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 is dried with a UV-A lamp.

- 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 Surfacer 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.

| Bare steel sanded and cleaned | Galvanized steel sanded and cleaned | Sandthroughs of maximum 3 cm to bare aluminium, sanded and cleaned | Old or original paintwork well sanded and cleaned | Surfaces pretreated with 2K polyester products and then finely sanded and cleaned | OEM primer (e-coat), sanded and cleaned | Plastic substrates coated with Primat Elastic Primer 3304 transparent. |

- Ready to use

- Not applicable

<table>
<thead>
<tr>
<th>Spray nozzle</th>
<th>Spray pressure</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Compliant</td>
<td>1.2 mm</td>
<td>1.8 - 2 bar</td>
</tr>
<tr>
<td>HVLP</td>
<td>1.2 mm</td>
<td>0.7 bar</td>
</tr>
</tbody>
</table>

- See manufacturer’s instructions

- 2 light coats

- Intermediate flash-off not needed

- Final flash-off: 2 min

- Dedicated commercial UV-A-lamps fitted with a mercury bulb with at least 400W are recommended. A sufficient through hardening and adhesion is dependent on: dry film thickness, intensity of the light bulb (decreasing over working time), distance to the object (increasing the lamp distance decreases the UV intensity on the surface) and curing time. UV-A Primer-Surfacer is slightly transparent in order to achieve good drying. Do not apply to coverage. Cure time 3 minutes at a distance of 15 cm or 6 minutes at a distance of 25 cm.

- P500 - P600

- Basecoat + clearcoat

- Permasolid HS Automotive Top Coat 275 / Permacron Automotive Top Coat 257 / Permacron MS Automotive Top Coat 730

- VOC compliant

  - 2004/42/IIIB(c)(540) 425: The EU limit value for this product (product category: IIIB(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.

<table>
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| OEM primer (e-coat), sanded and cleaned |

| Ready to use |

| Not applicable |

### Spray pressure

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</table>

see manufacturer’s instructions

2 light coats

intermediate flash-off not needed

final flash-off: 2 min

VISIT UV Flash Dry 15/700

2 x 20 flashes

P500 - P600

### VOC compliant

Basecoat + clearcoat

Permasolid HS Automotive Top Coat 275 / Permacron Automotive Top Coat 257 / Permacron MS Automotive Top Coat 730

2004/42/II(b)(540) 425: The EU limit value for this product (product category: II(b)) 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  - Plastic

<table>
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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 transparent.

Ready to use

Not applicable

- **0.5 coat**
  - VISIT UV Flash Dry 15/700
  - 20 flashes

- **0.5 + 1**
  - 1 operation coat
  - VISIT UV Flash Dry 15/700
  - 20 flashes
  - with intermediate flash-off: 1 min
  - VISIT UV Flash Dry 15/700
  - 20 flashes
  - final flash-off: 2 min

- **P500 - P600**

- **Basecoat + clearcoat**
  - Permasolid HS Automotive Top Coat 275 / Permacron Automotive Top Coat 257 / Permacron MS Automotive Top Coat 730

- **VOC compliant**
  - 2004/42/II(b)(540) 425: The EU limit value for this product (product category: II(b)) 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**

### Products

| Permasolid® 1K UV Primer Surfacer  9002 |

### Product mix

Mixing ratios with special agents are available in the productmix table on Phoenix and in the specific TDS.

<table>
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<th>70 - 90 µm</th>
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<td>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.</td>
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| Clean after use with a suitable solventbased guncleaner. |

### Remarks

- Material has to be at room temperature (18-25°C) before use.
- Surplus ready for use material should not be returned to original can.
- Stir very well with the mixing stick before pouring.
- Spray guns should be equipped with a light-proof gravity cup.
- With regard to elastifying properties, the use of Permasolid Elastic Additive 9050 is not allowed.
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.

For professional use only! The information provided in this documentation has been carefully selected and arranged by us. It is based upon our best knowledge on the subject at the date of issuance. The Information is given for information purposes only. We are not liable for its correctness, accuracy and completeness. It is up to the user to check the information with regard to up-to-dateness and suitability for his intended purpose. The intellectual property in this Information, including patents, trademarks and copyrights, is protected. All rights reserved. The relevant Material Safety Data Sheet and Warnings displayed on the product label need to be observed. We may modify and/or discontinue operation of all or portions of this Information at any time in our sole discretion, without notice and assume no responsibility to update the Information. All rules set forth in this clause shall apply accordingly for any future changes and amendments.