

# Standocryl VOC Xtreme Plus Clear K9600

for use with conventional Standox Primer Surfacers



Thanks to its flexible application in 1.5 or 2 coats and its excellent vertical stability, Standocryl VOC Xtreme Plus Clear K9600 is very easy to apply. Its improved drying properties give bodyshops the opportunity to save time, to increase efficiency and to minimise energy consumption.

- When used as part of the Standox Xtreme System, there is no need to harden Standoblue Basecoat.
- Simple 2:1 mixing ratio with all Standox Xtreme Hardeners.
- Flexible application in 1.5 or 2 coats provides more options to match OEM appearance.
- Outstanding vertical stability.
- Improved filling properties cover dirt and dust inclusions.
- Incredibly fast drying: air drying at 20 °C / 30-55 min or low bake at 40-45 °C / 10-15 min.
- The state-of-the-art Axalta technology ensures excellent gloss hold-out.
- Can be tinted with Standox Clearcoat Additives for special OEM colours.
- For use on plastic parts, simply add Standox Plasticiser 5660.

**NOTE** When not used with U7600 & U7650, Standoblue Basecoat must be hardened.

**Part of the Standox Xtreme System - Revolutionary energy saving clear with super-fast curing and the highest performance.**



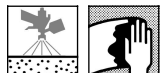
**The Art of Refinishing.**

# Standocryl VOC Xtreme Plus Clear K9600

## Product preparation - application STANDARD



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Old or original paintwork well sanded and cleaned.  
Activated Standobase Basecoat.



Clear		Hardener	
Volume	Weight	Volume	Weight
2	100	1	52
K9600		4580 (XTREME HARDENER) 4590 (XTREME HARDENER SLOW) 4595 (XTREME HARDENER EXTRA SLOW)	

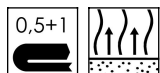
It is possible to use a slower hardener if there is a risk of defects at high air humidity.  
It is possible to use a faster hardener if drying is too slow or the weather is dry (low air humidity).



at 20°C: 45 min - 1 hr



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.3	0.7 bar	atomisation pressure
see manufacturer's instructions			



0.5 + 1  
1 operation  
1st: thin and closed  
2nd: normal

without intermediate flash-off  
final flash-off: 3 min - 5 min at 20°C

or

2 coats

with intermediate flash-off: 0 min - 2 min at 20°C  
final flash-off: 3 min - 5 min at 20°C



For drying options, see details page.

VOC compliant

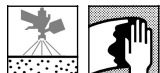
2004/42/IIB(c)(420) 420: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

# Standocryl VOC Xtreme Plus Clear K9600

## Product preparation - application ELASTIC



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Old or original paintwork well sanded and cleaned.  
Activated Standoblu Basecoat.



Clear		Additive		Hardener	
Volume	Weight	Volume	Weight	Volume	Weight
2	100	10%	11	1	57
K9600		5660		4595 (XTREME HARDENER EXTRA SLOW)	

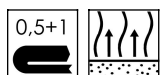
It is possible to use the 4590 XTREME HARDENER SLOW if drying is too slow or weather is dry (low air humidity)



After activation, use immediately.



	Spray nozzle	Spray pressure	
Compliant	1.2 - 1.3	1.8 - 2 bar	inlet pressure
HVLP	1.2 - 1.3	0.7 bar	atomisation pressure
see manufacturer's instructions			



0.5 + 1  
1 operation  
1st: thin and closed  
2nd: normal

without intermediate flash-off  
final flash-off: 3 min - 5 min at 20°C

or

2 coats

with intermediate flash-off: 0 min - 2 min at 20°C  
final flash-off: 3 min - 5 min at 20°C



For drying options, see details page.

VOC compliant

2004/42/IIB(d)(420) 420: The EU limit value for this product (product category: IIB(d)) in ready to use form is maximum 420 g/l of VOC. The VOC content of this product in ready to use form is maximum 420 g/l.

# Standocryl VOC Xtreme Plus Clear K9600

## Products

Standocryl VOC Xtreme Plus Clear K9600

Standox Xtreme Hardener 4580

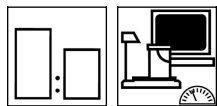
Standox Xtreme Hardener Slow 4590

Standox Xtreme Hardener Extra Slow 4595

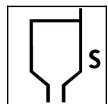
Standox Plasticiser 5660

Standox Performance Blend 5730

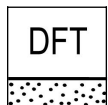
## Product mix



Mixing ratios with special agents are available in the productmix table on Standowin IQ and in the specific TDS.



DIN 4: 14 - 16 s at 20°C



45 - 55 µm 1.5 coats  
50 - 60 µm 2 coats

### Theoretical coverage

515 m<sup>2</sup>/l at 1 micron dry film thickness  
Due to different hardener characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.  
Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.

# Standocryl VOC Xtreme Plus Clear K9600

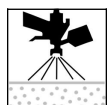


Outside temperature		< 5°C	5 - 20°C	20 - 30°C	> 30°C
STANDARD*	Air drying		4580	4590	4595
			30 - 45 min	35 - 45 min	40 - 50 min
	Low baking 10-15 min at 40-45°C	4580	4590	4595	4595
	Optional bake: 5-10 min at 60-65°C	4580	4590		
ELASTIC**	Air drying		4595	4595	
			50 - 60 min	50 - 60 min	
	Low baking 15-20 min at 40-45°C		4595	4595	

\* It is possible to use a slower hardener if there is a risk of defects at high air humidity.

\* It is possible to use a faster hardener if drying is too slow or the weather is dry (low air humidity).

\*\* It is possible to use the 4590 XTREME HARDENER SLOW if drying is too slow or weather is dry (low air humidity)



Standocryl VOC Xtreme Plus Clear K9600 can be overcoated with itself within 24 hours, without intermediate sanding



Clean after use with a suitable solventbased guncleaner.

# Standocryl VOC Xtreme Plus Clear K9600

## Remarks

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- Refer to the original TDS of the selected system.
  - Material has to be at room temperature (18-25°C) before use.
  - Elastification is mandatory for rigid & half rigid types of plastics.
  - Humidity has an accelerating influence on the drying performance and potlife.
  - Allow additional time for preheating up to panel temperature.
  - Surplus ready for use material should not be returned to original can.
  - Once a can of clear or hardener has been opened, only 1 month remaining shelf life can be guaranteed.
  - Close can of clear and hardener tightly immediately after use, as both products will react with humid air and water and lose their hardening effect.
  - Application only with Standox Xtreme Hardeners 4570 / 4580 / 4590 / 4595.
  - Polishing: Prepare with finest available abrasive paper.
  - Within the full "Xtreme" System, Standox Basecoat activation is not necessary.
  - For full "Xtreme" System approach please refer to the K9600sys TDS.
  - Standocryl VOC Xtreme Plus Clear K9600 cannot be matted.
  - Tinting of Standocryl VOC Xtreme Plus Clear K9600 is possible.
  - In countries without VOC legislation Hardened Standox Basecoat can be used as well.
  - 20% Standox Hardener MS + 30% Standox MSB Thinner.
  - 15% Standox Hardener HS + 40% Standox MSB Thinner.
  - 10% Standox Hardener VOC + 45% Standox MSB Thinner.
  - Standohyd Plus Basecoat has to be activated with 5% Standohyd Plus Special Additive 8050 directly before applying.
  - Standohyd Plus Color Blend 8070 needs to be activated with 5% Standohyd Plus Special Additive 8050 directly before applying.
  - Standox Basecoat has to be activated with 5% Standox Hardener 8550 directly before applying.
  - Standox Color Blend 8570 / 8580 needs to be activated with 5% Standox Hardener 8550 directly before applying.
  - The drying process should not be interrupted until dust free time is reached.
  - Fade out repairs require the use of a specific blending thinner. Please use Standox Performance Blend 5730. For more detailed process information, please refer to the technical data sheet of Standox Performance Blend 5730.
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Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our Standox product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Standox product range, unless explicitly indicated otherwise.

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