

Product Data Sheet

June 2014

INTERNATIONAL MASTER FOR PROFESSIONAL USE ONLY



H5110V

UV Speedprime - UV Cured Primer P110-5001

Product	Description
P110-5001	UV Speedprime - UV Cured Primer
P275-5002	UV Speedprime Activator

Product Description

UV Speedprime - UV Cured Primer offers a route to achieving very fast application and curing of high quality repairs. The cured material has good film build and easy sanding.

The rapid cure obtained through unique technology using UV light provides faster processing of repairs than conventionally cured products.

Note: The size of repair is limited by the area illuminated by the UV lamp used for curing.

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UV SPEEDPRIME - UV CURED PRIMER P110-5001

H5110V

PROCESS				
	P110-5001100 Parts by weight.P275-500214 Parts by weight.			
∏s	24 - 26 sec DIN4 Pot Life : No pot-life after activation, if stored in a totally dark place.			
ř.	Spray gun:1.4 mm Gravity.Inlet Pressure :Refer to spraygun manufacturers instructions, (Normally 2 bar/30 psi at gun inlet)			
	For best results apply 3 passes in a 1 visit process working from out to in. The first pass covering the largest area. Subsequent passes remain inside the previous pass. (No Flash off between passes)			
	Refer to lamp manufacturers guidelines prior to use. Follow all lamp manufactures safety recommendations.Always allow lamp to warm up fully before use.UV 250 / 400 WATT UV "A" Type Lamp. Lamp to panel distance must be no more than 20cmUV 800 WATT UV "A" Type Lamp. Lamp to panel distance must be no more than 30cmThe use of the higher power lamp will allow a larger repair.			
	Sufficient UV energy for a full & even cure. Surface Cleaning Process (Optional) For best sanding properties - P273-5255 can be used to remove uncured surface residue and overspray. Alternatively thinner P850-1693 may be used. The entire area should be well cleaned and wiped dry before sanding. Note: Separate cloths should be used for application and removal of P273-5255 or thinners.			
e	SandingFinishing withHand dry P320Machine dry P500			
ТОРСОАТ	UV cured primer can be over coated with all solvent based and water based topcoat systems.			

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THESE PRODUCTS ARE FOR PROFESSIONAL USE ONLY.

WEIGHT MIX TABLE FOR P110-5001 USING P275-5002 ACTIVATOR

GUIDELINES FOR WEIGHT MIXING

Where a specific volume of primer mix is required, this may be best achieved by weight mixing, using the guidelines below.

Target Volume of RFU Primer required (Litres)	Weight Primer P110-5002	Weight Activator P275-5002	Weight Cumulative weight Primer and Activator	
0.10 L	127.0 g	17.6 g	144.6 g	
0.15L	190.4 g	26.4 g	216.8 g	
0.20 L	253.9 g	35.2 g	289.1 g	
0.25 L	317.4 g	44 g	361.4 g	
0.30 L	380.9 g	52.9 g	433.8 g	
0.40 L	507.8 g	70.5 g	578.3 g	
0.50 L	634.8 g	88.1 g	722.9 g	

Visc 32s/DIN4/18s

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PROCESS RECOMMENDATIONS

Surface Preparation

The surface to be painted should be in sound condition and free from dirt or grease.

PE Stopper must be finished with P180 block sanded. Surrounding area should be sanded with P320 to provide a suitable key for the UV Primer.

For best results use NEXA AUTOCOLOR[®] 2-pack Etch Primer on areas of bare metal.

Painting Plastics

UV Primer may be used on small areas of bare plastic after abrading, cleaning and application of a Plastics adhesion promoter, such as P572-2000 or P572-2001.

Application

For best results apply 3 passes in a 1 visit process working from out to in. The first pass covering the largest area. Subsequent passes remain inside the previous pass.

The "out-to-in" technique requires that the entire area to be painted is covered by the initial application of paint. The area of subsequent applications is reduced until the final application, which is applied only to the centre of the repair.

UV Curing

Always refer to the manufacturer's instructions and health and safety advice prior to handling UV equipment.

- The UV lamp requires a warm-up time **before** it can be used to cure UV Primer. Please refer to manufacturer's instructions.
- Constant on/off switching will damage the UV lamp, resulting in reduced lifetime.
- When switched off, the lamp requires a cooling down period of approximately 10 minutes before re-ignition.
- The cure/drying of UV primer is dependent on several factors. Film build of UV Primer Power of lamp Lamp to panel distance. Age of UV bulb. (Follow lamp manufactures recommendation for bulb life)
- Ensure area of primer to be dried is fully illuminated by the UV lamp at the recommended Lamp to panel distance.

When repairing areas of styling lines, care must be taken that all of the applied UV Primer 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.

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Precautions

Carry out risk assessment before adopting process. Refer to the Material Safety Data Sheet for UV Primer before use. Always use UV Primer in an enclosed well ventilated area such as a spraybooth. Always refer to UV lamp manufacturers guidelines for safe use. Do not expose eyes or skin to direct UV light. Always use UV safety glasses. Do not use the UV lamp if the filter glass is cracked, damaged or unsecured in any way. **Spectral Grey –** Please refer to colour information for the recommended Spectral Grey shade.

VOC INFORMATION - P110-5001

The EU limit value for these products (product category: IIB.c) in ready to use form is max. 540g/litre of VOC. The VOC content of this product in ready to use form is max. 540g/litre. Depending on the chosen mode of use, the actual ready to use VOC of these products may be lower than that specified by the EU Directive code.

These products are for professional use only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose. For Heath and Safety information please refer to the material Safety Data Sheet, also available at: **www.nexaautocolor.com**

For further information please contact:

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