

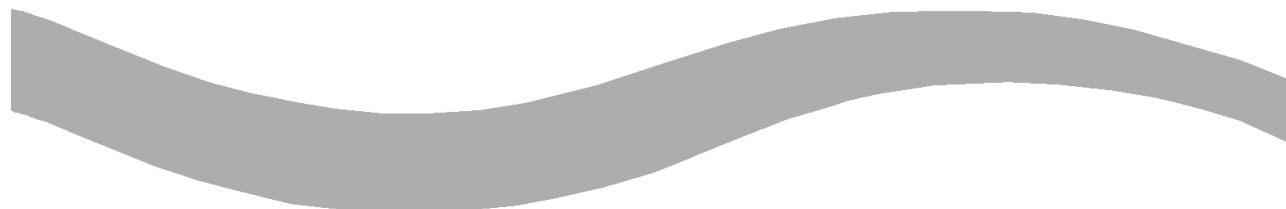


## **Stadox**

### **1K-Füllprimer U3010**

### **1K Primer Filler U3010**

- **1K acid primer**
- **Corrosion protection**
- **Certificate for welding**



## **Technical Description:**

- Suitable as a primer
- 1 spray coat
- Overcoat with Stadox Filler after  
10-15 min / 18-22°C flash off

# Stadox 1K Primer Filler U3010

## Substrate:

- Bare metal, sanded
- Aluminium, sanded
- Galvanised metal, sanded
- Small through-sanded areas in old paintwork and primed replacement panels

## Pretreatment / Cleaning:



For substrate preparation information see Stadox Painting System S1.



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

## Application: Primer



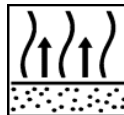
50% Stadox 2K / VOC Thinner  
18-20 s / DIN 4 mm / 20°C  
45-53 s / ISO 4 mm / 20°C



Compliant 1.4 - 1.5 mm  
2.0 - 2.5 bar inlet pressure  
1 = 15 micron



HVLP 1.5 - 1.6 mm  
0.7 bar atomization pressure  
1 = 15 micron



10-15 min / 18-22°C



Stadox Filler

# Stadox 1K Primer Filler U3010

## Flashpoint:

- 24 °C / 75.2 °F

## Specific Gravity:

- 1.04 - 1.07 g/cm<sup>3</sup>

## Solid Content

### (without thinner added):

- 37.1 - 38.7 Weight %
- 19.3 - 19.5 Volume %

## VOC (2004/42/EC):

2004/42/IIB(c)(780)760

The EU limit value for this product (product category: IIB.c) in ready for use form is max 780 g/l of VOC. The VOC content of this product in ready for use form is max. 760 g/l.

## Theoretical

### Coverage:

- 3.7-3.8 m<sup>2</sup>/l at 40 micron dry film thickness

## Cleaning of equipment:

Clean after use with Stadox Cleaning Thinner.

## Important remarks:

- After sanding Stadox 1K Primer Filler U3010 has to be covered completely with Stadox Filler.
- Do not overcoat with PE or EP products.
- Stadox 1K Primer Filler U3010 gives steel 3 months weather resistance, if a dry film thickness of 50 micron is obtained in several spray passes.
- Do not dry sand.
- IR drying possible  
5 min 50% performance

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