

UV paintsystem

Paint system with 1K UV primer filler for repairs on metal parts

A 1.7.1

Process description

High efficient repair solution for small / medium damages on car panels by using 1K UV-A technology primer filler. Lower energy consumption and shorter process times compared to existing repair solutions. UV technology allows fast drying with nearly no impact on substrate temperature.

Substrates

- Bare automobile body sheet
- Electro-coated surfaces
- R-M fillers
- Automotive OEM finishes, fully cured and solvent-resistant
- Automotive refinishes, fully cured and solvent-resistant

Products required

- PK 700, PK 1000, PK 2000
- STOP UNI
- LIGHT FILLER GREY P 2530 / UV LIGHT FILLER LIGHT GREY P 2530LG / UV LIGHT FILLER DARK GREY P 2530DG
- R-M topcoat




Safety instructions

It cannot be ruled out that these products contain particles < 0.1 µm.

The products are suitable for professional use only.

For the use of these products, please adhere to the actual safety recommendations and the personal protective equipment.

Pre-treatment

	Degreasing PK 700 or PK 1000
	Mechanical de-rusting of damaged areas with P80 / P150
	Degreasing PK 700 or PK 1000

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





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Putty







	STOP UNI Hardener	100 g 3 g
	Coats: Film thickness:	2 – 3 2 – 3 mm max.
	20°C 60°C	20 min. 10 min.
	(short wave) (medium wave)	4 min. 50 % 6 min.
	Dry with P80, P150, P240, P320	
	Degreasing PK 2000	

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LIGHT FILLER GREY P 2530 / UV LIGHT FILLER LIGHT GREY P 2530LG /
UV LIGHT FILLER DARK GREY P 2530DG

	Material is ready for use		
	HVLP gravity-feed spraygun RP gravity-feed spraygun	1.1 1.1	2.0 bar 2.0 bar
	Spray coats Film thickness	½ + 1 max. 120 µm	
	Flash off at 20°C Depending on the film thickness the flash off time might be longer	20 s between spray coats	
	UV drying (shortwave UV-A > 6 mW/cm²)	5 min.	
	P400 – P500		
	Degreasing PK 2000		

Note: Do not spray until hiding. If higher film thicknesses are necessary, a second layer LIGHT FILLER GREY P 2530 / UV LIGHT FILLER LIGHT GREY P 2530LG / UV LIGHT FILLER DARK GREY P 2530DG can be applied with intermediate sanding after having dried the first layer.

For good drying properties respect the distance and heat up time of the lamp and be aware of shadow edges

Topcoat

	ONYX HD, UNO HD CP, UNO HD CP PLUS Apply in accordance with the Technical Data Sheet
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