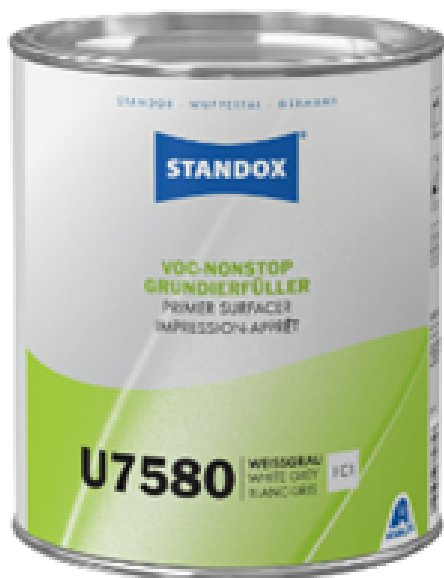


# Standex VOC Nonstop Primer Surfacer U7580



Good adhesion and corrosion properties characterise the Standox VOC Nonstop Primer Surfacer U7580. It builds on the success of the proven and well-known VOC Nonstop Primer Filler U7550 and can be applied directly to small bare steel or aluminium substrates when refinishing passenger cars. In combination with the new Standox VOC Plastic Additive U7590, it can be used to refinish most commonly used plastic substrates on passenger cars. With a single product it is possible to prime and coat several different types of substrate economically using the wet-on-wet application process.

- VOC compliant.
- Applied direct to small bare metal areas or to plastic.
- Good corrosion protection and adhesion properties.
- Very good application properties.
- Wet-on-wet application possible in a single spray process (One Visit Application).
- Short flash-off time.
- Long pot life.
- Can be overcoated with all Standox Basecoats.

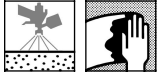


# Stadox VOC Nonstop Primer Surfacer U7580

## Product preparation - application STANDARD WET-ON-WET VOC



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



Bare steel sanded and cleaned - small repair areas only  
 Galvanised steel or aluminium, sanded and cleaned - small repair areas only  
 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  
 Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.



| Filler |        | Activator |        | Thinner     |        |
|--------|--------|-----------|--------|-------------|--------|
| Volume | Weight | Volume    | Weight | Volume      | Weight |
| 5      | 100    | 1         | 13     | 30 %        | 18     |
| U7580  |        | VOC 10-20 |        | VOC T 15-30 |        |
|        |        | VOC 20-25 |        | VOC T 30-40 |        |
|        |        | VOC 25-30 |        |             |        |
|        |        | VOC 30-40 |        |             |        |



Pot life at 20°C: 45 min - 1 hr 30 min



|                                 | Spray nozzle | Spray pressure |                      |
|---------------------------------|--------------|----------------|----------------------|
| Compliant                       | 1.3 - 1.4 mm | 1.5 - 2 bar    | inlet pressure       |
| HVLP                            | 1.3 - 1.4 mm | 0.7 bar        | atomisation pressure |
| see manufacturer's instructions |              |                |                      |



1 - 2 coats

final flash-off: 15 min - 8 hr



Basecoat + Clearcoat  
 Standocryl 2K Topcoats

VOC compliant

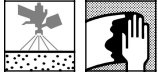
2004/42/IIB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

# Stadox VOC Nonstop Primer Surfacer U7580

## 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.



Bare steel sanded and cleaned - small repair areas only  
 Galvanised steel or aluminium, sanded and cleaned - small repair areas only  
 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  
 Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.



| Filler |        | Activator                                   |        | Thinner                    |         |
|--------|--------|---|--------|----------------------------|---------|
| Volume | Weight | Volume                                      | Weight | Volume                     | Weight  |
| 3      | 100    | 1   | 20     | 20 - 23 %                  | 14 - 16 |
| U7580  |        | HS 5-15<br>HS 15-25<br>HS 20-30<br>HS 25-40 |        | VOC T 15-30<br>VOC T 30-40 |         |



Pot life at 20°C: 45 min - 1 hr 30 min



|                                 | Spray nozzle | Spray pressure |                      |
|---------------------------------|--------------|----------------|----------------------|
| Compliant                       | 1.3 - 1.4 mm | 1.5 - 2 bar    | inlet pressure       |
| HVLP                            | 1.3 - 1.4 mm | 0.7 bar        | atomisation pressure |
| see manufacturer's instructions |              |                |                      |



1 - 2 coats

final flash-off: 15 min - 8 hr



Basecoat + Clearcoat  
 Standocryl 2K Topcoats

VOC compliant

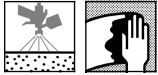
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# Stadox VOC Nonstop Primer Surfacer U7580

## Product preparation - application STANDARD SANDING VOC



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



Bare steel sanded and cleaned - small repair areas only  
 Galvanised steel or aluminium, sanded and cleaned - small repair areas only  
 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  
 Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.



| Filler |        | Activator  |        | Thinner                    |        |
|--------|--------|--|--------|----------------------------|--------|
| Volume | Weight | Volume   | Weight | Volume                     | Weight |
| 5      | 100    | 1  | 13     | 20 %                       | 12     |
| U7580  |        | VOC 10-20<br>VOC 20-25<br>VOC 25-30<br>VOC 30-40 |        | VOC T 15-30<br>VOC T 30-40 |        |



Pot life at 20°C: 45 min - 1 hr 30 min



|                                 | Spray nozzle | Spray pressure |                      |
|---------------------------------|--------------|----------------|----------------------|
| Compliant                       | 1.4 - 1.8 mm | 1.5 - 2 bar    | inlet pressure       |
| HVLP                            | 1.4 - 1.8 mm | 0.7 bar        | atomisation pressure |
| see manufacturer's instructions |              |                |                      |



2 - 3 coats intermediate and final flash-off: 5 min - 10 min



|            | VOC10-20/VOC20-25/VOC25-30/VOC30-40 |
|------------|-------------------------------------|
| 20 °C      | 12 hr - 16 hr                       |
| 60 - 65 °C | 25 min - 30 min                     |



Guideline for short wave IR equipment  
 Half power: 2 min  
 Full power: 8 min



P400 - P600



Basecoat + Clearcoat  
 Standocryl 2K Topcoats

VOC compliant

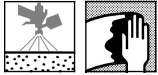
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# Stadox VOC Nonstop Primer Surfacer U7580

## 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.



Bare steel sanded and cleaned - small repair areas only  
 Galvanised steel or aluminium, sanded and cleaned - small repair areas only  
 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  
 Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.



| Filler |        | Activator                                   |        | Thinner                    |        |
|--------|--------|---|--------|----------------------------|--------|
| Volume | Weight | Volume                                      | Weight | Volume                     | Weight |
| 3      | 100    | 1   | 20     | 10 - 15 %                  | 7 - 10 |
| U7580  |        | HS 5-15<br>HS 15-25<br>HS 20-30<br>HS 25-40 |        | VOC T 15-30<br>VOC T 30-40 |        |



Pot life at 20°C: 45 min - 1 hr 30 min



|                                 | Spray nozzle | Spray pressure |                      |
|---------------------------------|--------------|----------------|----------------------|
| Compliant                       | 1.4 - 1.8 mm | 1.5 - 2 bar    | inlet pressure       |
| HVLP                            | 1.4 - 1.8 mm | 0.7 bar        | atomisation pressure |
| see manufacturer's instructions |              |                |                      |



2 - 3 coats intermediate and final flash-off: 5 min - 10 min



|            | HS5-15/HS15-25/HS20-30/HS25-40 |
|------------|--------------------------------|
| 20 °C      | 12 hr - 16 hr                  |
| 60 - 65 °C | 25 min - 30 min                |



Guideline for short wave IR equipment  
 Half power: 2 min  
 Full power: 8 min



P400 - P600



Basecoat + Clearcoat  
 Standocryl 2K Topcoats

VOC compliant

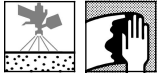
2004/42/IIB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

# Stadox VOC Nonstop Primer Surfacer U7580

## Product preparation - application STANDARD PLASTICS VOC



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.  
 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.  
 Remove thoroughly all traces of release agents.



| Filler |        | Activator  |        | Thinner |        |                                |        |
|--------|--------|--|--------|---------|--------|--------------------------------|--------|
| Volume | Weight | Volume   | Weight | Volume  | Weight | Volume                         | Weight |
| 5      | 100    | 1  | 13     | 40 %    | 26     | 0 - 10 %                       | 0 - 6  |
| U7580  |        | VOC 10-20<br>VOC 20-25<br>VOC 25-30<br>VOC 30-40 |        | U7590   |        | VOC T 15-30 *<br>VOC T 30-40 * |        |

\* If needed add 0-10% Stadox Thinner VOC T 15-30 or VOC T 30-40



Pot life at 20°C: 45 min - 1 hr 30 min



|           | Spray nozzle | Spray pressure |                      |
|-----------|--------------|----------------|----------------------|
| Compliant | 1.3 - 1.4 mm | 1.5 - 2 bar    | inlet pressure       |
| HVLP      | 1.3 - 1.4 mm | 0.7 bar        | atomisation pressure |

see manufacturer's instructions



1 - 2 coats

final flash-off: 15 min - 8 hr



Basecoat + Elastified Clearcoat  
 Elastified 2K Topcoat

VOC compliant

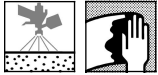
This product mix is out of scope for VOC directive

# Stadox VOC Nonstop Primer Surfacer U7580

## Product preparation - application STANDARD PLASTICS HS



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.  
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. Remove thoroughly all traces of release agents.



| Filler |        | Activator |        | Thinner |        |               |        |
|--------|--------|-----------|--------|---------|--------|---------------|--------|
| Volume | Weight | Volume    | Weight | Volume  | Weight | Volume        | Weight |
| 3      | 100    | 1         | 20     | 30 %    | 22     | 0 - 10 %      | 0 - 7  |
| U7580  |        | HS 5-15   |        | U7590   |        | VOC T 15-30 * |        |
|        |        | HS 15-25  |        |         |        | VOC T 30-40 * |        |
|        |        | HS 20-30  |        |         |        |               |        |
|        |        | HS 25-40  |        |         |        |               |        |

\* If needed add 0-10% Stadox Thinner VOC T 15-30 or VOC T 30-40



Pot life at 20°C: 45 min - 1 hr 30 min



|           | Spray nozzle | Spray pressure |                      |
|-----------|--------------|----------------|----------------------|
| Compliant | 1.3 - 1.4 mm | 1.5 - 2 bar    | inlet pressure       |
| HVLP      | 1.3 - 1.4 mm | 0.7 bar        | atomisation pressure |

see manufacturer's instructions



1 - 2 coats

final flash-off: 15 min - 8 hr



Basecoat + Elastified Clearcoat  
Elastified 2K Topcoat

VOC compliant

This product mix is out of scope for VOC directive

# Stadox VOC Nonstop Primer Surfacer U7580

## Products

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Stadox VOC Nonstop Primer Surfacer U7580

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Stadox Hardener HS 5-15

Stadox Hardener HS 15-25

Stadox Hardener HS 20-30

Stadox Hardener HS 25-40

Stadox Hardener VOC 10-20

Stadox Hardener VOC 20-25

Stadox Hardener VOC 25-30

Stadox Hardener VOC 30-40

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Stadox Thinner VOC 15-30

Stadox Thinner VOC 30-40

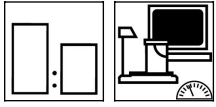
Stadox VOC Plastic Additive U7590

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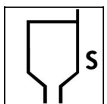
# Stadox VOC Nonstop Primer Surfacer U7580

## Product mix



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

|             |   |
|-------------|---|
| HS 5-15     | Accelerated fast hardener suitable for Micro and Spot repairs. Recommended for cooler application conditions. Suitable for Stadox Fillers for air drying at lower temperatures. |
| HS 15-25    | Medium hardener suitable for panel and multi panel repairs. Recommended for application temperature of 15-25°C.   |
| HS 20-30    | Medium-slow hardener suitable for medium to large size repairs. Recommended also for warm conditions e.g. 20-30°C.  |
| HS 25-40    | Non-accelerated slow hardener suitable for medium to large size repairs. Recommended for use in hot climates e.g. 25-40°C.  |
| VOC 10-20   | Accelerated fast hardener suitable for Micro Repair, spot and panel repairs. Recommended for cooler application conditions e.g. 10-20°C.  |
| VOC 20-25   | Medium hardener suitable for panel and multi panel repairs. Recommended for application temperature of 20-25°C.   |
| VOC 25-30   | Medium-slow hardener suitable for medium to large size repairs. Recommended also for warm conditions e.g. 25-30°C.  |
| VOC 30-40   | Non-accelerated slow hardener suitable for medium to large size repairs. Recommended for use in hot climates e.g. 30-40°C.  |
| VOC T 15-30 | Medium thinner suitable for panel, multi panel and large size repairs. Recommended for application temperature e.g. 15-30°C.  |
| VOC T 30-40 | Slow thinner for medium to large size repairs. Recommended for use in hot climates e.g. 30-40°C.  |



ISO 4: 37 - 68 s at 20°C  
DIN 4: 16 - 24 s at 20°C



30 - 50 µm non-sanding  
60 - 120 µm sanding



Clean after use with a suitable solventbased guncleaner.

# Stadox VOC Nonstop Primer Surfacer U7580

## Remarks

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- Material has to be at room temperature (18-25°C) before use.
- Allow additional time for preheating up to panel temperature.
- For **small** repairs areas only, VOC Nonstop Primer Surfacer U7580 can be applied direct to metal.
- For **large** bare metal steel, galvanized steel and soft aluminium areas, wash primer, epoxy primer or Stadox Express Prep Wipes U3000 must be applied prior to application of U7580.
- When using Acid Primer no IR drying is allowed.
- Non-sanding plastic primer-surfacer setting can also be used on adjacent non plastic panels.
- For air drying we recommend a minimum temperature of +15°C.
- Sanding version is limited to DFT max 100µm when used over Acid Primer.
- Surplus ready for use material should not be returned to original can.
- Mix thoroughly by hand before placing the can on mixing machine.
- Coated plastic car parts should not be washed with a high-pressure jet cleaner within the first six weeks. After this period, the nozzle must be held at a distance of no less than 30 cm from the object.
- In order to achieve elastic properties the use of Stadox Plasticiser is not required.
- Bare metal sand-through areas which needs to be overcoated with Stadox Polyester Spray Filler U1100 or Stadox Polyester Stopper, the fastest overcoatability can be achieved with Stadox HS Hardener 5-15 in mixing ratio 3:1 + 20-25% Stadox VOC Thinner. The flash off time before recoating with polyester products must be a minimum of 30-40 minutes at 20°C.
- Stadox VOC Nonstop Primer Surfacer U7580 Black and Light Grey can be mixed with each other to achieve various grey shades if desired.
- Stadox 2K Thinners can be used as alternatives for Stadox VOC Thinners in the same mixing ratios.
- In countries without VOC legislation the amount of thinner can be increased by 5% when preparing the product mix for wet-on-wet application on metal parts.
- For detailed information regarding suitable plastic substrates, please refer to the Stadox Plastic Painting System TDS - 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 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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