

Autosurfacer[®] UV aerosol

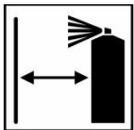
FOR PROFESSIONAL USE ONLY

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.



Shake thoroughly before use



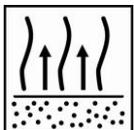
Application distance
Approximately 12-18 cm



2 – 3 coats



Invert aerosol and depress nozzle after use
This allows the propellant to clean the nozzle



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



Recoat 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

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Description

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Suitable substrates

Existing finishes
Steel
Aluminium
Electrolytic galvanized steel

Glass Reinforced Polyester laminates
Polyester bodyfillers

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

Do not apply Autosurfacer UV over Sikkens Washprimers.
Do not apply Autosurfacer UV directly over OEM Electrocoat

Product and additives

Autosurfacer UV

Basic raw materials

Autosurfacer UV: Acrylic polymers and monomers

Surface preparation



Surface cleaning; remove any surface contamination prior to sanding using an appropriate surface cleaner. *Pre-clean the surface with warm water and detergent, rinse sufficiently with clean water.*



Sanding; final dry sanding steps; P220 - P320
Rigid OEM electro coated parts; final dry sanding steps; P220 - P320
Sikkens polyester bodyfillers and Polysurfacer; finished with; P180 - P220
Featheredge sanding for spot repair, finish outer area with P400
For detailed surface preparation see TDS S8.06.02



Surface cleaning; remove any surface contamination prior to Autosurfacer UV application using appropriate surface cleaner. *Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).*

Flexible parts

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

Pot-life

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

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Application



Hold aerosol approximately 12 – 18 cm from the panel and apply 2 – 3 even coats. *Autosurfacers UV is transparent to allow proper curing of the filler. **Do not spray until hiding. Too much layer thickness may cause adhesion failures due to insufficient through cure.***

Allow each coat to flash-off naturally, this also supports to achieve higher film build. Do not force-dry with air support.

Flash-off between the coats is dependent on ambient temperature, applied layer thickness and airflow.

Do not apply Autosurfacers UV below a temperature 15°C. At lower temperature solvent retention in the coating is higher and may cause loss of gloss in time.



After application, invert aerosol and depress the nozzle for 2-3 seconds. *This allows the propellant to clean the nozzle sufficiently for further use*

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 (Heat up time)	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 <i>Approximate guide</i>	Flash-off, by passing UV lamp over the primed area before applying the next coat	Curing time with UV lamp
Small spot: 5cm x 5cm	3-8 sec	30 sec
Medium spot: 10cm x 10cm	3-8 sec	1 min
Large spot: 20cm x 20cm	3-8 sec	2 min

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

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Final sanding



Final sanding step P500

- Initial sanding steps may be executed with a coarser sanding grit; P360 - P400
- Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02



Final sanding step P1000

- Initial sanding steps may be executed with a coarser sanding grit P600 - P800
- Respect a maximum 200 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02



Surface cleaning; remove any surface contamination prior to the application of the topcoat using an appropriate surface cleaner.

Recoatable with

All Sikkens topcoats

Film thickness

By using the recommended application: 2 - 3 coats; 80-100 µm.

Theoretical coverage

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

Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

VOC

The VOC content of this product in ready to use form is max. 580 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

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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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