

PDS N4.70C

May 2005

P110-5000

UV-SpeedPrime

PRODUCT DESCRIPTION

Nexa Autocolor's revolutionary UV-SpeedPrime sets a new standard for speed.

Curing at the speed of light, the unique technology of UV-SpeedPrime allows it to cure in 2 minutes using an approved low energy UV lamp, significantly reducing process time for small repairs.

UV-SpeedPrime is an aerosol, high-build primer. When used with an approved UV lamp, UV-SpeedPrime is ready to sand in 2 minutes.

The fast curing of UV-Speed Prime will increase production and the ability to deliver customer vehicles sooner. UV-SpeedPrime also eliminates the need for primer mixing and gun cleaning.

UV-SpeedPrime must be used with an approved UV lamp to cure.

Thorough sanding and cleaning is needed for successful refinishing when using UV-SpeedPrime.

UV-SpeedPrime should only be applied to areas that have been properly prepared.

Note: Only recommended for small area spot repairs. The size of the repair is limited by the area illuminated by the approved UV lamp used for curing.

- High Build = fewer coats, material savings
- Superior Sanding = labor savings

- Excellent Holdout = less rework
- Fast Dry = reduced process times

UV-SpeedPrime

PRODUCTS

P110-5000

UV-SpeedPrime

P273-5260

Cleaner for UV-SpeedPrime

THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF AUTOMOTIVE VEHICLES ONLY

PROCESS

MIX RATIO

UV-SpeedPrime is supplied Ready-for-Use.

Shake aerosol well before use.

APPLICATION



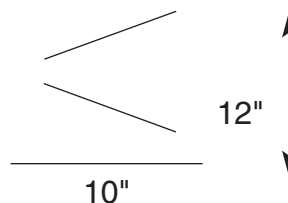
Apply **4-5** continuous passes over repairs at a spray distance of 8-10 inches (20-25 cm) to achieve a film build of 3-5 mils.

DRYING



Curing time for UV-SpeedPrime is 2 minutes using an approved UV curing lamp.

Apply light from UV curing lamp at a distance of 8-10 inches (20-25 cm) from UV-SpeedPrime with a footprint of approximately 12" x 12" at 10 inches.



CLEANING



Using P273-5260 (Cleaner for UV-SpeedPrime), thoroughly clean the repair area to remove uncured surface residue and overspray. The entire area should be well cleaned and wiped dry before sanding.

Note: Use a separate cloth to wipe off P273-5260 before it dries on the surface.

SANDING



Sand the cured UV Primer with the following grades:

Wet: P600 or Finer: Single Layer
P800 or Finer: Basecoats

Dry: P320 or Finer: Single Layer
P360 or Finer: Basecoats

Note: If surface is not thoroughly cleaned, some disc clog may be noticed. If this occurs, change discs and continue sanding.

UV-SpeedPrime

SUBSTRATES

UV-SpeedPrime can be applied directly over factory primer, factory finishes in good condition, bare steel, aluminum and galvanized metals after proper preparation, cleaning and sanding.

UV-SpeedPrime can be recoated with Nexa Autocolor Undercoats or directly topcoated with Nexa Autocolor 2K Topcoats.

UV-SpeedPrime can be applied directly over most plastics*, after proper cleaning and sanding without the need for a plastics primer.

***For PE and Polystyrene contact Nexa Autocolor Customer Service.**

GENERAL PROCESS NOTES

RESTRICTIONS OF USE

Do not use **UV-SpeedPrime** over any self etch primers.

UV-SpeedPrime is suitable for use directly over most plastics; however, contact Nexa Autocolor Customer Service when applying UV-SpeedPrime over polystyrene, polyethylene or highly flexible plastics.

SURFACE PREPARATION

The surface to be painted should be in sound condition and free from dirt or grease. As with any spot repair, all of the previous paint finish should be removed from the repair area. If required, polyester bodyfiller should then be applied directly to bare metal and sanded to the desired profile. The entire area to be painted with UV-SpeedPrime must be prepared by sanding with P400 paper or coarser to provide a suitable scratch.

The use of other abrasive media such as scotch pads is not recommended as these produce an insufficient scratch, which in turn may result in localized adhesion failure of the paint system.

GENERAL PROCESS NOTES (CONT'D)

UV CURING

UV-SpeedPrime must be cured using an approved UV light source. Primer will not cure unless it is directly exposed to the approved UV light source.

UV SpeedPrime requires a cure time of 2 minutes with a light to panel distance of 8-10 inches. If this distance is exceeded, cure times will be significantly extended. Reducing the lamp to panel distance will decrease the area exposed to UV light and thus restrict the size of the area that is cured.

UV-SpeedPrime contains an optically active agent that fluoresces in the presence of UV light. All of the applied paint film should “glow” under the UV lamp, indicating that it is exposed to UV light.

In the event that all of the repair area cannot be exposed to UV light with the lamp 8-10 inches away from the vehicle, the following steps should be followed.

- Firstly, partially cure the whole repair area by moving the lamp around the repair, ensuring that all of the applied UV-SpeedPrime paint film has been exposed to UV light for at least 30 seconds.
- Then fully cure the repair area in sections for 2 minutes at a time.
- Clean with P273-5260 and sand as recommended earlier in this data sheet.

When repairing areas of styling lines, care must be taken that all of the applied UV-SpeedPrime is illuminated. It may be necessary to alter the angle and / or position of the lamp to fully illuminate the paint film within the styling line. Material will not cure unless it is directly exposed to UV light.

Failure to fully cure UV-SpeedPrime may result in adhesion failure of the paint system and / or a color change in the topcoat over the repair area.

Always refer to the Light Manufacturers instructions and health and safety advice prior to handling UV equipment.

UV-SpeedPrime

GENERAL PROCESS NOTES (CONT'D)

WISE PRECAUTIONS

- Refer to the Nexa Autocolor MSDS sheet for P110-5000 before use.
- **Always** use UV-SpeedPrime in a well-ventilated area.
- **Always** wear air-fed breathing apparatus when spraying UV-SpeedPrime
- **Always** wear nitrile gloves when spraying and wiping UV-SpeedPrime.
- **Never** look directly into the light or deliberately expose skin to the UV lamp.
- **Do not** use the lamp if the filter glass is cracked, damaged or unsecured in anyway.
- **Always** wear UV protective glasses when using the UV lamp.

PERFORMANCE SPECIFICATIONS

Product:	P110-5000 U.V. SpeedPrime
Category:	Automotive Primer / Surfacer
VOC As Packaged:	3.67 lbs. per gal. / 440 gm/l
VOC (RFU):	Aerosol packaged ready for use
RFU Weight Solids:	39.2%
RFU Volume Solids:	25.9%

Product:	P273-5260 Cleaner for U.V. Primer
Category:	Surfacer cleaner
VOC As Packaged:	0.0 lbs. per gal. / 0.0 gm/l
VOC (RFU):	Packaged ready for use

For further information please contact:

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