

Technical Data Sheet.

Permasolid® 1K UV Primer Surfacer 9002



UV drying, 1K primer surfacer for ultra-quick minor damage repairs. Permasolid 1K UV Primer Surfacer 9002 is slightly transparent and suitable for very fast repairs of small areas of damage and Speed Repairs. The product can be cured with any HID mercury lamp or any UV-A light emitting LED lamp with sufficient intensity in the 360-400 nm range.

- 1K product, ready for use (no pot life).
- Fast drying using UV-A drying equipment.
- Good spraying properties.
- Easy sanding.
- Suitable for recoating with all Spies Hecker base coats and topcoats.

For professional use only!

Spies Hecker simply closer.



An Axalta Coating Systems Brand

Permasolid® 1K UV Primer Surfacers 9002

Product preparation - application UV-A lamp



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Bare steel sanded and cleaned
Galvanized steel sanded and cleaned
Sandthroughs of maximum 3 cm to bare aluminium, sanded and cleaned
Old or original paintwork well sanded and cleaned.
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
OEM Primer (e-coat), sanded and cleaned.
Rigid & half rigid types of plastics primed with Priomat Elastic Primer 3304/3410 transparent / Priomat Elastic Adhesion Primer 3400 after preparation (cleaning/tempering/cleaning).



Ready to use



Not applicable



	Spray nozzle	Spray pressure	
Compliant	1.2	1.8 - 2 bar	inlet pressure
HVLP	1.2	0.7 bar	atomisation pressure

see manufacturer's instructions



2 light coats

intermediate flash-off not needed
final flash-off: 2 min



Estimated curing time for dedicated 400W Mercury HID Lamps: 3 minutes at a distance of 10 cm.
Estimated curing time for a UV-A light emitting LED Lamp (360 nm - 400 nm with 350mW/cm² peak light performance): 1 minute at a distance of 10 cm in the area of peak light performance. By using UV-A light emitting LED lamps curing times can be reduced due to higher intensities in the relevant wavelength range (360 nm-400 nm). A sufficient curing and adhesion is dependent on: dry film thickness, intensity & emission spectrum of the UV lamp, distance to the object, size of the repair and curing time. UV-A lamps have considerable differences in their performance, therefore we recommend to make test application together with your chosen lamp to ensure good through curing. The product is slightly transparent in order to achieve good drying. Do not apply to coverage!



P500 - P600



Basecoat + Clearcoat
2K Topcoat

VOC compliant

2004/42/IIB(c)(540) 425: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 425 g/l.

Permasolid® 1K UV Primer Surfacers 9002

Product preparation - application VISIT UV Flash Dry lamp - Metal



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Bare steel sanded and cleaned
Galvanized steel sanded and cleaned
OEM Primer (e-coat), sanded and cleaned.
Sandthroughs of maximum 3 cm to bare aluminium, sanded and cleaned
Old or original paintwork well sanded and cleaned.
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.



Ready to use



Not applicable



	Spray nozzle	Spray pressure	
Compliant	1.2	1.8 - 2 bar	inlet pressure
HVLP	1.2	0.7 bar	atomisation pressure

see manufacturer's instructions



2 light coats

intermediate flash-off not needed
final flash-off: 2 min



VISIT UV Flash Dry 15/700
2 x 20 flashes



P500 - P600



Basecoat + Clearcoat
2K Topcoat

VOC compliant

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Permasolid® 1K UV Primer Surfacer 9002

Product preparation - application VISIT UV Flash Dry lamp - Plastic



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Plastic substrates coated with Priomat Elastic Primer 3304/3410 transparent / Priomat Elastic Adhesion Primer 3400.



Ready to use



Not applicable



	Spray nozzle	Spray pressure	
Compliant	1.2	1.8 - 2 bar	inlet pressure
HVLP	1.2	0.7 bar	atomisation pressure

see manufacturer's instructions



0.5 coat

VISIT UV Flash Dry 15/700
20 flashes

0.5 + 1
1 operation
1st: thin and closed
2nd: normal

final flash-off: 2 min
VISIT UV Flash Dry 15/700
20 flashes
with intermediate flash-off: 1 min
VISIT UV Flash Dry 15/700
20 flashes



see above



P500 - P600



Basecoat + Clearcoat
2K Topcoat

VOC compliant

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Permasolid® 1K UV Primer Surfacers 9002

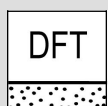
Products

Permasolid® 1K UV Primer Surfacers 9002

Product mix



Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.



70 - 90 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

470 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.



Clean after use with a suitable solventbased guncleaner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Surplus ready for use material should not be returned to original can.
- Stir very well with the mixing stick before pouring.
- Spray guns should be equipped with a light-proof gravity cup.
- With regard to elastifying properties, the use of Permasolid Elastic Additive 9050 is not allowed.
- On bare steel, galvanized steel and soft aluminium, Priomat Reactive Pretreatment Wipes 4000 can be applied for improved corrosion protection and adhesion.

Permasolid® 1K UV Primer Surfacer 9002

Health and safety:

This product is classified according to regulation (EC) 1272/2008 (CLP).

Please consult the Safety Data Sheet.

The use of suitable personal protection equipment is highly recommended during application, to avoid skin and eye-irritation and long term adverse effects.

Drying by UV-A radiation:

- Handling UV radiation sources requires particular care. Dangers can only be avoided if a licensed UV-A drying equipment is used in the proper way.
- Strictly follow the operating and safety instructions of the manufacturer of the UV-A drying equipment.
- To protect the skin and eyes from UV radiation, the following measures should be taken.
 - wear UV protective face mask
 - wear UV light absorbing/reflecting gloves and working clothes

Also possible:

Drying with Hensel UV Flash Dry 15/700

For further notes on application, safety and health, please refer to the Data Sheet of Permasolid 2K UV Starlight Primer Surfacer 9000.

We expressly declare that we give all advice and information in this Product Information regarding the suitability, the handling and safety of the UV hardening coating materials and the ultraviolet radiation sources based upon our best knowledge. Such advice and information shall never constitute a warranty or guarantee of the suitability or fitness of a particular use of the UV hardening coating materials and the ultraviolet radiation sources nor shall it release you from your duty to examine and test the UV hardening coating materials and the ultraviolet radiation sources on your own for your intended processes and purposes.

The use of ultraviolet radiation sources is at one's own danger.

With regard to such advice and information we shall only be liable for intentional action or gross negligence, unless liability exists by law due to death, personal injury or injury to health or due the provisions of the German Product Liability Act.

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.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/ or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.