

Provisional Technical Data Sheet.

Permasolid® UV Starlight Primer Surfacer 9000

Substrate

Application

Drying

Further treatment

Permasolid® UV Starlight Primer Surfacer 9000 is a new primer surfacer for spot repairs.

Special important notes

It has been specially developed for drying by pulsed UV lamp.

Health and Safety

Data

Storage

For professional use only!



Substrate



Suitable substrates:

1. Bare steel, cleaned and sanded
2. Electroplated/roller galvanized steel panels or soft aluminium, cleaned and sanded
3. Well sanded old or original finish (except thermoplastic finish)
5. Surfaces treated with Raderal®2K polyester products and then finely sanded

Suitable primer for plastic parts:

Priomat® Elastic Primer 3304 transparent

Important note:

Owing to the wide variety of metal alloys and manufacturing processes, it is essential to carry out a preliminary test on the respective substrate to ensure that the pretreatment is sufficient to guarantee perfect adhesion.

Substrate pretreatment:



Steel, electroplated/roller galvanized steel panels or soft aluminium - degrease and sand lightly.

Remove original primer by sanding.




Original or old finish - clean and sand lightly, remove all traces of rust and sand the areas around the former rust spots to create a smooth transition to the old paintwork.



Before further treatment, clean all substrates once more with Permanent Silicone Remover 7010 or Perமானal®Silicone Remover 7799.

Application



Method of application		HVLP design guns (e. g. Sata mini jet)
		gravity feed
		
	Application viscosity 4 mm, +20°C, DIN 53211	viscosity as supplied = application viscosity
	Spray nozzle	1.0–1.2 mm
	Nozzle inlet pressure	2 bar
	Number of coats	1.5 another 1.5 coats may follow after intermediate drying (e.g. for polyester putty)
	Prescribed film thickness	60–90 µm dry film thickness

Drying



Drying by pulsed UV lamp: at +20°C ambient temperature



Visit Flash dry 15/700
reflector 22 cm Ø: 20 pulses

Special note: No other drying equipment may be used.

Further treatment



Dry sanding:

with random orbital sander and dust extraction, P 400–500 grade



Wet sanding:

P 800 grade

When used as a primer:

recoat with Permacron®/Permasolid® 2K acrylic surfacer

Recoat with:

Permacron®Automotive Top Coat Series 257
Permasolid®HS Automotive Top Coat Series 270
Permahyd® Base Coat Series 280/285 und
Permacron®/Permasolid®2K clear coat
Permacron®Base Coat Series 293/295 und
Permacron®/Permasolid®2K clear coat

Special important notes



Product-related notes

- We recommend an HVLP design gun for spot repair application.
- Spray guns should be equipped with opaque gravity cups.
- When repairing new parts coated with electrophoretic paints (cathodic/anodic dip painting), the electrophoretic finish has to be removed by sanding from the area to be repaired.

Health and Safety



The UV-curing Permasolid® UV Starlight Primer Surfacer 9000 itself is in principle not considered to be unhealthy. Therefore, when applying this primer surfacer, the same protective and safety measures are to be taken as for standard paint materials.

Handling UV radiation sources, however, requires particular care. Dangers can only be avoided if a licensed UV drying equipment is used in the proper way.

Spies Hecker always endeavours to inform its customers comprehensively about all relevant safety aspects, in particular about environmental and health protection. To avoid as far as possible any dangers for environment and health which may result from the use of UV radiation sources in a bodyshop, the following notes are to be observed when using UV technology:

1. Strictly follow the operating instructions of the manufacturer of the UV drying equipment.
2. To protect the skin and the eyes from blinding and UV radiation, the following measures are to be taken:
 - UV protective head mask
(see enclosure Protective Equipment Required for the Application of Permasolid® UV Starlight Primer Surfacer 9000)
 - Wear UV light absorbing/reflecting gloves according to our recommendations
(see enclosure Protective Equipment Required for the Application of Permasolid® UV Starlight Primer Surfacer 9000)
 - Wear UV light absorbing/reflecting working clothes according to our recommendations
(see enclosure Protective Equipment Required for the Application of Permasolid® UV Starlight Primer Surfacer 9000)
 - No unprotected personnel within a 5 m distance to the lamp
3. Measurements performed in-house showed that when the "UV Flash Dry" device from Visit is used in the proper way (see operating instructions), UV radiation generally remains below the permissible daily dose of 30 J/m² stipulated by the ICNIRP, provided the output of 3000 pulses per 8 hour working day is not exceeded. Please note that the reflector is equipped with a glare shield which must be intact at the time of usage of the reflector.

Measurement of the UV radiation on-site is strictly required if the number of pulses exceeds 3000 pulses per 8 hour working day. Please contact the respective Institution for Statutory Accident Insurance and Prevention in this case.
4. UV drying equipment may only be used by instructed and trained personnel. In accordance with the legal requirements, the bodyshop should display operating instructions describing the use of the device. DIN EN 12198-1 is applicable for devices emitting radiation.
5. Vehicle areas where fuel vapour may occur, e.g. tank caps, may not be repaired.
6. Masking paper must be removed completely before drying by pulsed UV lamp.

Data



Viscosity as supplied:	thixotropic	
Flash point:	above +23°C	
Solids content:	approx. 99.3% by weight approx. 99.0% by volume	
Specific weight:	approx. 1.27 g/cm ³	
VOC value:	9 g/l	
Coverage*:	approx. 15.0 m ² /l at 60 µm dry film thickness	approx. 10.0 m ² /l at 90 µm dry film thickness

* The coverage was calculated on the basis of the recommended dry film thickness and the solids content by volume (without reducer). No allowance was made for wastage during application.

Storage



Guaranteed shelf life:	6 months in sealed original containers
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The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed.

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Enclosure of the Provisional Technical Data Sheet for Permasolid® UV Starlight Primer Surfacer 9000

Protective Equipment Required for the Application of Permasolid® UV Starlight Primer Surfacer 9000

SATA UV protective head mask Vision 2000	article No. 49600142
UVEX safety goggles for spectators	article No. 49600144
MAPPA rubber gloves black	article No. 49600145
WIBECO painter's overall	article No. 49041908 (size M) article No. 49041924 (size L) article No. 49041932 (size XL) article No. 49041940 (size XXL)