

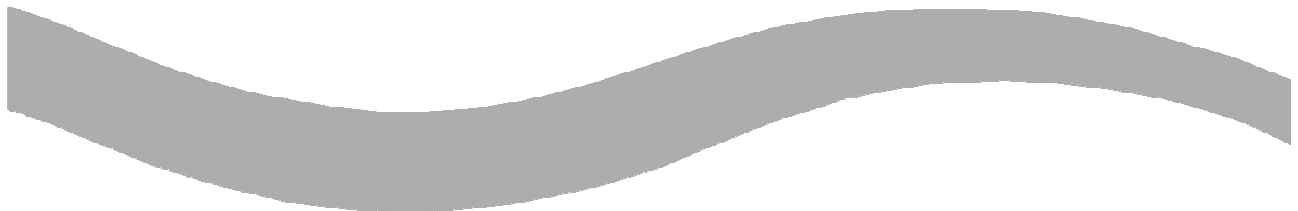


Stadox

VOC-System-Füller

VOC System Filler

- **VOC compliant**
- **Good vertical stability**
- **Good filling properties**
- **Easy to sand**
- **Excellent tension**
- **Chromate-free**
- **Good isolating properties**



Technical Description:

- Mix 7:1 with all
Stadox VOC Hardeners
- or
- Mix 4:1 with all
Stadox 2K HS Hardeners
- Force drying possible
- Air dry overnight / 18-22°C

Stadox VOC-System-Füller

Substrate:

- Through-hardened sanded paintwork, except TPA
- OEM Primer or EDP, sanded
- Stadox PE Products, sanded
- UP-GF, sanded

Bare metal substrates must be pre-primed with Stadox Acid Primer.

Pretreatment / Cleaning:



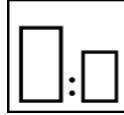
For substrate preparation information see Stadox Painting System S1.



Use air fed respirator. Refer to relevant Health and Safety Data Sheets.

**Flash off 5-15 min / 18-22 °C
before oven- or infrared drying**

Application: VOC System



7:1 with all
Stadox VOC Hardeners
Potlife 90-120 min / 18-22 °C



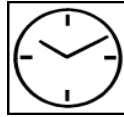
10% Stadox VOC Thinner
22-24 s / DIN 4mm / 20 °C
61-68 s / ISO 4 mm / 20 °C



Compliant 1.6 - 1.8 mm
1.5 - 3.0 bar inlet pressure
2 - 3 = max. 250 micron



HVLP 1.6 - 1.9 mm
0.7 bar atomization pressure
2 - 3 = max. 250 micron



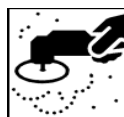
Air dry overnight / 18-22 °C or
30-40 min. / 60-65 °C panel temperature



Short wave 10 - 15 min
(see Stadox Painting System S10)



P800



P400 - P500
Orbital sander



Standocryl VOC Topcoat or
Standohyd / Standoblue Basecoat with
Standocryl VOC Clears

Stadox VOC-System-Füller

Substrate:

- Through-hardened sanded paintwork, except TPA
- OEM Primer or EDP, sanded
- Stadox PE Products, sanded
- UP-GF, sanded

Bare metal substrates must be pre-primed with Stadox Acid Primer.

Pretreatment / Cleaning:



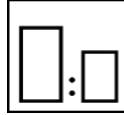
For substrate preparation information see Stadox Painting System S1.



Use air fed respirator. Refer to relevant Health and Safety Data Sheets.

**Flash off 5-15 min / 18-22 °C
before oven- or infrared drying**

Application: HS System



4:1 with all
Stadox 2K HS Hardeners
Potlife 60-90 min / 18-22 °C



If necessary 5-10% Stadox 2K Thinner
24-26 s / DIN 4mm / 20 °C
68-76 s / ISO 4 mm / 20 °C



Compliant 1.6 - 1.8 mm
1.5 - 3.0 bar inlet pressure
2 - 3 = max. 250 micron



HVLP 1.6 - 1.9 mm
0.7 bar atomization pressure
2 - 3 = max. 250 micron



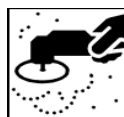
Air dry overnight / 18-22 °C or
30-40 min. / 60-65 °C panel temperature



Short wave 10 - 15 min
(see Stadox Painting System S10)



P800



P400 - P500
Orbital sander



Standocryl VOC Topcoat or
Standohyd / Standoblue Basecoat with
Standocryl VOC Clears

Stadox VOC-System-Füller

Flash point:

- 24 - 25 °C / 75.2 - 77.0 °F

Specific Gravity:

- 1,50 - 1,52 g/cm³

Solid Content

(without thinner added):

- 69.5 - 70.6 Weight %
- 47.5 - 48.8 Volume %

VOC (2004/42/EC):

2004/42/IIB(c)(540)540

The EU limit value for this product (productcategory IIB.c) in ready to use form is max 540 g/l VOC. The VOC content of this product in ready for use form is max. 540 g/l.

Theoretical

Coverage:

- 5.6 - 5.8 m²/l at 80 micron dry film thickness

Cleaning of equipment:

Clean after use with Stadox Cleaning Thinner.

Important remarks:

- For better control of the sanding process, spray the filler and allow to flash off. Spray a thin coat of Control Black as a guide coat.
- The filler can be mixed with max. 15% Standocryl VOC Topcoat. Drying and sanding properties will change.
- For film thicknesses of more than 150 micron air dry overnight / 18-22°C or 40 min / 60-65°C panel temperature.
- In countries without VOC legislation Stadox Basecoat / Standocryl 2K Topcoat can be used as well.

2K Paints react with moisture. Therefore all equipment must be kept moisture free. Ready to use paint materials containing isocyanates can cause irritation of the mucous membranes - and of the respiratory organs, in particular - and cause hypersensitive reactions. There is a risk of hypersensitization if the vapour or spray mist is inhaled. When using materials containing isocyanates, all precautions relating to the handling of solvents should be carefully followed. In particular, care should be taken not to inhale spray mist or vapour. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

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