



## 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!


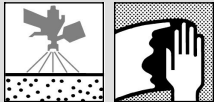

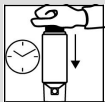


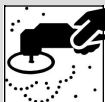
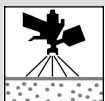
Spies Hecker simply closer.



An Axalta Coating Systems Brand


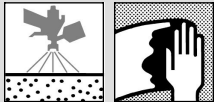

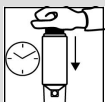



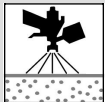
# Permasolid® 1K UV Primer Surfacers 9002

## 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.	
	<p>Bare steel sanded and cleaned</p> <p>Galvanized steel sanded and cleaned</p> <p>Sandthroughs of maximum 3 cm to bare aluminium, sanded and cleaned</p> <p>Old or original paintwork well sanded and cleaned.</p> <p>Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.</p> <p>OEM Primer (e-coat), sanded and cleaned</p> <p>Rigid &amp; half rigid types of plastics primed with Priomat Elastic Primer 3304/3410 transparent / Priomat Elastic Adhesion Primer 3400 after preparation (cleaning/tempering/cleaning).</p>	
	<p>Shake before use. (for at least 2 minutes)</p> <p>Make a spray test after shaking.</p>	
	Not applicable	
	<p>2 light coats</p> <p>Do not apply to coverage.</p>	<p>intermediate flash-off not needed</p> <p>final flash-off: 2 min</p>
	<p>Estimated curing time for dedicated 400W Mercury HID Lamps: 3 minutes at a distance of 10 cm.</p> <p>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 &amp; 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!</p>	
	P500 - P600	
	<p>Basecoat + Clearcoat</p> <p>2K Topcoat</p>	
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.	


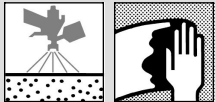

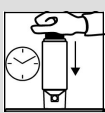
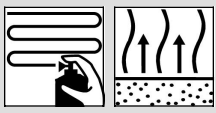

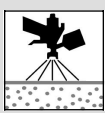
# Permasolid® 1K UV Primer Surfacer 9002

## 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.	
	<p>Bare steel sanded and cleaned</p> <p>Galvanized steel sanded and cleaned</p> <p>Sandthroughs of maximum 3 cm to bare aluminium, sanded and cleaned</p> <p>Old or original paintwork well sanded and cleaned.</p> <p>Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.</p> <p>OEM Primer (e-coat), sanded and cleaned</p>	
	<p>Shake before use. (for at least 2 minutes)</p> <p>Make a spray test after shaking.</p>	
	Not applicable	
	<p>2 light coats</p> <p>Do not apply to coverage.</p>	<p>intermediate flash-off not needed</p> <p>final flash-off: 2 min</p>
	<p>VISIT UV Flash Dry 15/700</p> <p>2 x 20 flashes</p>	
	P500 - P600	
	<p>Basecoat + Clearcoat</p> <p>2K Topcoat</p>	
VOC compliant	<p>2004/42/IIIB(e)(540) 425: The EU limit value for this product (product category: IIB(e)) 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.</p>	

# 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.	
	Shake before use. (for at least 2 minutes) Make a spray test after shaking.	
	Not applicable	
	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	
	Basecoat + Clearcoat 2K Topcoat	
VOC compliant	2004/42/IIB(e)(540) 425: The EU limit value for this product (product category: IIB(e)) 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

## Products

	Permasolid® 1K UV Primer Surfacers 9002
	50 - 70 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.
<b>Theoretical coverage</b>	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.
	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.
- Vehicle areas where fuel vapour may occur, e.g. tank caps, may not be repaired.
- Masking paper must be removed completely before drying by pulsed UV lamp.
- The material can be overcoated with itself after UV-drying without intermediate sanding.
- Follow all safety instructions.
- Do not operate equipment before reading and understanding the manufacturer's user manual and safety instructions.
- Stored material should not be exposed to light.
- 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.

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