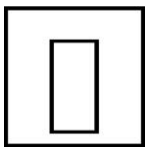
Autosurfacer UV

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.



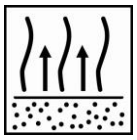
Autosurfacer UV

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.
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

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 pre-treatment wipes.)

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).*

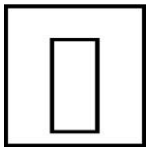
Autosurfacer UV

FOR PROFESSIONAL USE ONLY

Stir before use

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

Mixing

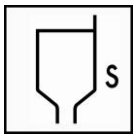


Autosurfacer UV

Flexible parts

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

Viscosity



15-16 seconds DIN cup 4 at 70°F (20°C)

Spray gun set-up / application pressure

Spray gun	Fluid tip – set-up	Application pressure
Gravity feed	1.2-1.4 mm	28-30 psi (1.7-2.2 bar) at the spray gun air inlet HVLP max 8-10 psi (0.6-0.7 bar) at the air cap
Mini jet	1.0-1.1 mm	

For maximum build use a larger fluid tip and lower the application pressure.

Pot-life

Unlimited (within product shelflife in a closed container away from direct UV exposure) ; this also means storage of the primer in transparent RPS/PPS cups in normal shop conditions; if long term storage is needed use black RPS/PPS cups).

Application

Apply one coat over the total sanded area. Next apply the 2nd coat within the previous coat.
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 retention in the coating is higher and may cause loss of gloss in time.

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

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

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 coats; 3.2-4.0 mils (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.

Cleaning of equipment

Sikkens Solvents or solvent borne guncleaners

Autosurfacer UV

FOR PROFESSIONAL USE ONLY

VOC

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.

The VOC content of this product in ready to use form is max. 1.69 lb/gal. (US)

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*

Akzo Nobel Car Refinish bv.
Address: Rijksstraatweg 31, PO Box 3, 2170 BA Sassenheim
Tel: +31(0)71308-6944

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