

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.



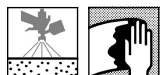
The Art of Refinishing.

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) * 4120 (FLEET HS) * 4130 (FLEET HS SLOW) * | | 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



60 °C

4120 / 4110 / 4130
45 min



P360 - P500



Standofleet 2K Topcoats
Standox Basecoat

VOC compliant

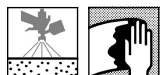
2004/42/IIB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

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

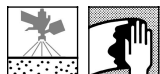
This product mix is not VOC compliant.

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

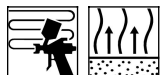


Pot life at 20°C: 2 hr



| | 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
Standex 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 Topcoats
Stadox Basecoat

VOC compliant

Standofleet 2K Primer Surfacer U2510

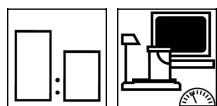
Products

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. |

DFT

50 - 100 µm

Theoretical coverage

470 - 480 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.

Standofleet 2K Primer Surfacer U2510

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.
 - 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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