

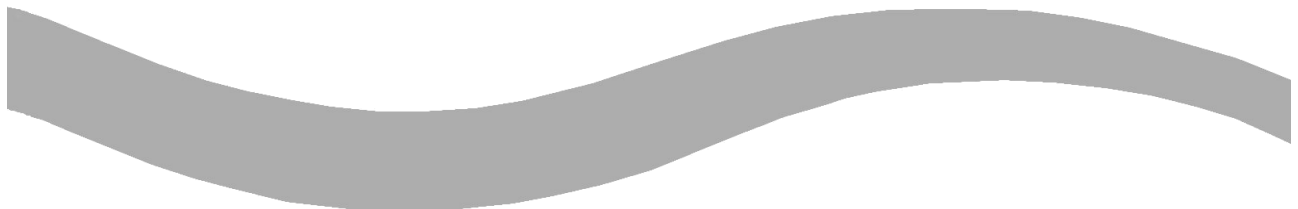


Stadox

VOC-Nonstop-Füllprimer U7550

VOC Nonstop Primer Filler U7550

- **Universal 2K filler**
- **Wet-on-wet or sanding filler**
- **One visit application for wet-on-wet process**
- **Isolating filler also for critical substrates**
- **Excellent hold out**



Technical Description:

- Mix 5:1 with all
Stadox VOC Hardeners
- or
- Mix 3:1 with all
Stadox HS Hardeners
- Force drying possible
- Air dry overnight / 18-22°C
- Dry sand and wet sand

Stadox VOC Nonstop Primer Filler U7550

Substrate:

- Through-hardened sanded paintwork
- Stadox PE Products, sanded
- Well cleaned and fine or unsanded OEM Primer or EDP.
- Only genuine OEM factory supplied parts in KTL or factory E-coat have the advantage that no sanding is required prior to the application of Stadox VOC Nonstop Primer Filler U7550.

Bare metal substrates must be pre-primed with Stadox acid primer.

Pretreatment / Cleaning:



For substrate preparation information see Stadox Painting System S1.

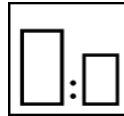


Use air fed respirator. Refer to relevant Health and Safety Data Sheets.

3:1 with
Stadox HS Hardeners
20-23% Stadox VOC Thinner
15-16 s / DIN 4mm / 20°C
33-37 s / ISO 4 mm / 20°C

It is necessary to allow to flash-off at least 30 min / 20-30 micron before overcoating with Standohyd / Standoblue Basecoat in a wet-on-wet system.

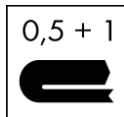
Application: Wet-on-Wet Filler



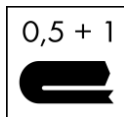
5:1 with all
Stadox VOC Hardeners
Potlife 60 min / 18-22°C



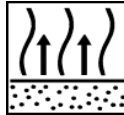
30% Stadox VOC Thinner
15-16 s / DIN 4mm / 20°C
33-37 s / ISO 4 mm / 20°C



Compliant 1.3 - 1.4 mm
2.0 - 2.5 bar inlet pressure
0.5+1 = 20 - 30 micron



HVLP 1.3 - 1.5 mm
0.7 bar atomization pressure
0.5+1 = 20 - 30 micron



30 min / 18-22°C



Standocryl VOC Topcoat or Stadox /
Standohyd / Standoblue Basecoat with
Standocryl 2K / VOC Clears

Stadox VOC Nonstop Primer Filler U7550

Substrate:

- Through-hardened sanded paintwork
- Stadox PE Products, sanded
- Thermoplastic coatings (TPA) and sensitive substrates
- Well cleaned and fine or unsanded OEM Primer or EDP.
- Only genuine OEM factory supplied parts in KTL or factory E-coat have the advantage that no sanding is required prior to the application of Stadox VOC Nonstop Primer Filler U7550.

Bare metal substrates must be pre-primed with Stadox acid primer.

Pretreatment / Cleaning:



For substrate preparation information see Stadox Painting System S1.

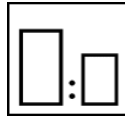


Use air fed respirator. Refer to relevant Health and Safety Data Sheets.

3:1 with
Stadox HS Hardeners
10-15% Stadox 2K Thinner /
Stadox VOC Thinner
20-25 s / DIN 4mm / 20°C
53-72 s / ISO 4 mm / 20°C

Flash off 5-10 min / 20-22°C before
oven- or infrared drying

Application: Sanding Filler



5:1 with all
Stadox VOC Hardeners
Potlife 30-60 min / 18-22°C



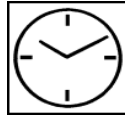
15-20% Stadox VOC Thinner
20-25 s / DIN 4mm / 20°C
53-72 s / ISO 4 mm / 20°C



Compliant 1.6 - 1.8 mm
2.0 - 2.5 bar inlet pressure
2 - 3 = 60 - 100 micron



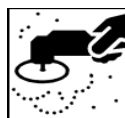
HVLP 1.6 - 1.8 mm
0.7 bar atomization pressure
2 - 3 = 60 - 100 micron



Air dry overnight / 18-22°C or
25-30 min. / 60-65°C panel temperature



P800



P400 - P500
Orbital sander



Standocryl VOC Topcoat or Stadox /
Standohyd / Standoblue Basecoat with
Standocryl 2K / VOC Clears

Stadox VOC Nonstop Primer Filler U7550

Substrate:

- Through-hardened sanded paintwork
- Stadox PE Products, sanded
- Thermoplastic coatings (TPA) and sensitive substrates

Bare metal substrates must be pre-primed with Stadox acid primer.

Pretreatment / Cleaning:



For substrate preparation information see Stadox Painting System S1.



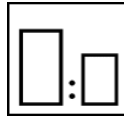
Use air fed respirator. Refer to relevant Health and Safety Data Sheets.

3:1 with
Stadox HS Hardeners
20-23% Stadox VOC Thinner
15-16 s / DIN 4mm / 20°C
33-37 s / ISO 4 mm / 20°C

Flash off 5-10 min / 20-22°C before oven- or infrared drying

Do not sand through the isolating filler. Sand-through areas must be reprimed.

Application: Isolating Filler



5:1 with all
Stadox VOC Hardeners
Potlife 60 min / 18-22°C



30% Stadox VOC Thinner
15-16 s / DIN 4mm / 20°C
33-37 s / ISO 4 mm / 20°C



Compliant 1.3 - 1.4 mm
2.0 - 2.5 bar inlet pressure
3 - 4 = 60 - 100 micron



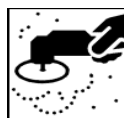
HVLP 1.3 - 1.5 mm
0.7 bar atomization pressure
3 - 4 = 60 - 100 micron



Air dry overnight / 18-22°C or
25-30 min. / 60-65°C panel temperature



P800



P400 - P500
Orbital sander



Standocryl VOC Topcoat or Stadox /
Standohyd / Standoblue Basecoat with
Standocryl 2K / VOC Clears

Stadox VOC Nonstop Primer Filler U7550

Flash point:

- 24°C / 75°F

Specific Gravity:

- 1,56 - 1,59 g/cm³

Solid Content

(without thinner added):

- 69.6 - 69.9 Weight %
- 46.9 - 47.5 Volume %

VOC (2004/42/EC):

2004/42/IIB(c)(540)540

The EU limit value for this product (productcategory IIB.c) in ready to use form is max 540 g/l VOC. The VOC content of this product in ready for use form is max. 540 g/l.

Theoretical

Coverage:

- Wet-on-Wet:
12.8 m²/l at 30 micron dry film thickness
- Sanding filler:
4.8 m²/l at 80 micron dry film thickness

Cleaning of equipment:

Clean after use with Stadox Cleaning Thinner.

Important remarks:

- Apply spray passes with care.
- Do not use infrared drying for substrates not resistant to solvents and TPA.
- The filler can be mixed with max. 15% Standocryl VOC Topcoat. Drying and sanding properties will change.
- In a wet-on-wet process flash-off times can be reduced to 15-20 min / 20-30 micron if overcoated with Stadox Basecoat / Standocryl VOC Topcoat.

2K Paints react with moisture. Therefore all equipment must be kept moisture free. Ready to use paint materials containing isocyanates can cause irritation of the mucous membranes - and of the respiratory organs, in particular - and cause hypersensitive reactions. There is a risk of hypersensitization if the vapour or spray mist is inhaled. When using materials containing isocyanates, all precautions relating to the handling of solvents should be carefully followed. In particular, care should be taken not to inhale spray mist or vapour. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

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