

Standox VOC Xtreme Filler U7670

The first generation Standox VOC-Xtreme Fillers set the standard for productivity and performance. The Standox VOC Xtreme Filler U7670 builds on that. The streamlined offering combines sanding and wet-on-wet options in a single product requiring only one hardener. With its extraordinary air-drying performance, it enables bodyshops to free-up capacity, improve efficiency and reduce complexity.



- Streamlined two-in-one filler, combining sanding & wet-on-wet options in one product.
- Simple 1:1 mixing ratio.
- Excellent vertical stability and convenient application.
- Very impressive air-drying performance.
- Can be sanded after as little as 30 minutes air-dry time in sanding application.
- Wet-on-wet version can be overcoated after five minutes.
- Very flexible drying options: IR and low bake also possible for shortest drying times.
- Available in three colors: white, grey and black.
- For metal substrate pretreatment, the use of Express Prep Wipes U3000 is mandatory.

Part of the Standox Xtreme System. A revolutionary energy saving two-in-one filler with the highest productivity and excellent performance.

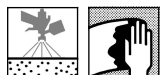


Standex VOC Xtreme Filler U7670

Product preparation - application STANDARD SANDING - 4660



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), sanded and cleaned.

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	55	10%	10
U7670		4660		U7610	
		4620*			

* Below 15°C & 30% RH, when drying is too slow, use Xtreme Filler Hardener Fast 4620.



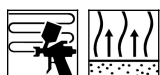
Potlife at 20°C: 30 min - 1 hr

* Setting with Xtreme Filler Hardener Fast 4620, apply within 30 min.



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	1 - 1.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	air cap pressure

see manufacturer's instructions



2 - 4 coats

until flat after the first coat, for the subsequent coats no flash-off is required



	Xtreme Filler Hardener
20 °C	30 min - 1 hr
40 - 45 °C	10 min - 15 min
60 - 65 °C	5 min - 10 min



Guideline for short wave IR equipment

Half power: 5 - 10 min



P500 - P600



Standoblue Basecoat / Standoflow Basecoat + Clearcoat

Basecoat + Clearcoat

2K Topcoat

For best product performance sand and clean prior to overcoating. If left unsanded, no storage limitation applies - sand and clean before overcoating.

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 Xtreme Filler U7670

Product preparation - application STANDARD SANDING HIGH BUILD - 4660



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), sanded and cleaned.

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	55	10%	10
U7670		4660		U7610	
		4620*			

* Below 15°C & 30% RH, when drying is too slow, use Xtreme Filler Hardener Fast 4620.



Potlife at 20°C: 30 min - 1 hr

* Setting with Xtreme Filler Hardener Fast 4620, apply within 30 min.



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	1 - 1.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	air cap pressure

see manufacturer's instructions



2 - 4 coats

First coat flashed till flat: 2 min - 5 min
with intermediate flash-off: 1 min - 2 min



	Xtreme Filler Hardener
20 °C	45 min - 1 hr
40 - 45 °C	10 min - 15 min
60 - 65 °C	5 min - 10 min



Guideline for short wave IR equipment
Half power: 5 - 10 min



P500 - P600



Standoblue Basecoat / Standoflow Basecoat + Clearcoat
Standex Basecoat + Clearcoat
2K Topcoat

For best product performance sand and clean prior to overcoating. If left unsanded, no storage limitation applies - sand and clean before overcoating.

VOC compliant

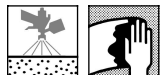
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Standex VOC Xtreme Filler U7670

Product preparation - application STANDARD SANDING PLASTIC - 4660



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	55	20%	20
U7670		4660		U7660	



Potlife at 20°C: 30 min - 1 hr

* Setting with Xtreme Filler Hardener Fast 4620, apply within 30 min.



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	1.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	air cap pressure

see manufacturer's instructions



2 - 3 coats
until flat after the first coat, for the subsequent coats no flash-off is required



	Xtreme Filler Hardener
20 °C	30 min - 1 hr
40 - 45 °C	10 min - 15 min
60 - 65 °C	5 min - 10 min

P500 - P600



Standoblue Basecoat / Standoflow Basecoat + Elastified Clearcoat
Basecoat + Elastified Clearcoat
Elastified 2K Topcoat

For best product performance sand and clean prior to overcoating. If left unsanded, no storage limitation applies - sand and clean before overcoating.

VOC compliant

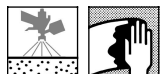
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Standex VOC Xtreme Filler U7670

Product preparation - application STANDARD WET-ON-WET - 4660



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	55	10%	10
U7670		4660		U7610 VOC T 30-40 *	

* At climate above 25°C / 50% rel. humidity use VOC T 30-40 instead of U7610.

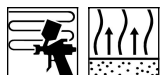


Potlife at 20°C: 30 min - 1 hr



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

see manufacturer's instructions



1 - 2 coats

final flash-off: 5 min - 8 hr



Very early denibbing at the earliest after 5 min possible.



Standoblue Basecoat / Standoflow Basecoat + Clearcoat
Basecoat + Clearcoat
2K Topcoat

VOC compliant

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Standex VOC Xtreme Filler U7670

Product preparation - application STANDARD WET-ON-WET PLASTICS - 4660



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	55	20%	20
U7670		4660		U7660	

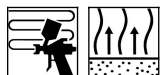


Potlife at 20°C: 30 min - 1 hr



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

see manufacturer's instructions



1 - 2 coats

final flash-off: 5 min - 8 hr



Very early denibbing at the earliest after 5 min possible.



Standoblue Basecoat / Standoflow Basecoat + Elastified Clearcoat
Basecoat + Elastified Clearcoat
Elastified 2K Topcoat

VOC compliant

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Standex VOC Xtreme Filler U7670

Product preparation - application STANDARD SANDING - 4575/4570



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), sanded and cleaned.

Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.



Filler		Hardener		Thinner/Additive/Accelerator	
Volume	Weight	Volume	Weight	Volume	Weight
2	100	1	29	30 - 40%	23 - 30
U7670		4575		U7610	
		4570			



Potlife at 20°C: 30 min - 1 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	1 - 1.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	air cap pressure

see manufacturer's instructions



2 - 4 coats

until flat after the first coat, for the subsequent coats no flash-off is required



	Xtreme Hardeners
20 °C	45 min - 1 hr 15 min
40 - 45 °C	15 min - 20 min
60 - 65 °C	10 min - 15 min



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



P500 - P600



Standoblue Basecoat / Standoflow Basecoat + Clearcoat

Basecoat + Clearcoat

2K Topcoat

For best product performance sand and clean prior to overcoating. If left unsanded, no storage limitation applies - sand and clean before overcoating.

VOC compliant

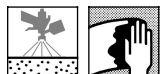
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Standex VOC Xtreme Filler U7670

Product preparation - application STANDARD WET-ON-WET - 4575



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
2	100	1	29	30 - 40%	23 - 30
U7670		4575		U7610	



Potlife at 20°C: 30 min - 1 hr



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

see manufacturer's instructions



1 - 2 coats

final flash-off: 5 min - 8 hr



Very early denibbing at the earliest after 15 min possible.



Standoblue Basecoat / Standoflow Basecoat + Clearcoat
Basecoat + Clearcoat
2K Topcoat

VOC compliant

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Standex VOC Xtreme Filler U7670

Product preparation - application STANDARD SANDING PLASTIC - 4575/4570



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		Additive		Thinner	
Volume	Weight	Volume	Weight	Volume	Weight	Volume	Weight
2	100	1	29	25%	19	25%	19
U7670		4575 4570		U7660		VOC T15-30	



Potlife at 20°C: 30 min - 1 hr



	Spray nozzle	Spray pressure	
Compliant	1.4 - 1.6	1.5 bar	inlet pressure
HVLP	1.4 - 1.6	0.7 bar	air cap pressure

see manufacturer's instructions



2 - 3 coats
until flat after the first coat, for the subsequent coats no flash-off is required



	Xtreme Hardeners
20 °C	45 min - 1 hr 15 min
40 - 45 °C	15 min - 20 min
60 - 65 °C	10 min - 15 min



P500 - P600



Standoblue Basecoat / Standoflow Basecoat + Elastified Clearcoat
Basecoat + Elastified Clearcoat
Elastified 2K Topcoat

For best product performance sand and clean prior to overcoating. If left unsanded, no storage limitation applies - sand and clean before overcoating.

VOC compliant

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Standex VOC Xtreme Filler U7670

Product preparation - application STANDARD WET-ON-WET PLASTICS - 4575



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		Additive		Thinner	
Volume	Weight	Volume	Weight	Volume	Weight	Volume	Weight
2	100	1	29	25%	19	25%	19
U7670		4575		U7660		VOC T15-30	

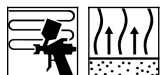


Potlife at 20°C: 30 min - 1 hr



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

see manufacturer's instructions



1 - 2 coats

final flash-off: 5 min - 8 hr



Very early denibbing at the earliest after 15 min possible.



Standoblue Basecoat / Standoflow Basecoat + Elastified Clearcoat
Basecoat + Elastified Clearcoat
Elastified 2K Topcoat

VOC compliant

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Standex VOC Xtreme Filler U7670

Products

Standex VOC Xtreme Filler U7670 White

Standex VOC Xtreme Filler U7670 Grey

Standex VOC Xtreme Filler U7670 Black

Standex Xtreme Filler Hardener 4660

Standex Xtreme Filler Hardener Fast 4620

Standex Xtreme Hardener Fast 4570

Standex Xtreme Hardener Medium Fast 4575

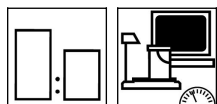
Standex Xtreme Filler Accelerator U7610

Standex VOC Xtreme Plastic Additive U7660

Standex Thinner VOC 15-30

Standex Thinner VOC 30-40

Product mix

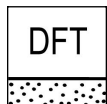


Mixing ratios with special agents are available in the productmix table on Standwin IQ and in the specific TDS.

The choice of hardener and Thinner should be made according to application temperature and size of repair.

4660	Xtreme Filler Hardener is a dedicated hardener to be used in VOC Xtreme Filler only. It can be used for all type of repairs and under any climate condition and any drying option.
4620	Xtreme Filler Hardener fast 4620 is a dedicated hardener to be used in VOC Xtreme Fillers only. It accelerates the curing performance and is to be used in cold and dry weather <15°C / <30% R.H. only.
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 Fillers to provide direct to plastic refinishing properties
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.

Standex VOC Xtreme Filler U7670



80 - 150 µm Sanding
120 - 250 µm Sanding High Build
80 - 150 µm Sanding Plastics
25 - 50 µm Wet-on-Wet

Theoretical coverage

380 - 385 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.

Remarks

- Mix thoroughly by hand before placing the can on mixing machine.
- Humidity has an accelerating influence on the drying performance and potlife.
- The use of the Standox Express Prep Wipes U3000 is mandatory for bare metal substrates. Non-use can be detected analytically.
- Material has to be at room temperature (18-25°C) before use.
- Can also be applied with short intermediate flash-off time to isolate Stopper repairs and sensitive prep work.
- Surplus material should not be returned to the original can.
- Very early sanding will be achieved with premium / flexible sanding discs.
- Sandable as of 30 min depending on the humidity / temperature and dry film thickness.
- After usage all cans must be closed immediately.
- If required, for large areas up to 5% thinner can be added to the mixed material.
- If Standox VOC Xtreme Filler U7670 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.
- For improved adhesion properties, particularly on critical plastic substrates such as e.g. PP, the use of Standoflex Plastic Adhesion Primer U3070/U3070S prior the application of VOC Xtreme Filler U7670 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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