

## UV paintsystem

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

#### A 1.7

#### Process description

High efficient repair solution for small / medium damages on painted assembly plastic parts 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.

Pure polypropylene (PP) and polyethylene (PE) cannot be painted. In order to guarantee paintability, modified plastic materials are used for vehicle parts that shall be painted. Although these plastic parts are often labelled PP, the material is nevertheless paintable.

#### Substrates

- Plastic add-on parts with surface defects
- Plastic parts repaired using a plastic repair kit (e.g., Teroson)

#### Products required

- PK 600 / PK 700 / PK 1000
- STOP FLEX
- AM 870 SEALERPLAST 90
- LIGHT FILLER GREY P 2530 / UV LIGHT FILLER LIGHT GREY P 2530LG / UV LIGHT FILLER DARK GREY P 2530DG







#### 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 600	Degreasing PK 700
		Degreasing PK 1000
	Damaged area: P80-P600 Entire part: sanding pad	Damaged area: P80-P600 Entire part: sanding pad
	Degreasing PK 1000	Degreasing PK 1000
	60°C	1 h
	Degreasing PK 1000	Degreasing PK 1000

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





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


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#### Putty

	<b>STOP FLEX Hardener</b> Unsuitable for highly flexible plastic substrates	100 g 3 g
	Coats: Film thickness:	2 – 3 2 – 3 mm maximal
	20°C 60°C	25 – 35 min. 15 min.
	(short wave) (medium wave)	8 min. 50 % 10 min.
	P80, P150, P240, P320	
	Degreasing PK 1000	

#### Primer

	<b>AM 870 SEALERPLAST 90</b> hake vigorously for 2 min. before use	
	Spraycoats: Fim thickness:	1 – 2 5 µm
	Flash-off 20°C:	15 min.







# Technical Information

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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. 80 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	
	Sanding P400 – P500		
	Degreasing PK 1000		

**Note: Do not spray until hiding, max. 80µm**

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

### Topcoat

	<b>ONYX HD, UNO HD CP, UNO HD CP PLUS</b> Apply in accordance with technical data sheet		
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