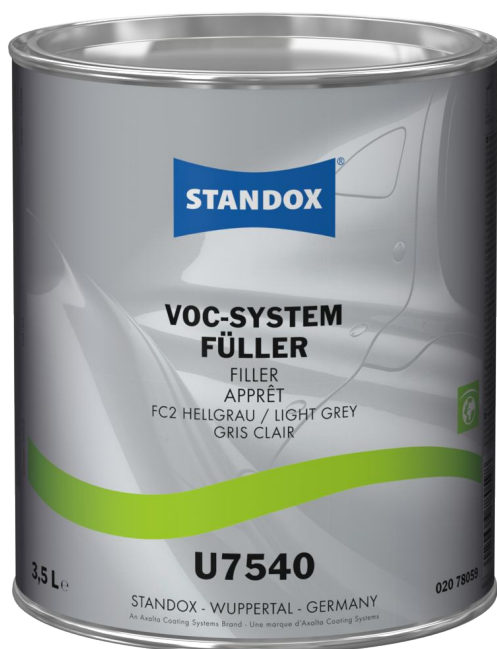


## Standex VOC System Filler U7540



Standex VOC System Filler U7540 offers high-performance and it very economical. It is chromate-free and ideal for universal use. It can easily be applied on almost any substrate, from factory primed substrates to sanded Standox polyester substrates. Standox VOC System Filler U7540 demonstrates extreme vertical stability, dries quickly, provides good build-up and cures very well. Even at high film thicknesses, the surface remains free of blisters. Its good filling properties ensure the surface is easy to sand, wet or dry, and provide excellent topcoat holdout, which helps to save time and money. It can be overcoated with high solid topcoats and conventional or waterborne basecoats.

- Easy to sand.
- Good filling properties.
- Good insulating properties.
- VOC compliant.
- Optimal topcoat holdout.
- Extremely high filling power thanks to the high solids content (70% when ready to use).
- Various hardening options: 4:1 with Standox HS Hardener or 7:1 with Standox VOC Hardener.



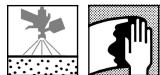
**The Art of Refinishing.**

# Stadox VOC System Filler U7540

## 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.



Acid Primer or epoxy primer  
 Old or original paintwork well sanded and cleaned  
 OEM Primer (e-coat), sanded and cleaned  
 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		Hardener		Thinner	
Volume	Weight	Volume	Weight	Volume	Weight
7	100	1	10	10 %	6
U7540		VOC 10-20 VOC 20-25 VOC 25-30 VOC 30-40		VOC T 15-30 VOC T 30-40	



Pot life at 20°C: 1 hr 30 min - 2 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.7	1.8 - 2.2 bar	inlet pressure
HVLP	1.4 - 1.7	0.7 bar	atomisation pressure
see manufacturer's instructions			



1 - 3 coats with intermediate and final flash-off until flat



	VOC10-20/VOC20-25/VOC25-30/VOC30-40
20 °C	3 hr - 4 hr
60 - 65 °C	30 min - 40 min



Guideline for short wave IR equipment  
 Half power: 5 min  
 Full power: 15 min



P400 - P500  
 P800 - P1000



Standocryl 2K Topcoats  
 Basecoat + Clearcoat

VOC compliant

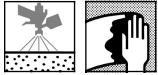
2004/42/IIB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

# Standex VOC System Filler U7540

## 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.



Acid Primer or epoxy primer  
 Old or original paintwork well sanded and cleaned  
 OEM Primer (e-coat), sanded and cleaned  
 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		Hardener		Thinner	
Volume	Weight	Volume	Weight	Volume	Weight
4	100	1	17	5 - 10 %	4 - 7
U7540		HS 5-15 HS 15-25 HS 20-30 HS 25-40		VOC T 15-30 VOC T 30-40	



Pot life at 20°C: 1 hr 30 min - 2 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.7	1.8 - 2.2 bar	inlet pressure
HVLP	1.4 - 1.7	0.7 bar	atomisation pressure

see manufacturer's instructions



1 - 3 coats with intermediate and final flash-off until flat



	HS5-15/HS15-25/HS20-30/HS25-40
20 °C	3 hr - 4 hr
60 - 65 °C	30 min - 40 min



Guideline for short wave IR equipment  
 Half power: 5 min  
 Full power: 15 min



P400 - P500  
 P800 - P1000



Standocryl 2K Topcoats  
 Basecoat + Clearcoat

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 System Filler U7540

## Products

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Stadox VOC System Filler U7540

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Stadox Hardener HS 15-25  
Stadox Hardener HS 20-30  
Stadox Hardener HS 25-40  
Stadox Hardener HS 5-15

Stadox Hardener VOC 10-20  
Stadox Hardener VOC 20-25  
Stadox Hardener VOC 25-30  
Stadox Hardener VOC 30-40

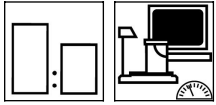
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Stadox Thinner VOC 15-30  
Stadox Thinner VOC 30-40

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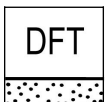
# Stadox VOC System Filler U7540

## Product mix



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

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.
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 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.



60 - 80 µm per coat

# Stadox VOC System Filler U7540

## Theoretical coverage



380 - 460 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 guncleaner.

## Remarks

- Material has to be at room temperature (18-25°C) before use.
- Mix thoroughly and put can on mixing machine.
- Allow additional time for preheating up to panel temperature.
- When isolating certain spots - even on problem substrates - the best results are achieved with a medium film thickness of 80-120µm in 2 coats, after either air drying overnight or force drying/IR drying. With problem substrates, careful pretreatment is necessary and the Filler must be applied to the entire area.
- For dry film thicknesses of more than 150 micron air dry overnight at 20°C or 40 minutes at 60-65°C.
- Surplus ready for use material should not be returned to original can.
- The filler can be mixed with maximum 15% Standocryl VOC Topcoat. Drying and sanding properties will change.
- In countries without VOC legislation Stadox Basecoat can be used as well.
- 15% of Stadox Plasticiser 5660 can be added to the Filler before adding hardener, but mixing ration will change.  
Mixed with Stadox Hardeners VOC - 4:1 + 10% Stadox Thinner VOC  
Mixed with Stadox Hardeners HS - 3:1 + 5-10% Stadox Thinner VOC

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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