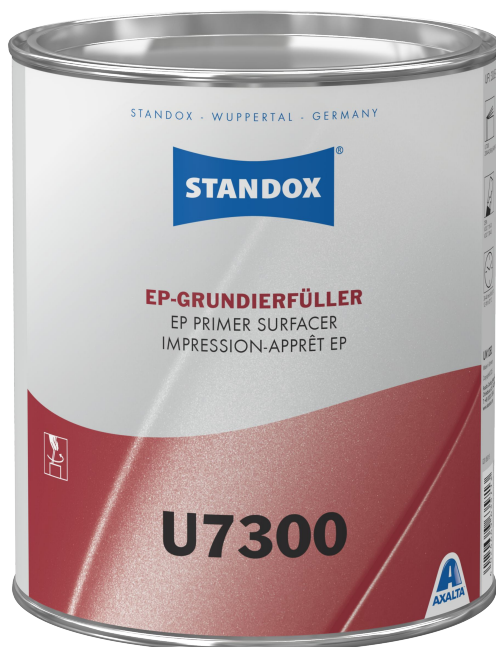


Standox EP Primer Surfacer U7300

Standox EP Primer Surfacer U7300 is an epoxy-based, universal, zinc chromate-free primer surfacer that provides good corrosion protection and adhesion for steel and galvanised substrates.



- Allows for easy application.
- Suitable for use as a wet-on-wet and sanding surfacer.
- Good insulation effect.
- Suitable for IR drying.
- Good storage durability.
- Universal epoxy-based primer surfacer.
- Mix 5:1 with EP Hardener U7310.
- Classic epoxy-resin-based primer surfacer with very good technical properties.



Standex EP Primer Surfacer U7300

Product preparation - application STANDARD SANDING



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



Bare steel sanded and cleaned

Galvanised steel or aluminium sanded and cleaned

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 polyester substrates, free of release agents, sanded and cleaned.



| Primer surfacer | | Hardener | | Thinner | | | |
|-----------------|--------|----------|--------|---------|--------|----------|--------|
| Volume | Weight | Volume | Weight | Volume | Weight | Volume | Weight |
| 5 | 100 | 1 | 11 | 25% | 16 | 20% | 13 |
| U7300 | | U7310 | | VOC T | | 2K 10-20 | |
| | | | | 15-30 | | 2K 15-25 | |
| | | | | VOC T | | 2K 20-25 | |
| | | | | 30-40 | | 2K 25-35 | |
| | | | | | | 2K 35-40 | |

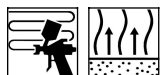


Potlife at 20°C: 6 hr



| | Spray nozzle | Spray pressure | |
|-----------|--------------|----------------|----------------------|
| Compliant | 1.3 - 1.6 | 1.5 - 2 bar | inlet pressure |
| HVLP | 1.3 - 1.6 | 0.7 bar | atomisation pressure |

see manufacturer's instructions



2 - 3 coats

with intermediate flash-off: 5 min - 10 min
before bake: 5 min - 10 min



| | U7310 / VOC T / 2K Thinner |
|------------|----------------------------|
| 20 °C | 12 hr - 16 hr |
| 60 - 65 °C | 30 min - 40 min |



Guideline for short wave IR equipment

Half power: 3 - 5 min

Full power: 12 - 15 min



P400 - P600



2K Topcoat

Standoblue Basecoat / Standohyd Plus Basecoat + Clearcoat

Basecoat + Clearcoat

Polyester products

VOC compliant

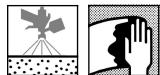
2004/42/IIB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

Standex EP Primer Surfacer U7300

Product preparation - application STANDARD WET-ON-WET



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



Bare steel sanded and cleaned
Galvanised steel or aluminium sanded and cleaned
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.



| Primer surfacer | | Hardener | | Thinner | | | |
|-----------------|--------|----------|--------|---------|--------|----------|--------|
| Volume | Weight | Volume | Weight | Volume | Weight | Volume | Weight |
| 5 | 100 | 1 | 11 | 25% | 16 | 20% | 13 |
| U7300 | | U7310 | | VOC T | | 2K 10-20 | |
| | | | | 15-30 | | 2K 15-25 | |
| | | | | VOC T | | 2K 20-25 | |
| | | | | 30-40 | | 2K 25-35 | |
| | | | | | | 2K 35-40 | |



Potlife at 20°C: 6 hr



| | Spray nozzle | Spray pressure | |
|-----------|--------------|----------------|------------------|
| Compliant | 1.3 - 1.6 | 1.5 - 2 bar | inlet pressure |
| HVLP | 1.3 - 1.6 | 0.7 bar | air cap pressure |

see manufacturer's instructions



| Primer | | Primer-surfacer | |
|--------|--------------------------------|-----------------|---|
| 1 coat | final flash-off: 30 min - 2 hr | 1 - 2 coats | with intermediate flash-off: 5 min - 10 min final flash-off: 1 hr - 2 hr |



| Primer | Primer-surfacer |
|-----------|---|
| 2K Filler | 2K Topcoat Standoblue Basecoat / Standohyd Plus Basecoat + Clearcoat Standex Basecoat + Clearcoat |

VOC compliant

2004/42/IIB(C) 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 EP Primer Surfacer U7300

Products

Standex EP Primer Surfacer U7300

Standex EP Hardener U7310

Standex Thinner VOC 15-30

Standex Thinner VOC 30-40

Standex Thinner 2K 10-20

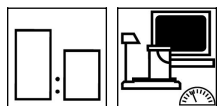
Standex Thinner 2K 15-25

Standex Thinner 2K 20-25

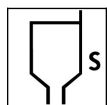
Standex Thinner 2K 25-35

Standex Thinner 2K 35-40

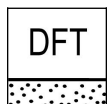
Product mix



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



DIN 4: 16 - 19 s at 20°C



60 - 110 µm sanding
20 - 30 µm non-sanding

**Theoretical
coverage**

375 - 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.

Standex EP Primer Surfacer U7300

Remarks

- Material has to be at room temperature (18-25°C) before use.
 - Allow additional time for preheating up to panel temperature.
 - Surplus ready for use material should not be returned to original can.
 - Can not be applied over acid containing primers.
 - Polyester putties can be applied over cured and sanded epoxy primer-surfacers.
 - Mix thoroughly by hand before placing the can on mixing machine.
 - With regard to elastifying properties, the use of Standox Plasticiser is not allowed.
-

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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