

# Standofleet 2K Primer Surfacer U2510



**Standofleet is the modular paint system for commercial vehicles that complies with the strict VOC limits of the European Union. Standofleet 2K Primer Surfacer U2510 is a VOC-compliant 2K wet-on-wet/sanding filler for universal use in the commercial vehicle sector.**

- Good filling power.
- Good vertical stability.
- Universal in use.

**Universal and environmentally-responsible.**



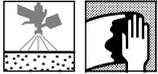
**The Art of Refinishing.**

# Standofleet 2K Primer Surfacer U2510

## Product preparation - application STANDARD SANDING HS



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



Steel, galvanised steel or soft aluminium, sanded and cleaned and coated with Acid Primer  
 Coil coated, sanded and cleaned  
 Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.  
 Old or original paintwork well sanded and cleaned.  
 Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.  
 OEM Primer (e-coat), sanded and cleaned.  
 Sandblasted steel (SA 2.5)



Filler		Hardener		Thinner	
Volume	Weight	Volume	Weight	Volume	Weight
6	100	1	12	25 - 30 %	18 - 21
U2510		4110 (FLEET HS FAST) *		5110 (FLEET FAST)	
		4120 (FLEET HS) *		5120 (FLEET THINNER)	
		4130 (FLEET HS SLOW) *		5130 (FLEET SLOW)	
				5140 (FLEET EXTRA SLOW)	
				5150 (FLEET SPECIAL)	

\* Spray Viscosity DIN4: 20-26 seconds

Pot life at 20°C: 2 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure
Membrane pump	1.1	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure
Airmix	0.23 - 0.28	90 - 120 bar	material pressure

see manufacturer's instructions



2 - 3 coats  
 with intermediate flash-off: 5 min - 10 min  
 before bake: 15 min - 30 min



	<b>4120 / 4110 / 4130</b>
60 °C	45 min



P360 - P500



Standofleet 2K Topcoats  
 Standox Basecoat

VOC compliant

2004/42/IIB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

# Standofleet 2K Primer Surfacer U2510

## Product preparation - application STANDARD SANDING MS



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



Steel, galvanised steel or soft aluminium, sanded and cleaned and coated with Acid Primer  
 Coil coated, sanded and cleaned  
 Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.  
 Old or original paintwork well sanded and cleaned.  
 Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.  
 OEM Primer (e-coat), sanded and cleaned.  
 Sandblasted steel (SA 2.5)



Filler		Hardener		Thinner	
Volume	Weight	Volume	Weight	Volume	Weight
3	100	1	22	10 %	8
U2510		4010 (FLEET MS FAST) * 4020 (FLEET MS) *		5110 (FLEET FAST) 5120 (FLEET THINNER) 5130 (FLEET SLOW) 5140 (FLEET EXTRA SLOW) 5150 (FLEET SPECIAL)	

\* Spray Viscosity DIN4: 20-26 seconds

Pot life at 20°C: 2 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure
Membrane pump	1.1	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure
Airmix	0.23 - 0.28	90 - 120 bar	material pressure

see manufacturer's instructions



2 - 3 coats  
 with intermediate flash-off: 5 min - 10 min  
 before bake: 15 min - 30 min



	4020 / 4010
60 °C	45 min



P360 - P500



Standofleet 2K Topcoats  
 Standox Basecoat

VOC compliant

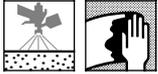
This product mix is not VOC compliant.

# Standofleet 2K Primer Surfacer U2510

## Product preparation - application STANDARD WET-ON-WET HS



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



Steel, galvanised steel or soft aluminium, sanded and cleaned and coated with Acid Primer  
Coil coated, sanded and cleaned  
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.  
Old or original paintwork well sanded and cleaned.  
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.  
OEM Primer (e-coat), sanded and cleaned.  
Sandblasted steel (SA 2.5)



Filler		Hardener		Thinner	
Volume	Weight	Volume	Weight	Volume	Weight
6	100	1	12	30 %	21
U2510		4110 (FLEET HS FAST) *		5110 (FLEET FAST)	
		4120 (FLEET HS) *		5120 (FLEET THINNER)	
		4130 (FLEET HS SLOW) *		5130 (FLEET SLOW)	
				5140 (FLEET EXTRA SLOW)	
				5150 (FLEET SPECIAL)	

\* Spray Viscosity DIN4: 18-20 seconds

Pot life at 20°C: 2 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure
Membrane pump	1.1	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure
Airmix	0.23 - 0.28	90 - 120 bar	material pressure

see manufacturer's instructions

1 coat

final flash-off: 30 min - 1 hr



Standofleet 2K Topcoats  
Stadox Basecoat

VOC compliant

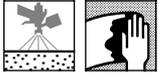
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# Standofleet 2K Primer Surfacer U2510

## Product preparation - application STANDARD WET-ON-WET MS



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



Steel, galvanised steel or soft aluminium, sanded and cleaned and coated with Acid Primer  
Coil coated, sanded and cleaned  
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.  
Old or original paintwork well sanded and cleaned.  
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.  
OEM Primer (e-coat), sanded and cleaned.  
Sandblasted steel (SA 2.5)



Filler		Hardener		Thinner	
Volume	Weight	Volume	Weight	Volume	Weight
3	100	1	22	15 %	12
U2510		4010 (FLEET MS FAST) *		5110 (FLEET FAST)	
		4020 (FLEET MS) *		5120 (FLEET THINNER)	
				5130 (FLEET SLOW)	
				5140 (FLEET EXTRA SLOW)	
				5150 (FLEET SPECIAL)	

\* Spray Viscosity DIN4: 18-20 seconds

Pot life at 20°C: 2 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	atomisation pressure
Membrane pump	1.1	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1	0.8 - 1.2 bar	material pressure
Airmix	0.23 - 0.28	90 - 120 bar	material pressure

see manufacturer's instructions



1 coat final flash-off: 30 min - 1 hr



Standofleet 2K Topcoats  
Stadox Basecoat

VOC compliant

This product mix is not VOC compliant.

# Standofleet 2K Primer Surfacer U2510

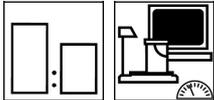
## Products

Standofleet 2K Primer Surfacer U2510

Standofleet 2K HS Hardener 4120  
Standofleet 2K HS Hardener Fast 4110  
Standofleet 2K HS Hardener Slow 4130  
Standofleet 2K MS Hardener 4020  
Standofleet 2K MS Hardener Fast 4010

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.

4010	Accelerated fast hardener for small panels or for design work (stripes) 20-25°C.
4020	Standard hardener for all 2K CV products (20-25°C).
4110	Accelerated fast hardener for small panels or for design work (stripes) 20-25°C.
4120	Standard hardener for all 2K CV products (20-25°C).
4130	Slow hardener for large surfaces and high temperatures (>30°C).
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.

50 - 100 µm



### Theoretical coverage

470 - 480 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.



Clean after use with a suitable solventbased guncleaner.

# Standofleet 2K Primer Surfacer U2510

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## Remarks

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- Material has to be at room temperature (18-25°C) before use.
  - Surplus ready for use material should not be returned to original can.
  - On sandblasted steel the recommended dry film thickness must be measured above the peaks.
  - Mix thoroughly by hand before placing the can on mixing machine.
  - For a Nonstop process the topcoat must be applied within 24 hours or drying and sanding is necessary.
  - Filler is tintable up to 10% with Standofleet / Standomix mixing enamels or up to 20% with Standofleet Topcoat. Drying and sanding can be affected.
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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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