

Standofleet 2K VOC Sanding Filler U2520



Standofleet is the modular paint system for commercial vehicles that complies with the strict VOC limits of the European Union. Standofleet 2K VOC Sanding Filler U2520 is a VOC-compliant, 2K sanding filler with outstanding filling properties.

- Excellent filling power.
- High vertical stability.
- Very good topcoat holdout.
- Easy to sand.



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Product preparation - application STANDARD SANDING



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.



Filler		Hardener		Thinner	
Volume	Weight	Volume	Weight	Volume	Weight
8	100	1	9	10 - 15 %	7 - 10
U2520		4110 (FLEET HS FAST) 4120 (FLEET HS) 4130 (FLEET HS SLOW)		5110 (FLEET FAST) 5120 (FLEET THINNER) 5130 (FLEET SLOW)	



Pot life at 20°C: 1 hr - 2 hr



	Spray nozzle	Spray pressure	
Compliant	1.6 - 1.8	2 - 2.5 bar	inlet pressure
HVLP	1.5 - 1.9	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: 10 min - 15 min



	4120 / 4110 / 4130
20 °C	12 hr - 16 hr
60 - 65 °C	45 min - 1 hr

P360 - P500



Standofleet 2K Topcoats
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.

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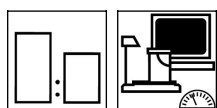
Products

Standofleet 2K VOC Sanding Filler U2520

Standofleet 2K HS Hardener 4120
Standofleet 2K HS Hardener Fast 4110
Standofleet 2K HS Hardener Slow 4130

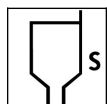
Standofleet 2K Thinner 5120
Standofleet 2K Thinner Fast 5110
Standofleet 2K Thinner Slow 5130

Product mix

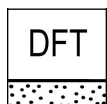


Mixing ratios with special agents are available in the productmix table on Standowin IQ and in the specific TDS.
The choice of hardener and Thinner should be made according to application temperature and size of repair.

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.



DIN 4: 22 - 26 s at 20°C



100 - 120 µm

Theoretical coverage

450 - 460 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 cleaning thinner.

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Remarks

- Material has to be at room temperature (18-25°C) before use.
 - Surplus ready for use material should not be returned to original can.
 - Mix thoroughly by hand before placing the can on mixing machine.
 - Filler is tintable up to 10% with Standofleet / Standomix mixing enamels or up to 20% with Standofleet Topcoat. Drying and sanding can be affected.
 - In Non-VOC countries the material can also be overcoated with Standofleet MS Topcoat or Stadox Basecoat with Standofleet 2K MS Clear K9310.
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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 Stadox 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 Stadox product range, unless explicitly indicated otherwise.

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