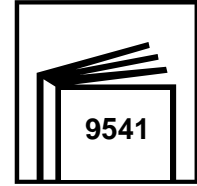


Standex® UV Filler



Ordering Information:		
1 Liter	UV Filler	020 16235
14 oz.	UV Filler Aerosol	020 16236

Features:

- ✧ Chromate free
- ✧ Excellent filling properties
- ✧ Ready to sand immediately after cure
- ✧ VOC compliant in both regulated areas and the US National Rule

Working Process: UV Priming System	
Substrates:	
<ul style="list-style-type: none"> ✓ Through-hardened, sanded paintwork ✓ Sanded, solvent resistant OEM primers used on replacement parts ✓ Bare metal, galvanized metal, and aluminum; sanded ✓ Standex Primers ✓ Standex 2K EP Primer Surfacer/2K EP Primer Aerosol ✓ Standoflex Plastic Primer Silver/Plastic Primer Silver Aerosol 	
	For substrate preparation information see Standex Painting System S1!
	Ready To Spray – No reduction recommended Potlife – Unlimited when properly stored (see Important Technical Remarks)
	Aerosol: 2 – 3 coats, Flash 1 minute between coats Do not spray to opacity.
	1.3 - 1.4 mm Please refer to gun manufacturer and local legislation for proper spray pressure recommendations. Using reduced air pressures may result in higher film build which affects the ability of the UV primer to cure. 2 coats = 4.0 – 5.0 mil (100 – 130 microns) Do not spray to opacity. Flash 1 minute between coats
	1.3 - 1.4 mm Please refer to gun manufacturer and local legislation for proper spray pressure recommendations. Using reduced air pressures may result in higher film build which affects the ability of the UV primer to cure. 2 coats = 4.0 – 5.0 mil (100 – 130 microns) Do not spray to opacity. Flash 1 minute between coats.
	Flash off 3 min/ 68°F (20°C) before UV cure
	See UV Cure instructions in Important Technical Remarks section below
	Orbital sand P500-P800 Wet sand P600-P800
	Standocryl® 2K Paints or Standex Basecoat / Standoblue® Basecoat

Standex[®] UV Filler

Important Technical Remarks:

- **Standex** UV Filler should be shaken and stirred before each use. If allowed to sit more than 15 minutes, material should be stirred again.
- Do not place **Standex** UV Filler on a mixing machine if it cannot be used within two weeks.
- **Standex** UV Filler is semi-transparent. Spraying to full opacity will not allow the primer to cure because of excessive film thickness.
- It is important to use the recommended air pressures. Using reduced air pressures may result in higher film build which affects the ability of the UV primer to cure.
- Because working with UV light equipment may pose potential safety and related hazards, we recommend following all instructions for use provided by the equipment manufacturers.
- **Standex** UV Filler should not be cured with outdoor UV exposure.
- The UV wand/lamp should be turned on when it is time to apply the first coat of **Standex** UV Filler. This will ensure that the light has been warmed up properly and is ready for the curing process.
- When using the Axalta UV LightCoat™ 2,400 E-5287 wand/lamp, make 3 passes over the UV primer using a technique similar to painting with a cross coat method. Make sure the light-to-panel distance is 3-6 inches and use a 50 - 75% overlap.
- When using the Axalta UV LightCoat™ Mini E-5294 wand/lamp, make 5 passes over the UV primer using a technique similar to painting with a cross coat method. Make sure the light-to-panel distance is 3-6 inches and use a 50 - 75% overlap.
- Passing the UV wand/lamp over the primed surface, moldings, plastic trim, lights, or etc. too slowly may result in panel temperatures over 180°F. Avoid overheating the UV primed panel during the curing process.
- For best results, cure rate may be verified using a Dosimeter. 100 mJ/cm² of UV exposure is required per mil of dry film build to ensure cure of the **Standex** UV Filler.
- **Standex** UV Filler should not be stored in transparent containers (mix cups, PPS cups, or spray guns with clear air caps).
- **Standex** UV Filler can be used all day in the gun or opaque cup. It is recommended that the UV primer be poured back into the can. Cleaning the gun after each use is not required.
- Sanding is required before recoating. Using a Guide Coat when sanding is recommended. Apply using an outside-in technique. You may sand **Standex** UV Filler once the cured primer filler has cooled down.
- Use a **Standex** Etch Primer on all bare metal for Warranty compliance.

UV Cure Table				
New UV Wand/Lamp	Required Exposure	# of Passes	% Overlap	Distance to the Primed Surface (Inches)
Axalta UV LightCoat™ 2,400 E-5287	100 mJ/cm ² per mil of dry film build	3	50 - 75	3 - 6
Axalta UV LightCoat™ Mini E-5294	100 mJ/cm ² per mil of dry film build	5	50 - 75	3 - 6

UV Cure Table			
UV Lamp	Distance to the Primed Surface (Inches)	Cure Area	Cure Time
400 Watt Lamp	15 inches	10" x 10"	90 seconds
1200 Watt Lamp	10 inches	10" x 10"	60 seconds
1200 Watt Lamp	15 inches	16" x 16"	120 seconds

Important Legislative Remarks:

- Please see the appropriate VOC Wallchart for compliance for your area. The values depicted below are “ready to spray”.

Coating Category: Auto Body Primer - Maximum 80% VOC and 0.95 MIR

Avg. Gallon Weight: 912 g/l; 7.61 lbs/gal

Avg. Weight % Volatiles: 62.8%

Avg. Weight % Water: 0.0%

Avg. Weight % Exempt Solvent: 21.6 %

Avg. Volume % Water: 0.0%

Avg. Volume % Exempt Solvent: 24.9%

Theoretical Coverage: 363.4 sq. ft. @ 1 mil

Theoretical Coverage @ Recommended Film Build: 73 - 91 sq. ft.

Coating Category: Primer

Avg. VOC AP: 165 g/l; 1.4 lbs/gal

Avg. VOC LE: 249 g/l; 2.1 lbs/gal

Avg. Gallon Weight: 1142 g/l; 9.53 lbs/gal

Avg. Weight % Volatiles: 38.2%

Avg. Weight % Water: 0.0%

Avg. Weight % Exempt Solvent: 23.8%

Avg. Volume % Water: 0.0%

Avg. Volume % Exempt Solvent: 33.9%

Theoretical Coverage: 755 sq. ft. @ 1 mil

Theoretical Coverage @ Recommended Film Build: 157 - 197 sq. ft.

- **For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components. Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates. Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.**
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