

Standox VOC Xtreme Filler U7600



Based on new chemistry, the VOC Xtreme Filler U7600 from Standox is a revolutionary product that provides a significant improvement in the preparation process. The filler is applied in a single spray process (One Visit Application). With a very impressive air-drying performance it is suitable for all bodyshops who want to free-up capacity for additional work and to improve efficiency.

- Simple 1:1 mixing ratio with Standox Xtreme Filler Hardener.
- Convenient application with excellent vertical stability.
- One Visit Application – up to four coats.
- Super smooth flow directly from the spray gun.
- Very impressive air-drying performance. It can be sanded from as early as *20 minutes air-dry time. (*dependant on local climate conditions).
- Very flexible drying options; IR and low bake also possible with shortest drying times.
- Micro Repair, panel and multi panel repairs, in fact any type of repair of any size can be handled at the same time, thanks to air-drying.
- Provides outstanding gloss hold-out after top coating.
- Available in three colours: white, grey and black.
- For metal substrate pretreatment use of Express Prep Wipes U3000 is mandatory.
- VOC Xtreme Filler and Express Prep Wipes are the foundation of the Standox 1 Day Repair concept.
- 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, fast drying filler.



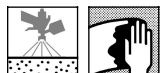
The Art of Refinishing.

Standex VOC Xtreme Filler U7600

Product preparation - application STANDARD SANDING



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 Standex 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



Surfacer		Additive		Hardener		Accelerator	
Volume	Weight	Volume	Weight	Volume	Weight	Volume	Weight
1	100	10%	6	1	60	10%	10
U7600		Elastic-Additiv 5660		4600 4620*		U7610	

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



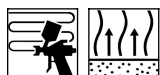
Pot life at 20°C: 30 min - 1 hr

* 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	20 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



Overcoating within 24 hours is recommended. (up to 72hrs maximum)
Standoblue Basecoat + all Standex Clearcoats
Standocryl VOC 2K Topcoat

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 U7600

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.



Surfacer		Hardener		Accelerator	
Volume	Weight	Volume	Weight	Volume	Weight
1	100	1	55	20%	20
U7600		4600		U7660	
		4620*			

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



Pot life 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	atomisation 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	20 min - 1 hr
40 - 45 °C	10 min - 15 min
60 - 65 °C	5 min - 10 min

P500 - P600



Overcoating within 24hrs is recommended (up to 72 hours maximum if using 5660 - refer remarks)

Elastified Standocryl VOC 2K Topcoat

Standoblue Basecoat + Elastified Standox Clearcoats.

VOC compliant

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Products

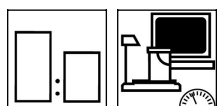
Standex VOC Xtreme Filler U7600

Standex Xtreme Filler Hardener 4600
Standex Xtreme Filler Hardener Fast 4620

Standex Thinner VOC 15-30
Standex Thinner VOC 30-40
Standex Xtreme Filler Accelerator U7610

Standex VOC Xtreme Plastic Additive U7660
Standex Plasticiser 5660

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.

4600	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 Filler U7600 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 Filler U7600 and VOC Xtreme Wet-on-wet Filler U7650 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.

DFT

80 - 150 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.



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Remarks

- Mix thoroughly by hand before placing the can on mixing machine.
 - Humidity has an accelerating influence on the drying performance and potlife.
 - Do not use Acid Primer under VOC Xtreme Filler U7600.
 - 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.
 - Surplus ready for use material should not be returned to original can.
 - Very early sanding will be achieved with premium / flexible sanding discs.
 - Sandable as of 20 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 VOC Xtreme Filler U7600 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 Primer U3060 prior the application of VOC Xtreme Filler U7600 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.**
 - If VOC Xtreme Filler U7600 film builds are likely to exceed 120 microns on plastic parts or the topcoat window is extended to the maximum 72hrs permissible, the use of 10% plasticisor 5660 is required before the addition of plastic additive U7660.
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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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