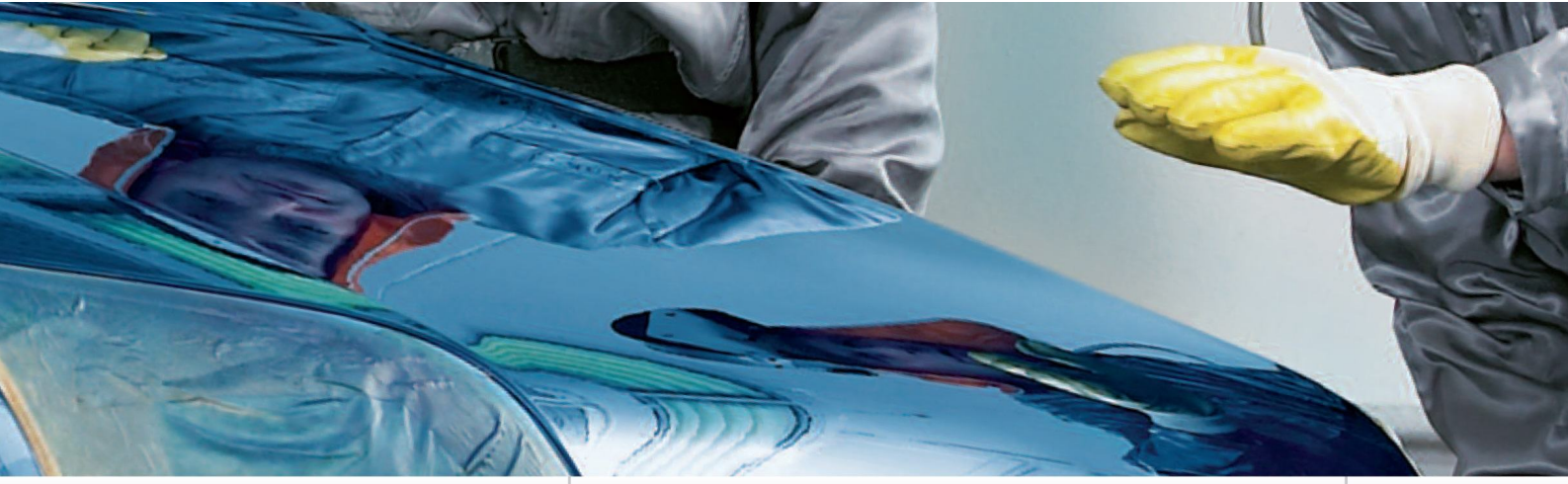


Technical Data Sheet.

Permasolid® 1K UV-TEC Primer Surfacer 9003



UV drying, 1K Primer Surfacer for ultra-quick minor damage repairs

The Permasolid UV-TEC Primer Surfacer 9003 is a 1K, semi-transparent grey primer surfacer for bodyshops who want to improve productivity. It dries in one minute using most commercially-available LED UV lamps, and can be sanded as soon as it is cured. It can be applied directly to a variety of substrates in 2 coats, without the need for a hardener or a thinner. Also suitable for plastic substrates, which must be pre-treated with a plastic adhesion promoter. The UV primer surfacer is suitable for recoating with all Spies Hecker base coats and topcoats.

- Lightning-fast curing process
- Highly productive, short flash-off time
- 1K technology, ready-for-use, no need for a hardener or a thinner
- Reduced waste due to 1K technology
- Superior adhesion for a better corrosion resistance
- Excellent spraying and sanding properties
- CMR-chemical-free formulation
- Suitable for ultra-fast spot repairs
- Also available in non-aerosol form

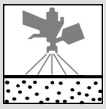
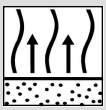
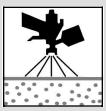
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Spies Hecker simply closer.

An Axalta Coating Systems Brand

Permasolid® 1K UV-TEC Primer Surfacer 9003

Product preparation - application PERMASOLID UV-TEC PRIMER-SURFACER 9003

	It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.
 	Bare steel sanded and cleaned Galvanised steel or aluminium sanded and cleaned Old or original paintwork well sanded and cleaned. OEM Primer (e-coat), sanded and cleaned Surfaces pretreated with 2K polyester products and then finely sanded and cleaned. Substrates should not be sanded coarser than with P240 abrasive (orbital machine sanding) prior overcoating with UV filler. Rigid & half rigid types of plastics primed with Priomat Elastic Adhesion Primer 3400 after preparation (cleaning/tempering/cleaning).
	Shake before use. (for at least 2 minutes) Make a spray test after shaking.
	Not applicable
 	2 light coats Do not apply to coverage. intermediate flash-off 30 sec. final flash-off 90 sec.
	All listed data is related to IRT UV SmartCure 395 LED handlamp. 1-2 min at a distance of 10-15 cm to the object.On putty/stopper spots the UV primer has to be cured for 2 min.A sufficient through hardening and adhesion is dependent on: Dry film thickness, intensity of the lamp (decreasing over working time), distance to the object (increasing the lamp distance decreases the UV intensity on the surface) and curing time. Permasolid 1K UV-TEC Primer Surfacer 9003 is slightly transparent in order to achieve good through curing. Do not apply to coverage.LED UV lamp 395nm.
 	P500 - P600 P800 - P1000
	Basecoat + Clearcoat 2K Topcoat
VOC compliant	2004/42/IIB(e)(840) 551: The EU limit value for this product (product category: IIB(e)) in ready to use form is maximum 840 g/l of VOC. The VOC content of this product in ready to use form is maximum 551 g/l.

Permasolid® 1K UV-TEC Primer Surfacer 9003

Products

	Permasolid® 1K UV-TEC Primer Surfacer 9003
	80 - 100 µm If higher film builds are needed, intermediate drying under UV-light is necessary before re-application of further coats. An intermediate sanding in the course of this process is not required.
Theoretical coverage	237 m²/l at 1 micron dry film thickness Due to different hardener characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary. Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.
	After use, hold aerosol can upside down and spray briefly to clean nozzle.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Application distance to the substrate should be 15 until 25 cm.
- The material can be overcoated with itself after UV-drying without intermediate sanding.
- Follow all safety instructions.
- Follow strictly the operational instructions of the drying equipment manufacturer.
- Alternative LED UV lamps with 395nm wave length and comparable intensity are useable.
- If intensity is lower, curing time and distance have to be adjusted.
- The use of UV drying undercoats is not recommended and must be avoided in the build-up with Matt Clear System.
- On bare steel, galvanized steel and soft aluminium, Priomat Reactive Pretreatment Wipes 4000 can be applied for improved corrosion protection and adhesion.

Drying by UV-A radiation - The handling of ultraviolet radiation sources requires particular care. Only with an appropriate handling of a licensed ultraviolet drying equipment potential dangers can be avoided. - Follow strictly the operating and safety instructions of the producer of the UV-A drying equipment. - The following UV protection for skin and eyes should be used: - Wearing UV protective safety goggles, gloves and clothes.

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our Spies Hecker product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Spies Hecker product range, unless explicitly indicated otherwise.

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