

## Standofleet Primer Very High Build U2610



**Standofleet Primer Very High Build U2610 is a 2K filler based on polyacrylic with a low VOC value and very high solids content.**

- Specially developed to meet the demanding requirements of the commercial vehicles sector, ACE segment and general industry.
- Fast drying time.
- Can be used either as Primer-Filler or Filler.
- Available in white, light grey and dark grey.



# Standofleet Primer Very High Build U2610

## Product preparation - application STANDARD SANDING



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



Old or original paintwork well sanded and cleaned.

Bare steel sanded and cleaned

Sandblasted steel (SA 2.5)

Stainless steel and Aluminium profiles, sanded, cleaned and coated with Acid Primer.

Surfaces must be prepared and cleaned correctly before application

Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.



Primer surfacer	Hardener	Thinner
8	1	15-25 %
U2610	4110 (Fleet HS Fast)	5110 (Fleet Fast)
	4120 (Fleet HS)	5120 (Fleet Thinner)
	4130 (Fleet HS Slow)	5130 (Fleet Slow)

Primer surfacer	Hardener	Thinner
5	1	5-10 %
U2610	4210 (Fleet Fast)	5110 (Fleet Fast)
	4220 (Fleet Standard)	5120 (Fleet Thinner)
	4230 (Fleet Slow)	5130 (Fleet Slow)
	4240 (Fleet Extra Slow)	

Activated: 2 hr - 3 hr

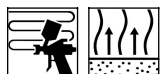


	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.8	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.8	0.7 bar	atomisation pressure
Membrane pump	1.1 - 1.3	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1 - 1.3	0.8 - 1.2 bar	material pressure
Airmix	0.28 - 0.33	80 - 120 bar	material pressure

see manufacturer's instructions

1 - 2 closed coats.

with intermediate flash-off: 10 min - 15 min  
before bake: 15 min - 20 min



20 - 25 °C	12 hr - 16 hr
50 - 60 °C	30 min - 45 min

P240 - P500



Standofleet 2K Topcoats

VOC compliant

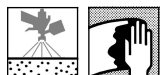
2004/42/IIB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

# Standofleet Primer Very High Build U2610

## 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.



Old or original paintwork well sanded and cleaned.

Bare steel sanded and cleaned

Sandblasted steel (SA 2.5)

Steel, galvanised steel or soft aluminium, sanded and cleaned and coated with Acid Primer

Surfaces must be prepared and cleaned correctly before application

Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.



Primer surfacer	Hardener	Thinner
8	1	15-25 %
U2610	4110 (Fleet HS Fast)	5110 (Fleet Fast)
	4120 (Fleet HS)	5120 (Fleet Thinner)
	4130 (Fleet HS Slow)	5130 (Fleet Slow)

Primer surfacer	Hardener	Thinner
5	1	5-10 %
U2610	4210 (Fleet Fast)	5110 (Fleet Fast)
	4220 (Fleet Standard)	5120 (Fleet Thinner)
	4230 (Fleet Slow)	5130 (Fleet Slow)
	4240 (Fleet Extra Slow)	



Activated: 2 hr - 3 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.8	2 - 2.5 bar	inlet pressure
HVLP	1.4 - 1.8	0.7 bar	atomisation pressure
Membrane pump	1.1 - 1.3	2 - 2.5 bar	atomisation pressure
Membrane pump	1.1 - 1.3	0.8 - 1.2 bar	material pressure
Airmix	0.28 - 0.33	80 - 120 bar	material pressure

see manufacturer's instructions



1 - 2 closed coats.

with intermediate flash-off: 10 min - 15 min  
final flash-off: 30 min - 1 hr



20 - 25 °C

30 min - 45 min



Standofleet 2K Topcoats

VOC compliant

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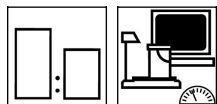
## Products

Standofleet Primer Very High Build U2610

Standofleet 2K HS Hardener 4120  
Standofleet 2K HS Hardener Fast 4110  
Standofleet 2K HS Hardener Slow 4130  
Standofleet Hardener Extra Slow 4240  
Standofleet Hardener Fast 4210  
Standofleet Hardener Slow 4230  
Standofleet Hardener Standard 4220

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

## Product mix

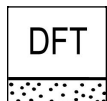
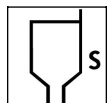


Mixing ratios with special agents are available in the productmix table on Standowin IQ and in the specific TDS.

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).
4210	Suitable for full and partial refinishes at low temperatures and at low air settling rates in the spray booth.
4220	Suitable for full and partial refinishes at low and medium temperatures and at low air settling rates in the spray booth.
4230	Suitable for full and partial refinishes at medium temperatures and at normal and high air settling rates in the spray booth.
4240	Suitable for full and partial refinishes at very high temperatures and at normal and high air settling rates in the spray booth.
5110	Fast thinner only for small panels/areas (15-20°C).
5120	Standard CV thinner for all CV products. (20 -25°C).
5130	Extra slow thinner for large surfaces and extra high temp. (>35°C) , to avoid overspray problems.

DIN 4: 24 - 35 s at 20°C



40 - 80 µm



# Standofleet Primer Very High Build U2610

## Theoretical coverage



320 - 330 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 cleaning thinner.

## 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.
- The Primer Surfacer can be overcoated within 1 month without sanding, only cleaning of the surface is necessary.
- A wet on wet application with Epoxy topcoat is not possible.
- On sandblasted steel the recommended dry film thickness must be measured above the peaks.
- Dry film thickness up to 300µm can be achieved. Extended flash-off time is required between coats.
- Mix thoroughly by hand before placing the can on mixing machine.
- Filler is tintable up to 10% with Standofleet / Standomix mixing tints or up to 20% with Standofleet Topcoat. Drying and sanding can be affected.
- In countries without VOC legislation Standox Basecoat can be used as well.

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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