

# Standex 1K Adhesion Primer U3030



**Standex 1K Adhesion Primer U3030 is a chromate-free, 1K etching primer that increases corrosion protection and is easy to apply. It is suitable for use as a primer in a single spray pass on welding parts (welding certificate available). It is also suitable as a primer under 2K primer fillers. For smaller repairs and sand-through areas, this adhesion primer is available in handy SprayMax spray cans.**

- One to two spray passes.
- Easy to use.
- 1K acid primer.
- Certified for welding.
- Chromate-free.
- Outstanding corrosion protection.

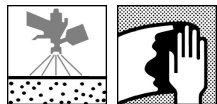


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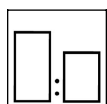
## Product preparation - application STANDARD



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  
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.  
Old or original paintwork well sanded and cleaned.  
OEM Primer (e-coat), sanded and cleaned.



Primer		Thinner	
Volume	Weight	Volume	Weight
100 %	100	50 %	43
U3030		2K 10-20 2K 15-25 2K 20-25 2K 25-35 2K 35-40 VOC T 15-30 VOC T 30-40	



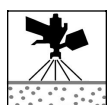
Pot life at 20°C: 8 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.5	1.5 - 2 bar	inlet pressure
HVLP	1.3 - 1.5	0.7 bar	atomisation pressure
see manufacturer's instructions			



1 - 2 coats  
final flash-off: 15 min - 20 min



2K Filler

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.

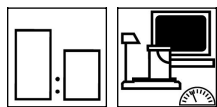
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## Products

Standex 1K Adhesion Primer U3030

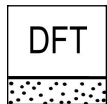
- Standex Thinner 2K 10-20
- Standex Thinner 2K 15-25
- Standex Thinner 2K 20-25
- Standex Thinner 2K 25-35
- Standex Thinner 2K 35-40
- Standex Thinner VOC 15-30
- Standex Thinner VOC 30-40

## Product mix



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

2K 10-20	Accelerated fast thinner suitable for Micro Repair, spot and panel repairs. Recommended for cooler application conditions e.g. 10-20°C.
2K 15-25	Fast thinner suitable for Micro Repair, Spot and panel repairs. Recommended for temperature of 15-25°C.
2K 20-25	Medium thinner suitable for panel and multi panel repairs. Recommended for application temperature of 20-25°C.
2K 25-35	Medium-slow thinner suitable for medium to large size repairs. Recommended also for warm conditions e.g. 25-35°C.
2K 35-40	Slow thinner suitable for medium to large size repairs. Recommended for use in hot climates e.g. 35-40°C.
VOC 15-30	Medium thinner suitable for panel, multi panel and large size repairs. Recommended for application temperature e.g. 15-30°C.
VOC 30-40	Slow thinner for medium to large size repairs. Recommended for use in hot climates e.g. 30-40°C.



15 - 30 µm

### Theoretical coverage

110 - 115 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.

# Stadox 1K Adhesion Primer U3030

## Remarks

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- Material has to be at room temperature (18-25°C) before use.
  - Application with a flat paint brush: 1-2 coats (application viscosity as supplied).
  - Do not recoat with polyester-, epoxy- or waterborne products.
  - This product gives three months weather resistance on bare steel at the dry film thickness of minimum 50 micron.
  - Mix thoroughly by hand before placing the can on mixing machine.
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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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