Technical Data Sheet

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SprayMax®
1K UV-Primer / Surfacer
Part no. 680024

Product

Description / Purpose

Highly efficient, high-yield and fast-drying semi-transparent 1K UV primer filler. For the quick repair of minor damage in bodyshops, also suitable for industry and crafts. Can be dried with most commercially available LED UV lamps in one minute and can be sanded immediately after curing. Hardens at a UV-A light wavelength of 395 nm.

SprayMax UV paint repair is a harmonised product system in regard to application process and coating properties, consisting of:
UV Primer / Surfacer Art.-Nr. 680024
UV Clearcoat Art.-Nr. 680059
UV BlenderThinner Art.-Nr. 680091

Properties

- Very fast curing process
- Short flash-off times
- Excellent adhesion and good corrosion resistance
- Very good sandability
- Suitable for quick small damage repairs (spot repair)

Material base

Speciality resins and acrylic monomers, pigments and mineral fillers

Colour

slightly grey, semi-transparent

VOC Value (EU)

551 g/l

Substrate

Blank steel (cleaned and sanded)

Galvanised steel or aluminium (cleaned and sanded)

Polyester surfaces (cleaned and sanded)

Old or factory paintwork (cleaned and sanded)

Original factory primer (KTL) (cleaned and sanded)

Also suitable for plastic surfaces that need to be pre-treated with plastic adhesion promoter

The damaged area must be dry and free of grease and dust and all rust needs to be removed.
Clean with SprayMax Silicone Remover 680090

Processing

Protection measures

Wear personal protection equipment.
(respiratory mask/gloves/goggles)
For more information, see safety data sheet.

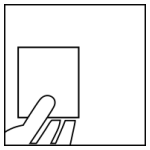
Curing with UV-A radiation:
Special care mast be applied when using UV radiation sources. Risks can only be avoided if an approved UV-A curing device is used correctly and as intended.
Please strictly comply with the operating instructions and safety information of the manufacturer of the UV-A curing device.

The following precautions always need to be observed to protect skin and eyes from glare and UV radiation.
- Wear a UV-protective mask
- Wear UV-light absorbing/reflecting gloves and workwear

Shake

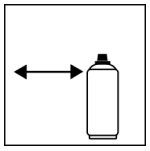
Shake can thoroughly for at least 2 minutes from when the mixing balls are heard.

Spray to test



After shaking the can, test spray and check compatibility with the surface and the colour.

Spraying distance

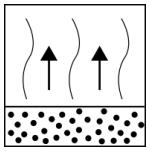


15 cm - 25 cm

Spray passes

Dry film thickness:
with approx. 2 spray coats 80 - 100 µm
<u>Flash-off time:</u>
approx. 30 sec. between the spray coats to achieve good curing. Do not apply as opaque coating.

Flash-off time

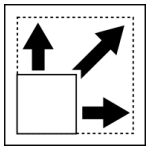


Final flash-off time before UV drying:
approx. 90 sec.

Processing conditions

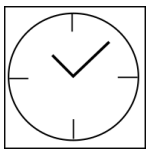
Optimum application at 18° C - 25° C and a relative humidity from 40 - 60 %.

Coverage



approx. 1 m²/ at 80 µm dry film thickness

Drying



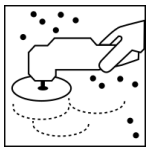
TG5 ready for assembly: after 1 - 2 min.
Cured with an UV lamp at distance of 10 - 15 cm from UV lamp to object.
On putties the drying time is extended to approx. 2 min.

<u>Sufficient hardening and adhesion depends on:</u>
Dry film thickness, intensity of the lamp (decreases with duration of use), distance to the object (the UV intensity on the surface decreases with greater distance from the lamp) and drying time.
Strictly observe the operating instructions from the manufacturer of the drying device.
The stated values refer to the above mentioned processing conditions and lamp equipment. The level of dryness is determined pursuant to DIN 53150.

Note:
Other processing conditions, lamp designs, age of light source and other distances bedween UV lamp and object lead to different drying times.

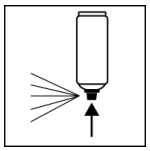
Continue

After drying and sanding, clean the surface with SprayMax Aqua Silicone Remover Art.Nr. 680094. Further reworking with itself after the UV drying can be carried out without intermediate sanding.
Can be painted over with all commercially available 1K or 2K top coats, solvent or water-based paints.



Dry with machine P 500 - P 600
Wet by hand P 800 - P 1000

Finish



After painting, turn the can upside down, spray for 3 - 5 seconds to clean the valve and put the lid back on the can.

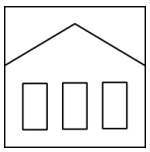
Additional Information

Important Information

Avoid bumps, friction and impact.

On bare steel, galvanised steel and soft aluminium pre-treatment cloths can be used to improve corrosion protection and adhesion.

Shelf Life



18 months
The usage period refers to an unused can that is stored correctly at a temperature of 15 - 25° C and a relative humidity below 60%. The can must be stored and transported in an upright position in a dry place where it is protected against chemical and mechanical influences. The safety information on the can and all statutory provisions applicable for the storage site must be observed.

Disposal

The completely emptied spray cans must be disposed of in the recycling system. Cans with hardened material must be disposed of as special waste.

Note

For professional use only.

For labelling see safety data sheet.