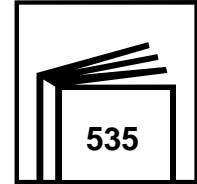




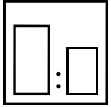
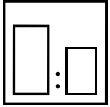






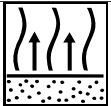
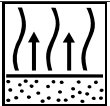




Standex® 2K Nonstop Primer Filler



Ordering Information:		
3.5 Liter	Medium Gray	020 15331
3.5 Liter	Dark Gray	020 16153
3.5 Liter	White	020 16154

Features:

- ✧ Available in 3 colors
- ✧ Outstanding Isolating properties
- ✧ Wet-on-wet or sanding application

Working Process: 3:1 Adhesion Promoter	Working Process: Sanding Filler / Isolator
Substrates: <ul style="list-style-type: none"> ✓ Solvent resistant OEM primers used on replacement parts Solvent test E-coat primers to determine suitability of this procedure.	Substrates: <ul style="list-style-type: none"> ✓ Through-hardened, sanded paintwork ✓ Sanded, solvent resistant OEM primers used on replacement parts ✓ Standex Primers ✓ TPA and critical substrates ✓ Standex Polyesters, sanded
 For substrate preparation information see Standex Painting System S1!	 For substrate preparation information see Standex Painting System S1!
 3:1 with Standex 2K Hardeners (05-15, 15-25, 20-30, 25-40) potlife 30 min/68°F (20°C)	 3:1 with Standex 2K Hardeners (05-15, 15-25, 20-30, 25-40, 30-45) potlife 30 min/68°F (20°C)
 30% Standex 2K Thinner 14-16 s/DIN 4 mm/68°F (20°C)	 15-20% Standex 2K Thinner 20-25 s/DIN 4 mm/68°F (20°C) 25% for Isolation
 1.3 - 1.4 mm 1-1.5 coats = 0.8-1.2 mil (20-30 micron) Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.	 1.4 - 1.7 mm 2-3 coats = 2.4-3.6 mil (60-120 micron) Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.
 1.2 - 1.3 mm 1-1.5 coats = 0.8-1.2 mil (20-30 micron) Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.	 1.4 - 1.7 mm 2-3 coats = 2.4-3.6 mil (60-120 micron) Please refer to gun manufacturer and local legislation for proper spray pressure recommendations.
 Flash off 15-20 min/68°F (20°C) *Before overcoating with Standohyd ® Basecoat, flash off at least 20 minutes.	 Flash off handslick 10-15 min/68°F (20°C) between coats.
 Standocryl ® 2K Paints or Standex Basecoat/ Standohyd Basecoat with Standocryl 2K Clears	 Air dry overnight/68°F (20°C) or 30 min/140°F (60°C) panel temperature or 60 min/120°F (48°C) panel temperature for isolating procedures
	 P800 (recommended for isolation) P400-P500 Orbital sander
	 Standocryl 2K Paints or Standex Basecoat/ Standohyd Basecoat with Standocryl 2K Clears

Standex[®] 2K Nonstop Primer Filler

Important Technical Remarks:

- Overcoat **Standex** 2K Nonstop Primer Filler within 45 minutes at 68°F (20°C) for maximum adhesion. After 45 minutes **Standex** 2K Nonstop Primer Filler must be sanded before overcoating.
- Do not use infrared drying for TPA or critical substrates not resistant to solvents.
- Unsanded replacement parts primed with solvent-resistant E-coat primer can be directly coated with this product after **thoroughly** cleaning with **Standex** Silicone Remover Antistatic/**Standohyd**[®] Silicone Remover 0.4/**Standohyd** Cleaner and a scuff pad.
- OEM E-coat must be sealed or primed to meet the **Standex** Lifetime Warranty Program requirements.
- Facilities enrolled in the **Standex** Lifetime Warranty Program are required to first use a **Standex** Etch Primer on all bare metal.
- 2K Thinner 30-45 may not be used in this product when used as a wet-on-wet sealer. When this product is used as a wet-on-wet sealer the mix ratio is 3:1+20%.
- For plastic refinishing, mix with 15-30% **Standex** 2K Plasticiser. If plasticised, do not store on mixing bank. Mix only before use. For structure recommendations in conjunction with **Standohyd** Basecoat, please see TDS 597.

OEM-Primed Replacement Bumpers (Wet-on-Wet) (See Plastics Pg 2.) Mixing Stick N or O.			
3	+15%	:1	+20-30%
2K Nonstop Primer Filler	2K Plasticiser	Hardener	2K Thinner
Repairing Plastic Parts (Sanding) (See Plastics Pg 3.) Mixing Stick H or L.			
3	+30%	:1	+10-15%
2K Nonstop Primer Filler	2K Plasticiser	Hardener	2K Thinner

Important Legislative Remarks:

- Please see the appropriate VOC Wallchart for compliance for your area. The values depicted below are “as applied regulatory” for the coating. Values have been determined using EPA Test Method 24. Please see the Master Values List for information for information on individual components.

VOC Category	VOC Regulatory	Density g/l	Wt% Volatiles, Water & Exempts	Vol% Water & Exempts
Primer Sealer	4.6 lbs/gal - 548 g/l	1399 g/l	43.5%	0.1%
Primer Surfacer	4.7 lbs/gal - 563 g/l	1384 g/l	45.8%	0.1%
Adhesion Promoter	4.8 lbs/gal - 572 g/l	1367 g/l	50.5%	0.1%
Elastomeric Coating	4.6 lbs/gal - 547 g/l	1391 g/l	47.4%	0.1%

- **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.**
- Any analytical results set forth herein do not constitute a warranty of specific product features or of the product's suitability for a specific purpose. All products are sold pursuant to our general conditions of sale. We hereby disclaim all warranties and representations, express or implied, with respect to this product, including any warranty of merchantability or fitness for a particular purpose. This product is protected by patent law, trademark law, copyright law, international treaties and/or other applicable law. All rights reserved. Unauthorized sale, manufacturing or use may result in civil and criminal penalties.