

UV Filler

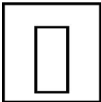
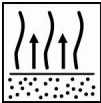
Primers/Surfacers

01/05/2020

L2.04.03 UK & Ireland

DESCRIPTION

UV Filler is a one-component UV curable filler suitable for small repairs. The filler only needs 5 minutes of curing by UV light and offers customers the opportunity to drastically reduce their preparation process time.

Mixing ratio		RFU	UV Filler
Equipment		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
Application		2-3 x 1 coat	
Flash-off		Between coats 2 minutes at 20°C	Before curing 5 minutes at 20°C
Drying		400W HID lamp 5 minutes Ensure suitable UV protection is observed	UV LED 5 minutes
Sanding		Final sanding step: P400-P500	
Recoatability		Topcoat HS 420	Basecoat WB (GT)
Protection		Use suitable respiratory protection Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator	

Read complete technical data sheet for detailed product information

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PRODUCT AND ADDITIVES

Product	UV Filler
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Chemical Basis	UV Filler	Acrylic resins
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METHOD OF USE

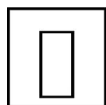
Substrates	Original finishes, including thermoplastic acrylics Steel Zinc coated steel Aluminium 1K Multi Plastic Primer Polyester Body Filler
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For systems which should meet the highest standards, pre-treat the metal substrate with AkzoNobel AutoPrep Pre-treatment Wipes

Substrate preparation	Original finishes: Sand with P180-P280 grit dry Steel: Sand with P180-P280 grit dry Polyester Body Filler: Sand with P180-P280 grit dry
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Mixing ratio

RFU UV Filler



UV Filler must be shaken thoroughly for 30 seconds before use

Spray gun set up



Spray gun:
HVLP Gravity
LVLP/HR Gravity

Fluid opening:
1.2-1.4mm
1.2-1.4 mm

Spraying pressure:
0.7 bar (at air cap)
1.7-2.2 bar (at air inlet)

Refer to user manual spray gun used

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APPLICATION TECHNIQUE

Application Apply two or three single coats, allowing to dry until matt after each coat



Equipment cleaning Use Multi Thinners or nitro cellulose thinner

Drying



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
400W HID lamp	3 minutes	5 minutes
UV LED	1 minute	5 minutes

Use the UV unit according recommendation

Tesla Cure R100 UV LED Handlamp

Repair size	Flash off with UV	Curing time
Small spot	3-8 sec	30 sec
Medium spot	3-8 sec	1 min
Half panel	3-8 sec	2 min

Personal protection equipment

When curing UV Filler, it is necessary to use suitable UV protection equipment which covers all skin areas on hand, arm and face. Wear long sleeves, gloves and cover the face with suitable full-face shield.

Layer thickness 80 – 100 microns

Material usage Ready for use mixture at 1 µm layer thickness : 525 m²/liter

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances

Sandpaper grades	Dry sanding :	Initial sanding P320	Final sanding P400-P500
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Recoatability	Topcoat HS 420 Basecoat WB GT
Product storage	Avoid extreme temperature fluctuation and high humidity levels
Shelf life	1 year at 20°C
VOC	2004/42/IIB(c)(540)400 The EU limit value for this product (product category : IIB.c) in ready to use form is max. 540 g/l VOC. The VOC content of this product in ready to use form is max. 400 g/litre.

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FOR PROFESSIONAL USE ONLY

IMPORTANT NOTE: The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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