



Stadox

1K-Haftprimer Rotbraun U3030

1K Adhesion Primer Red Brown U3030

- **1K acid primer**
- **Welding certificate**
- **Easy to apply**
- **Outstanding corrosion protection**



Technical Description:

- Add 50% thinner
- 1 - 2 spray passes
- Overcoat with Stadox Filler after 15-20 min /
18-22°C flash off

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Substrate:

- Bare metal, sanded
- Through-hardened sanded paintwork
- Repair panel, primed and sanded
- Stadox Polyester substrates, sanded
- Aluminium, sanded
- Galvanised metal

Pretreatment / Cleaning:

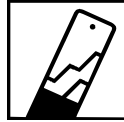


For substrate preparation information see Stadox Painting System S1.



Use air fed respirator. Refer to relevant Health and Safety Data Sheets.

Application:



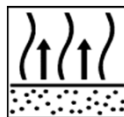
50% Stadox 2K / VOC Thinner
18-20 s / DIN 4mm / 20°C
45-53 s / ISO 4 mm / 20°C
Potlife 8h / 18-22°C



Compliant 1.4 - 1.5 mm
2.0 - 2.5 bar inlet pressure
1 - 2 = 15 - 30 micron



HVLP 1.5 - 1.6 mm
0.7 bar atomization pressure
1 - 2 = 15 - 30 micron



Air dry 15-20 min / 18-22°C



Stadox Filler

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Flash point:

- 26°C / 78.8°F

Specific Gravity:

- 1.01 g/cm³

Solid Content

(without thinner added):

- 32.9 Weight %
- 16.3 Volume %

VOC (2004/42/EC):

2004/42/II B(c)(780)780

The EU limit value for this product (productcategory II B.c) in ready to use form is max 780 g/l VOC. The VOC content of this product in ready for use form is max. 780 g/l.

Theoretical

Coverage:

- 5,7 m²/l at 20 micron dry film thickness

Cleaning of equipment:

Clean after use with Stadox Cleaning Thinner.

Important remarks:

- Certificate for welding existing.
- Suitable primer for panels which have to be welded.
- Do not overcoat with PE, EP, Standohyd and Standoblue products.
- Stadox 1K Adhesion Primer Red Brown U3030 gives steel 3 months weather resistance with a minimum dry film thickness of 50 micron.

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