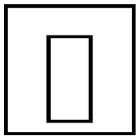
Autosurfacer UV

FOR PROFESSIONAL USE ONLY

Description

Sikkens Autosurfacer UV is a one-component, isocyanate free UV curable filler suitable for small repairs. The filler only needs 5 minutes of curing by UV light and offers customers the opportunityto drastically reduce their preparation process time.



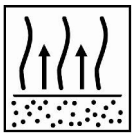
Autosurfacer UV

Ready to spray. (Shake well before use)

Spray gun set-up:
1.2-1.4 mm

Application pressure:
1.7-2.2 bar at the air inlet.

2 coats



Between coats:

2 minutes at 20°C

Before curing:

5 minutes at 20°C

400 W HID lamp	UV LED	Tesla Cure R100
5 minutes	5 minutes	30 secs – 2 minutes

For UV safety and UV equipment handling see TDS S8.01.02

Final sanding step: P500
See TDS S8.06.02

Recoatable with all Sikkens topcoats

Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information

Autosurfacer UV

FOR PROFESSIONAL USE ONLY

Description

Sikkens Autosurfacer UV is a one-component , isocyanate free UV curable filler suitable for small repairs. The filler only needs 5 minutes of curing by UV light and offers customers the opportunityto drastically reduce their preparation process time.

Suitable substrates

Existing finishes
Steel
Aluminium
Electrolytic galvanized steel
Glass Reinforced Polyester laminates
Polyester bodyfillers
Sikkens Polysurfacer

Autosurfacer UV can be applied on plastics parts which have been preceded by 1K All Plastics Primer or 2K Plastic Primer.

Do not apply Autosurfacer UV over Sikkens Washprimers.
(For systems which should meet the highest standards, pre-treat metal substrate with AkzoNobel AutoPrep pre-treatment wipes.)

Product and additives

Autosurfacer UV

Basic raw materials

Autosurfacer UV: Acrylic polymers and monomers

Surface preparation

Remove contamination using an appropriate cleaner..

Sanding; final dry sanding steps; P280 – P320

Remove contamination using an appropriate cleaner.

Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).

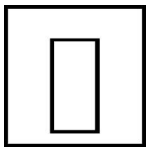
Autosurfacer UV

FOR PROFESSIONAL USE ONLY

Stir before use

Autosurfacer UV must be shaken thoroughly for 30 seconds before use.

Mixing

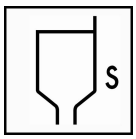


Autosurfacer UV

Flexible parts

Autosurfacer UV can be applied on plastics parts which have been preceded by 1K All Plastics Primer or 2K Plastic Primer.

Viscosity



15-16 seconds DIN cup 4 at 20°C

Spray gun set-up / application pressure

Spray gun	Fluid tip – set-up	Application pressure
Gravity feed	1.2-1.4 mm	1.7-2.2 bar at the spray gun air inlet
Mini jet	1.0-1.1 mm	

Pot-life

Unlimited (within product shelflife in a closed container away from direct UV exposure)

Application

Apply one coat over the total sanded area. Next apply the 2nd coat within the previous coat.

Do not spray until hiding. Too much layer thickness will cause insufficient through cure.

Allow each coat to flash-off naturally.

Do not apply Autosurfacer UV below a temperature 15°C.

Autosurfacer UV

FOR PROFESSIONAL USE ONLY

Cure specification

Position the HID lamp or LED approx..40 cm from the surface, ensuring the repair area is covered by the UV foot print.

	Time to full intensity	Drying time
400 W HID lamp	3 minutes	5 minutes
UV LED	1 minute	5 minutes

Use the UV unit according recommendation

Tesla Cure R100 UV LED Handlamp

Repair size	***Flash off with UV***	***Curing time***
Small spot	3-8 sec	30 sec
Medium spot	3-8 sec	1 min
Half panel	3-8 sec	2 min

For UV safety and UV equipment handling see TDS S8.01.02

Final sanding

Final sanding step P500

For detailed surface preparation see TDS S8.06.02

Final sanding step P1000

For detailed surface preparation see TDS S8.06.02

Remove contamination using an appropriate cleaner.

Recoatable with

All Sikkens topcoats

Film thickness

80-100 µm.

Theoretical coverage

	sq.ft/liter	**m²/liter**
Ready for use mixture at 1 µm dry film thickness:	5156	525

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances

.

Autosurfacer UV

FOR PROFESSIONAL USE ONLY

Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

VOC

2004/42/IIb(c)(540)420
The EU limit value for this product (product category: IIB. c) in ready to use form is max. 540 g/liter of VOC.
The VOC content of this product in ready to use form is max. 420 g/liter.

Product storage

Product shelf-life is determined when products are stored unopened at 20°C.
Avoid extreme temperature fluctuation.

- *Product shelf life data see TDS S9.01.02*

Akzo Nobel Coatings LTD
Address: Unit 2B, Didcot Park
Churchward, Southmead Industrial Estate
Didcot, Oxfordshire, OX11 7HB
Tel: +44 (0)1235 862226

Head Office
Akzo Nobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.sikkenscr.com