hours/ 68°F (20°C) when using Standox PF Fast Dry Agent. Speed bake 10 min at 110°F (43°C) panel temperature when using Standox PF Thinner (16215) or 5 min at 110°F (43°C) panel temperature when using Standox PF Fast Dry Agent (16219).
	Air dry 5 - 6 hours / 68°F (20°C) when using Standox 2K Thinner or Air dry 1 – 1.5 hours/ 68°F (20°C) when using Standox Fast Dry Additive. Bake 25-30 min at 110°F (43°C) panel temperature when using Standox 2K Thinner or 15 min at 110°F (43°C) panel temperature when using Standox Fast Dry Additive (16169).

Standocryl® Clear PFC Air Dry

Important Technical Remarks:

- **Standox** 2K Plasticiser may be added at 10% with **Standocryl** Clear PFC Air Dry. Mix ratio is:

Standocryl Clear PFC Air Dry Plasticised		Mixing Stick, AS11-060-N or AS11-061-N.	
4	+10%	:1	+20%
Standocryl Clear PFC Air Dry	2K Plasticiser	PF Hardener	PF Thinner
3	+10%	:1	+20%
Standocryl Clear PFC Air Dry	2K Plasticiser	2K Hardener	2K Thinner

Flash off and drying times will be longer.

- This clear must be used in a 2-coat process. Allow 1-3 minute flash between coats.
- Use only PFC or 2K components with **Standocryl** Clear PFC Air Dry.
- When using **Standox** PF Fast Dry Agent, time to air dry is reduced to 1 – 1.5 hours / 68°F (20°C), and speed bake is reduced to 5 min / 110°F (43°C) panel temperature.
- When using **Standox** Fast Dry Additive, time to air dry is reduced to approximately 1 hour / 68°F (20°C), and speed bake is reduced to 15 min / 110°F (43°C) panel temperature.
- Cut-ins and small panel or part repairs should be the focused repair areas when using **Standox** Fast Dry Additive with **Standocryl** Clear PFC Air Dry. **Standox** Fast Dry Additive can also be used with **Standocryl** Clear PFC Air Dry to accelerate dry time of the clear in extreme cold temperatures (especially when also using fast 2K Hardeners (H 05-15 (020 15080) or H 15-25 (020 15013))).
- Lowering the air pressure for complaint guns is recommended.

Important Legislative Remarks:

- Please see the appropriate VOC Wallchart for compliance for your area. The values depicted below are ready to spray.

Coating Category: Clear Coating (PF Hardeners)

Max. VOC (AP): 124 g/l; 1.0 lbs/gal

Max. VOC (LE): 250 g/l; 2.1 lbs/gal

Avg. Gallon Weight: 1087.7 g/l; 9.08 lbs/gal

Avg. Weight % Volatiles: 63.5%

Avg. Weight % Water: 0.0%

Avg. Weight % Exempt Solvent: 52.7%

Avg. Volume % Water: 0.0%

Avg. Volume % Exempt Solvent: 51.1%

Theoretical Coverage: 627 sq. ft. @ 1 mil

Theoretical Coverage @ Recommended Film Build: 251 – 314 sq. ft.

Coating Category: Elastomeric Clear Coating (PF Hardeners)

Max. VOC (AP): 132 g/l; 1.1 lbs/gal

Max. VOC (LE): 240 g/l; 2.0 lbs/gal

Avg. Gallon Weight: 1049.9 g/l; 8.46 lbs/gal

Avg. Weight % Volatiles: 59.5%

Avg. Weight % Water: 0.0%

Avg. Weight % Exempt Solvent: 47.2 %

Avg. Volume % Water: 0.0%

Avg. Volume % Exempt Solvent: 47.6%

Theoretical Coverage: 597.6 sq. ft @ 1 mil

Theoretical Coverage @ Recommended Film Build: 239 – 298 sq ft.

Coating Category: Clear Coating (2K Hardeners)

Max. VOC (AP): 360 g/l; 3.0 lbs/gal

Max. VOC (LE): 491 g/l ; 4.1 lbs/gal

Avg. Gallon Weight: 995.8 g/l; 8.31 lbs/gal

Avg. Weight % Volatiles: 61.9%

Avg. Weight % Water: 0.0%

Avg. Weight % Exempt Solvent: 26.2%

Avg. Volume % Water: 0.0%

Avg. Volume % Exempt Solvent: 27.2%

Theoretical Coverage: 534.6 sq. ft. @ 1 mil

Theoretical Coverage @ Recommended Film Build: 214 – 267 sq. ft.

Coating Category: Elastomeric Clear Coating (2K Hardeners)

Max. VOC (AP): 360 g/l; 3.0 lbs/gal

Max. VOC (LE): 479 g/l ; 4.0 lbs/gal

Avg. Gallon Weight: 1001.4 g/l; 8.36 lbs/gal

Avg. Weight % Volatiles: 59.6%

Avg. Weight % Water: 0.0%

Avg. Weight % Exempt Solvent: 23.7 %

Avg. Volume % Water: 0.0%

Avg. Volume % Exempt Solvent: 24.7%

Theoretical Coverage: 536.3 sq. ft @ 1 mil

Theoretical Coverage @ Recommended Film Build: 214 – 268 sq. ft.

- **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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