

Product Data Sheet

November 2007



INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

H5000V

UV-Speed Prime P110-5000

<i>Product</i>	<i>Description</i>
P110-5000	UV-Speed Prime
P273-5255	Surface Degreaser for UV-SpeedPrime

Product Description

UV-SpeedPrime offers a route to achieving very fast application and curing of high quality spot repairs with good film build and easy sanding and preparation.

UV-SpeedPrime can be used under **Nexa Autocolor** 2K topcoat systems.

The rapid cure obtained through **Nexa Autocolor**'s unique technology using UV light provides faster processing of repairs than conventionally cured products. The 1-pack Aerosol system also eliminates the need for gun cleaning and paint mixing.

Thorough preparation and cleaning are essential for successful refinishing using the UV primer. The UV Primer should only be applied to areas that have been well prepared with P400 paper or coarser. See the *Process recommendations* section of this datasheet for more details.



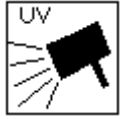

UV-SpeedPrime may be applied directly to well scuffed Steel, aluminium, galvanised steel, GRP, **Nexa Autocolor** polyester fillers, works primer and original finishes in sound condition. It may also be applied to all rigid and semi-rigid plastics apart from PE and Polystyrene.

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

PROCESS

	<p>Supplied ready for use Shake aerosol for at least 1 minute before after freeing ball bearings. Invert can and spray to clear the nozzle after use</p>
	<p>Spraying distance: 15-20 cm</p>
	<p>Use a suitable application technique to achieve a graduated film thickness across the repair area and featheredge. See Process recommendations for more details. Apply up to 6 continuous coats to achieve the maximum recommended film thickness of 120 microns.</p>
	<p>Refer to lamp manufacturer guidelines prior to use. Cure the primer with a Nexa Autocolor approved UV lamp Allow lamp to warm up for 2 minutes before use Lamp to panel distance must be no more than 20cm All primer must be fully illuminated by the UV lamp for 2 minutes to ensure an even and full cure.</p>
	<p>Using P273-5255 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: Separate cloths should be used for application and removal of P273-5255</p>
	<p>Sand the cured UV Primer with the following grades:- Wet P600 or Finer : Solid Colours (Direct Gloss) P800 or Finer : Basecoats</p>
	<p>Dry P320 or Finer : Solid Colours (Direct Gloss) P360 or Finer : Basecoats Note: - If the surface is not thoroughly cleaned some disc clog may be noticed. If this occurs, change discs and continue flattening.</p>

PROCESS

TOPCOAT

P110-5000 can be overcoated with **Nexa Autocolor** 2K topcoat systems

Some colours may require the use of a Spectral Grey Undercoat. Check Paint management or the microfiche for recommendations. Where a Spectral Grey is recommended, use -908, P565-9081, -9086 or -9087 over UV-SpeedPrime as appropriate.

PROCESS RECOMMENDATIONS

1. Restrictions of use.

Do not use P110-5000 over etch primers such as P565-597, -713, -9850, -908, -909, -9081, -9086 -9087.

P110-5000 is suitable for use directly over most plastics; however, P110-5000 should not be applied to polystyrene, polyethylene or highly flexible plastics.

2. 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 stopper should then be applied directly to bare metal and sanded to the desired shape. The entire area to be painted with P110-5000 must be prepared by machine sanding with P400 paper or coarser to provide a suitable key for UV-SpeedPrime. In difficult to reach areas such as styling lines, hand preparation with soft-backed P800 paper or coarser is advised. The use of other abrasive media such as scotch-pads is not recommended as these produce an insufficient key, which in turn may result in localised adhesion failure of the paint system.

3. Application.

For best results, use of an application technique that produces higher film builds over the central repair area and lower builds over peripheral areas, such as an “out-to-in” technique, is advised.

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.

PROCESS RECOMMENDATIONS

4. UV Curing.

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

UV-SpeedPrime is cured by a high performance UV light source. Currently, the only recommended UV unit is the UVH-254 produced by Panacol-Elosol GmbH. (Refer to your local **Nexa Autocolor** representative for contact information). The following are key points for its use:

- The UVH-254 requires a warm-up time of 2 minutes **before** it can be used to cure UV-SpeedPrime.
- Constant on/off switching will damage the UV lamp, resulting in reduced lifetime.
- Once switched on, the minimum lamp burning period should be 15 minutes. The equipment should only be switched off for production breaks exceeding 1 hour.
- When switched off, the lamp requires a cooling down period of approximately 10 minutes before re-ignition.

P110-5000 requires a cure time of 2 minutes with a lamp to panel distance of 20 cm. 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 20 cm from the panel, the following steps should be followed.

- Firstly, partially cure the whole of the repair area by moving the lamp around the repair, ensuring the all of the applied UV-SpeedPrime paint film has been exposed to UV light for at least 30 seconds.
- Then, fully cure the repair in sections for 2 minutes at a time.
- Clean with P273-5255 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.

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

5. Precautions.

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

VOC INFORMATION**For P273-5255**

The EU limit value for this product (product category: IIB.a) in ready to use form is max. 850g/litre of VOC.
The VOC content of this product in ready to use form is max. 850g/litre.

For P110-5000

The EU limit value for this product (product category: IIB.e) in ready to use form is max.840g/litre of VOC.
The VOC content of this product in ready to use form is max. 840g/litre

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: http://www.ppg.com/Autocolor_MSDS

For further information please contact:

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