

Product Data Sheet

June 2014



INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

H5110V

UV Speedprime - UV Cured Primer P110-5001

| <i>Product</i> | <i>Description</i> |
|----------------|---------------------------------|
| 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.

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



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 dependant 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.



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 Health and Safety information please refer to the material Safety Data Sheet, also available at: www.nexaautocolor.com

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