

Standocryl® 2K Clear 15-60 Plus

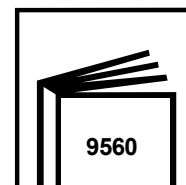
STANDOX

Ordering Information:

5 Liter	2K Clear 15-60 Plus	020 16198
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Features:

- ✧ Excellent appearance
- ✧ Easy to polish
- ✧ Effortless application
- ✧ 1 ½ or 2 coat application
- ✧ 2K Clear for production repairs



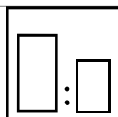
Working Process: 2:1 Clear System

Substrates:

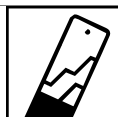
- ✓ **Standox®** Basecoat
- ✓ **Standoblue®** Basecoat



For substrate preparation information
see **Standox** Painting System S1!



2:1 with **Standox** 2K Hardeners
(05-15, 15-25, 20-30, 25-40, 30-45)
potlife 1-1.5 hours /68°F (20°C)



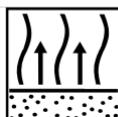
Up to 5% 2K Thinner
(10-20, 15-25, 25-35, 35-40)
16-18 s/DIN 4 mm/ 68°F (20°C)
Up to 5% **Standox** Fast Dry Additive may be added instead of 2K Thinners to speed up the
flash-off and baking process. See appropriate VOC Wallchart for compliance in your area.



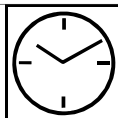
1.3 - 1.4 mm
1.5 -2 coats = 2.0-2.4 mil (50-60 micron)
Please refer to gun manufacturer and local legislation for proper spray pressure
recommendations.
Note: 1.5 coat process= one continuous application to achieve between 2.0- 2.4 mil.



1.2 - 1.3 mm
1-1.5 coats = 2.0-2.4 mil (50-60 micron)
Please refer to gun manufacturer and local legislation for proper spray pressure
recommendations.
Note: 1.5 coat process= one continuous application to achieve between 2.0- 2.4 mil.



Flash off 0-5 min/68°F (20°C)



Bake 15-20 min/140°F (60°C) panel temperature or
Air dry overnight/ 68°F (20°C)

Standocryl® 2K Clear 15-60 Plus

Important Technical Remarks:

- Apply both spray passes with good flow.
- Fast hardeners, thinners and 2K Fast Dry Additive may raise viscosity and shorten pot life.
- 2K Fast Dry Additive should be used on small and vertical panels only.
- For air districts in California with a 4.5 lbs/gal BC-CC limits, this product may be used as a spot repair clear coat. Mix 2:1 with 2.1 Hardeners and thin to viscosity with 2.1 Thinners.
- This clear can be polished after bake and a 1-1.5 hour cool down at 68°F (20°C).
- In a wet-on-wet application process, please observe proper flash-off times of sealer.
- This clear may be used in a 2-coat process, allow 10 minute flash-off between coats.
- **Standex** 2K Clear 15-60 Plus can be matted by mixing with **Standocryl** 2K Special Matt. See TDS 571.1.
- **Standex** 2K Clear 15-60 Plus can be mixed at 15% with **Standex** 2K Plasticiser (15260). **Flash off and drying times will be longer.** Up to 30% 2K Plasticiser may be added to extremely flexible parts. Mix ratio is:

2K Clear 15-60 Plasticised		Mixing Stick F or J.
2	+15%	:1
2K Clear 15-60 Plus	2K Plasticiser	Hardener

- Allow undercoats and Basecoats to flash thoroughly. Choose the correct hardener for the temperature and size of the job.

Important Legislative Remarks:

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

VOC Category	VOC (ap/le)	Wt% Volatiles, Water & Exempts	Gallon Weight
Topcoat Clear Coat 2K Hardener	499/509 g/l	52.27%, 0.00%, 1.49%	8.2 lbs/gal
Elastomeric Clear Coat 2K Hardener	456/464 g/l	47.21%, 0.00%, 1.34%	8.3 lbs/gal

- **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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