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

Recoatable 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
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

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
Autosurfacer UV aerosol

FOR PROFESSIONAL USE ONLY

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 Autosurfacer 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, than post cure the spots one by one according to the standard procedure.

*Curing speed is determined by several factors such as:
- Lamp intensity and UV spectra
- Bulb life
- Distance between lamp and the substrate
- 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 Autosurfacer 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
- 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

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 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*