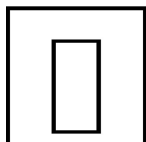


# Autosurfacer UV

## 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 opportunity to drastically reduce their preparation process time.



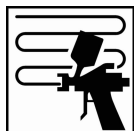
Ready to spray

Shake well before use

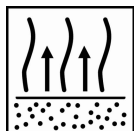


Spray gun set-up:  
1.2-1.4 mm

Application pressure:  
1.7-2.2 bar at the air inlet.  
HVLP max 0.6-0.7 bar at the air cap.



2 coats



Between coats:  
2 minutes at 20°C

Before curing:  
5 minutes at 20°C



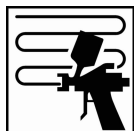
400 W HID lamp  
5 minutes

UV LED  
5 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

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### 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 opportunity to drastically reduce their preparation process time.

### Suitable substrates

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

*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



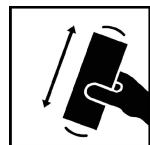
Sanding; final dry sanding steps; P220 - P320

*For detailed surface preparation see TDS S8.06.02*



Remove contamination using an appropriate cleaner.  
*Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).*

### Shake before use

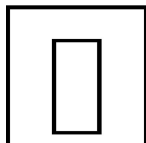


Before use Autosurfacer UV must be shaken thoroughly for 30 seconds.

# Autosurfacer UV

FOR PROFESSIONAL USE ONLY

## Mixing

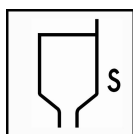


Autosurfacer UV

## 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**  
Gravity feed

**Fluid tip – set-up**  
1.2-1.4 mm

**Application pressure**  
1.7-2.2 bar at the spray gun air inlet  
HVLP max 0.6-0.7 bar at the air cap

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 2<sup>nd</sup> 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 at temperatures below 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

Ready for use mixture at 1 µm dry film thickness:

m<sup>2</sup>/liter  
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 Solvent 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 70°F (20°C).  
Avoid extreme temperature fluctuation.

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

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## FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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