

Standofleet 1K Welding Primer U2120

Standofleet 1K Welding Primer U2120 is a 1K etch primer for commercial vehicles.

- Two and three coat system.
- Outstanding corrosion protection.
- Welding certificate.
- Unlimited potlife.

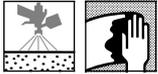


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Product preparation - application STANDARD WET-ON-WET



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



Bare steel sanded and cleaned
Galvanised steel or aluminium sanded and cleaned
Old or original paintwork well sanded and cleaned.
Coil coated, sanded and cleaned



Primer		Thinner	
Volume	Weight	Volume	Weight
1	100	30 - 50 %	24 - 40
U2120		5110 (FLEET FAST) 5120 (FLEET THINNER) 5130 (FLEET SLOW) 5140 (FLEET EXTRA SLOW) 5150 (FLEET SPECIAL)	



Not applicable



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2.5 - 3 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure
Membrane pump	1.1	2.5 - 3 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.8 bar	material pressure
Airmix	0.3	50 - 120 bar	material pressure

see manufacturer's instructions



Primer		Primer-surfacer	
1 coat	flash-off until matt	2 - 3 coats	with intermediate flash-off: 5 min - 10 min final flash-off: 15 min - 30 min



Primer	Primer-surfacer
2K Filler	Standofleet 2K Topcoats

VOC compliant

2004/42/IIB(C)(780) 780: The EU limit value for this product (product category: IIB(C)) in ready to use form is maximum 780 g/l of VOC. The VOC content of this product in ready to use form is maximum 780 g/l.

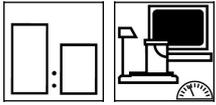
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Products

Standofleet 1K Welding Primer U2120

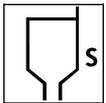
Standofleet 2K Special Thinner 5150
Standofleet 2K Thinner 5120
Standofleet 2K Thinner Extra Slow 5140
Standofleet 2K Thinner Fast 5110
Standofleet 2K Thinner Slow 5130

Product mix



Mixing ratios with special agents are available in the productmix table on Standowin IQ and in the specific TDS.
The choice of hardener and Thinner should be made according to application temperature and size of repair.

5110	Fast thinner only for small panels/areas (15-20°C).
5120	Standard CV thinner for all CV products. (20 -25°C).
5130	Slow thinner for large surfaces and high temp. (25-30°C), to avoid overspray problems.
5140	Extra slow thinner for large surfaces and extra high temp. (>35°C) , to avoid overspray problems.
5150	Special thinner only for airless or airmix application.



DIN 4: 20 - 26 s at 20°C



15 - 20 µm primer
25 - 30 µm primer-surfacer

Theoretical coverage

170 - 180 m²/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.



Clean after use with a suitable solventbased guncleaner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Mix thoroughly by hand before placing the can on mixing machine.
- This product gives steel 3 months weather resistance with a dry film thickness of 50 micron.
- On sandblasted substrates the roughness of the surface has to be filled.
- Do not overcoat with PE, EP, Standohyd and Standoblue products.

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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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