

## VOC-Xtreme Wet-on-Wet Filler U7650

Based on patented, innovative Axalta chemistry, the Standox VOC Xtreme Wet-on-Wet Filler U7650 is a revolutionary product. It enhances and completes the Standox Xtreme System as the fastest Wet-on-Wet Filler in the car refinishing industry. With a very impressive final flash-off time of five minutes, it is suitable for bodyshops who want the highest efficiency and outstanding gloss hold-out for new spare parts.



- Simple 1:1 +10% mixing ratio with Standox Xtreme Wet-on-Wet Filler Hardener 4650 and Standox Xtreme Filler Accelerator U7610.
- Most efficient and easy One Visit Application process in up to two coats.
- Provides excellent vertical stability and very smooth flow directly from the spray gun.
- After five minutes it can be overcoated with Standoblue basecoat or if needed it can be slightly denibbed (removal of dust inclusions).
- The new technology offers outstanding gloss hold-out after top coating.
- Available in three colours: white FC1, grey FC2 and black FC3.
- For metal substrate pre-treatment, the use of Standox Express Prep Wipes U3000 is mandatory, delivering an easy and convenient priming process without using wet products.
- The innovative Xtreme System is the foundation of the Standox 1Day Repair concept and stands out as the shortest repair process with significant energy cost savings.

**Revolutionary Xtreme technology, fastest Wet-on-Wet Filler in the car refinishing industry.**



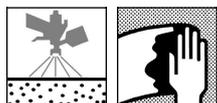
**The Art of Refinishing.**

# VOC-Xtreme Wet-on-Wet Filler U7650

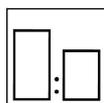
## Product preparation - application STANDARD WET-ON-WET



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

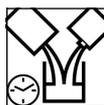


Steel, galvanised steel and soft aluminium, sanded and cleaned, treated with Standox Express Prep Wipes U3000  
 Old or original paintwork well sanded and cleaned  
 OEM Primer (e-coat), scuff sanded and cleaned  
 Surfaces pretreated with 2K polyester products and then finely sanded and cleaned



Filler		Additive		Hardener		Thinner	
Volume	Weight	Volume	Weight	Volume	Weight	Volume	Weight
1	100	10%	7	1	65	10%	12
U7650		5660		4650		U7610 VOC T 30-40 *	

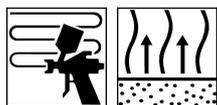
\* At climate above 30°C / 50% rel. humidity use VOC T 30-40 instead of U7610.



at 20°C: 30 min - 1 hr

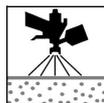


	Spray nozzle	Spray pressure	
HVLP	1.3 - 1.6 mm	0.7 bar	air cap pressure
Compliant	1.3 - 1.6 mm	1.5 - 1.8 bar	inlet pressure
see manufacturer's instructions			



1 - 2 coats

final flash-off: 5 min - 8 hr



Standoblue Basecoat + Clearcoat  
 Standocryl VOC Topcoat  
 Activated Standoblue Basecoat + Standocryl VOC Xtreme Clear K9580

VOC compliant

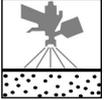
2004/42/IIB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

# VOC-Xtreme Wet-on-Wet Filler U7650

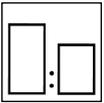
## Product preparation - application STANDARD ELASTIC



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.  
 Glass fibre polyester substrates, free of release agents, sanded and cleaned.  
 Plastic substrates coated with Standoflex Plastic Primer U3060.



Filler		Additive		Hardener		Thinner	
Volume	Weight	Volume	Weight	Volume	Weight	Volume	Weight
1	100	10%	7	1	65	10%	12
U7650		5660		4650		U7610 VOC T 30-40 *	

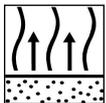
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at 20°C: 30 min - 1 hr

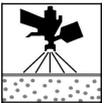


	Spray nozzle	Spray pressure	
HVLP	1.3 - 1.6 mm	0.7 bar	air cap pressure
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1 - 2 coats

final flash-off: 5 min - 8 hr



Standoblue Basecoat + Elastified Clearcoat  
 Elastified Standocryl VOC Topcoat  
 Activated Standoblue Basecoat + Standocryl VOC Xtreme Clear K9580

VOC compliant

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## Products

Standex VOC-Xtreme Wet-on-Wet Filler U7650

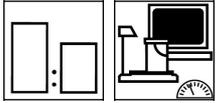
Standex Plasticiser 5660

Standex VOC Xtreme Wet-on-Wet Filler Hardener 4650

Standex Xtreme Filler Accelerator U7610

Standex Thinner VOC 30-40

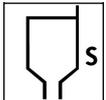
## Product mix



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

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

4650	Xtreme Wet-on-Wet Filler Hardener is a dedicated hardener to be used in VOC Xtreme Wet-on-Wet Filler U7650 only. It can be used for all type of wet-on-wet repairs of new panels in PC segment and under most climate conditions.
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.
VOC T 30-40	Slow thinner for multiple panels up to full resprays. Mainly to be used at higher temperatures of 30-40°C.



DIN 4: 13 - 14 s at 20°C



25 - 50 µm



Clean after use with a suitable solventbased guncleaner.

## Remarks

- No Acid Primer or 2K EP Primer-Surfacers under VOC Xtreme WOW Filler U7650 allowed.
- The use of the Standox Express Prep Wipes U3000 is mandatory for bare metal substrates. Non-use can be detected analytically.
- Elastification is mandatory for rigid & half rigid types of plastics.
- Non-sanding plastic surfacer setting can also be used on adjacent non plastic panels.
- Very early denibbing at the earliest after 5 min possible.
- After usage all cans must be closed immediately.
- Material has to be at room temperature (18-25°C) before use.
- Humidity has an accelerating influence on the drying performance and potlife.

# VOC-Xtreme Wet-on-Wet Filler U7650

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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