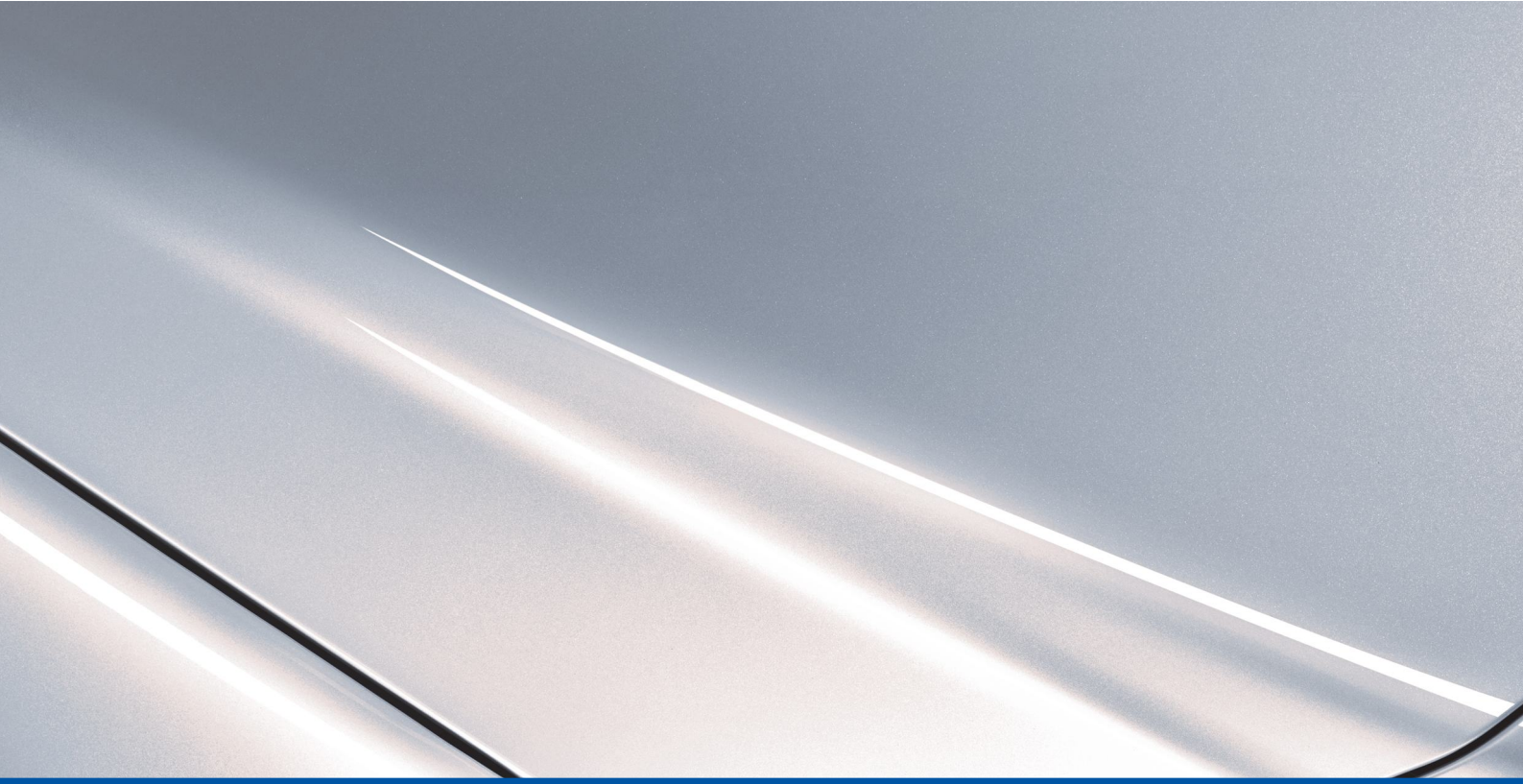


VOC-Xtreme Wet-on-Wet Filler U7650



Based on patented, innovative Axalta chemistry, the Standox VOC Xtreme Wet-on-Wet Filler U7650 is a revolutionary product. It enhances and completes the Standox Xtreme System as the fastest Wet-on-Wet Filler in the car refinish industry. With a very impressive final flash-off time of five minutes, it is suitable for bodyshops who want the highest efficiency and outstanding gloss hold-out for new spare parts.

- Simple 1:1 +10 % mixing ratio with Standox Xtreme Wet-on-Wet Filler Hardener 4650 and Standox Xtreme Filler Accelerator U7610.
- Most efficient and easy One Visit Application process in up to two coats.
- Provides excellent vertical stability and very smooth flow directly from the spray gun.
- After five minutes it can be overcoated with Standoblue or Standohyd Plus Basecoat or if needed it can be slightly denibbed (removal of dust inclusions).
- The new technolgogy offers outstanding gloss hold-out after top coating.
- Available in three colours: white FC1, grey FC2 and black FC3.
- For metal substrate pre-treatment, the use of Standox Express Prep Wipes U3000 is mandatory, delivering an easy and convenient priming process without using wet products.
- The innovative Xtreme System is the foundation of the Standox 1 Day Repair concept and stands out as the shortest repair process with significant energy cost savings.
- In combination with the Standox VOC Xtreme Plastic Additive U7660 it can be used for direct to plastic refinishing of most commonly used plastic substrates on passenger cars.

Revolutionary Xtreme technology, fastest Wet-on-Wet Filler in the car refinish industry.

STANDOX

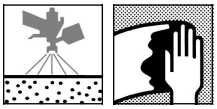
The Art of Refinishing.

VOC-Xtreme Wet-on-Wet Filler U7650

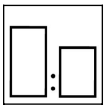
Product preparation - application STANDARD WET-ON-WET



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



Steel, galvanised steel and soft aluminium, sanded and cleaned, treated with Standox Express Prep Wipes U3000
Old or original paintwork well sanded and cleaned.
OEM Primer (e-coat), finely sanded or unsanded and thoroughly cleaned. Remark: due to the wide variety of electrocoats present on the market, its quality can differ a lot. For this reason preferably scuff sand the e-coat
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.



Filler		Hardener		Thinner/Additive/Accelerator	
Volume	Weight	Volume	Weight	Volume	Weight
1	100	1	59	10%	11
U7650		4650		U7610 VOC T 30-40 *	

* At climate above 30°C / 50% rel. humidity use VOC T 30-40 instead of U7610.

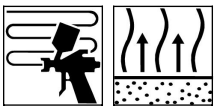


at 20°C: 30 min - 1 hr



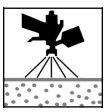
	Spray nozzle	Spray pressure	
HVLP	1.3 - 1.4	0.7 bar	air cap pressure
Compliant	1.3 - 1.4	1.5 - 1.8 bar	inlet pressure

see manufacturer's instructions



1 - 2 coats

final flash-off: 5 min - 8 hr



Standoblue Basecoat / Standohyd Plus Basecoat + Clearcoat
Standocryl VOC Topcoat
Activated Standohyd Plus Basecoat + Standocryl VOC Xtreme Plus Clear K9600
Standoblue Basecoat + Standocryl VOC Xtreme Plus Clear K9600.

VOC compliant

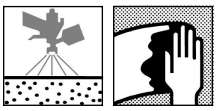
2004/42/IIB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

VOC-Xtreme Wet-on-Wet Filler U7650

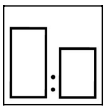
Product preparation - application STANDARD PLASTICS



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



Repairs to exterior common plastic car parts, sanded and cleaned.
OEM Primer for plastic, scuff sanded and cleaned.
New exterior common plastic car parts, tempering 60 min. 60-65°C / first cleaning use a pad ultrafine soaked in Standoflex Plastic Cleaner antistatic 6500 / final cleaning use a cloth moistened with Standoflex Plastic Cleaner antistatic 6500.
Wipe surface to loosen and lift contaminants. Immediately, thoroughly wipe off with a clean cloth. Change cloths often, never use dirty cloths.



Filler		Hardener		Thinner/Additive/Accelerator	
Volume	Weight	Volume	Weight	Volume	Weight
1	100	1	59	20%	22
U7650		4650		U7660	

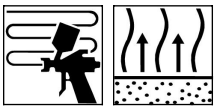


at 20°C: 30 min - 1 hr



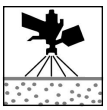
	Spray nozzle	Spray pressure	
HVLP	1.3 - 1.4	0.7 bar	air cap pressure
Compliant	1.3 - 1.4	1.5 - 1.8 bar	inlet pressure

see manufacturer's instructions



1 - 2 coats

final flash-off: 5 min - 8 hr



Standoblue Basecoat / Standohyd Plus Basecoat + Elastified Clearcoat
Elastified Standocryl VOC Topcoat
Activated Standohyd Plus Basecoat + elastified Standocryl VOC Xtreme Plus Clear K9600.
Standoblue Basecoat + elastified Standocryl VOC Xtreme Plus Clear K9600.

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.

VOC-Xtreme Wet-on-Wet Filler U7650

Products

Standox VOC Xtreme Wet-on-Wet Filler U7650

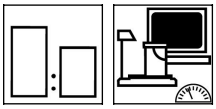
Standox VOC Xtreme Plastic Additive U7660

Standox VOC Xtreme Wet-on-Wet Filler Hardener 4650

Standox Xtreme Filler Accelerator U7610

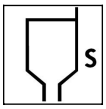
Standox Thinner VOC 30-40

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.

4650	Xtreme Wet-on-Wet Filler Hardener is a dedicated hardener to be used in VOC Xtreme Wet-on-Wet Filler U7650 only. It can be used for all type of wet-on-wet repairs of new panels in PC segment and under most climate conditions.
U7610	Xtreme Filler Accelerator U7610 can be used in VOC Xtreme Filler only. It accelerates the air dry performance particularly in low humidity conditions and when filler is forced dried.
U7660	VOC Xtreme Plastic Additive U7660 is a dedicated plastic adhesion promoter to be used exclusively in VOC Xtreme Filler U7600 and VOC Xtreme Wet-on-wet Filler U7650 to provide direct to plastic refinishing properties.
VOC T 30-40	Slow thinner for multiple panels up to full resprays. Mainly to be used at higher temperatures of 30-40°C.



DIN 4: 13 - 14 s at 20°C



25 - 50 µm

Theoretical coverage

390 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.

VOC-Xtreme Wet-on-Wet Filler U7650

Remarks

- The use of the Standox Express Prep Wipes U3000 is mandatory for bare metal substrates. Non-use can be detected analytically.
- VOC Xtreme Wet-on-Wet Filler U7650 is suitable for the repair of 3-stage colours with Standoblue Basecoat. Please refer to the corresponding Standoblue Basecoat Technical Data Sheet for the application of 3-stage colors.
- After usage all cans must be closed immediately.
- Very early denibbing at the earliest after 5 min possible.
- Material has to be at room temperature (18-25°C) before use.
- Humidity has an accelerating influence on the drying performance and potlife.
- If VOC Xtreme Wet-on-Wet Filler U7650 is mixed with VOC Xtreme Plastic Additive U7660, this mixture can also be applied to adjacent metal parts (bare metal areas need to be pre-primed with Standox Express Prep Wipes U3000) although this is not the primary intention.
- Mix thoroughly by hand before placing the can on mixing machine.
- No Acid Primer or 2K EP Primer-Surfacers under VOC Xtreme Wet-on-Wet Filler U7650 allowed.
- For improved adhesion properties, particularly on critical plastic substrates such as e.g. PP, the use of Standoflex Plastic Primer U3060/U3060S or Standoflex Plastic Adhesion Primer U3070/U3070S prior the application of VOC Xtreme Wet-on-Wet Filler U7650 mixed with VOC Xtreme Plastic Additive U7660 is recommended.
- For more detailed information, e.g. suitable plastic substrates, please refer to the Standox Plastic Painting System Data Sheet SXPlasticSystem.

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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