

Autosurfacer UV aerosol

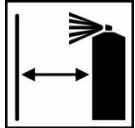
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Description

Sikkens Autosurfacer UV is a one-component UV curable surfacer suitable for small repairs. The surfacer 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



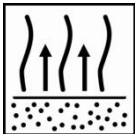
Application distance
Approximately 5"- 7" (12 – 18 cm)



2 coats



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



Between coats:

Before curing:

2 minutes at 70°F (20°C)

5 minutes at 70°F (20°C)



Minimum 5 minutes
Irradiate the coated area constantly with a 400 Watt UV lamp
Ensure suitable UV protection is observed (see TDS S8.01.02 UV Equipment Handling TDS)



Final sanding step: P500 to P600 grit dry.
See TDS S8.06.01



Recoat with all Sikkens topcoats



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends to use fresh air supply respirator.

Read complete TDS for detailed product information



Autosurfacer UV aerosol

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Description

Sikkens Autosurfacer UV is a one-component UV curable surfacer suitable for small repairs. The surfacer 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	Sikkens Polysurfacer
Aluminium	Zinc Coated Steel
Electrolytic galvanized steel	

Autosurfacer UV can be applied on plastics parts which have been preceded by Primer PO LV or Primer PO.

Product and additives

Autosurfacer UV

Basic raw materials

Autosurfacer UV: Acrylic polymers, acrylic monomers, pigments and mineral charge

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 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 Primer PO LV.

Pot life

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

Application



Hold aerosol approximately 5"-7" (12-18 cm) from the panel and apply 2 coats.
*Autosurfacer 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 Autosurfacer UV below a temperature 60°F (15°C). At lower temperature solvent



Autosurfacers UV aerosol

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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



By using a 400 watt UV lamp 5 minutes at UV exposure
Use the UV unit according recommendation (+3 minutes heat up time)

For curing of Autosurfacers UV place the UV lamp at 30 - 40 inches distance.
**There is no risk for over-cure by longer cure times and shorter lamp distances.*

If 2 spots are positioned very close to each other and the footprint of the UV lamp is too small to cure both spots at once, make sure that the UV lamp does not irradiate one of the spots partially. **Partial irradiance may cause wrinkling!**

2 options are possible:

1. Cure the spots separately at close distance, making sure that only one spot is irradiated at the time.
2. First move the UV lamp slowly over the surface once, then post cure the spots one by one according to the standard procedure.

Curing speed is determined by several factors such as:

- o *Lamp intensity and UV spectra*
- o *Bulb life*
- o *Distance between lamp and the substrate*
- o *Applied layer thickness*

This product is only released for curing with UV-A.

Curing by the use of sun light is not recommended.

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

Personal protection equipment

When curing Autosurfacers UV, it is necessary to use suitable UV protection equipment which covers all skin areas on hand, arm and face. Wear long sleeves, gloves and cover the face with suitable full face shield.

Final sanding



Final sanding step P500

- o *Initial sanding steps may be executed with a coarser sanding grit; P360 - P400*
- o *Respect a maximum 100 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.

Recoat with

All Sikkens topcoats

Autosurfacer UV aerosol

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Film thickness

By using the recommended application: 2 coats; 3.2-4.0 mils (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.

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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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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