






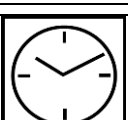
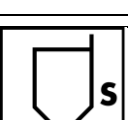
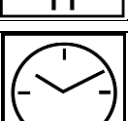


Technical Data Sheet

KRISTAL 1K UV Surfacers
Art.nbr.: 5810

Surfacers
Version: **EN-TDS-5810-4**
Revision: April 2016
Page: 1 of 5

RESTRICTED TO PROFESSIONAL USERS

APPLICATION SHEET

	Ready for use
	Shake well for 1 minute before application
	Spray nozzle: 1.2 – 1.3 mm Pressure: 1.8 – 2.2 bar at the air inlet
	1 – 2 spray coats Layer thickness 60-80 µm (wet layer thickness)
	2 – 4 minutes between the layers 4 – 6 minutes before UV curing At 20 °C application temperature
	5 minutes with 400w UV-A lamp Allow the UV-A lamp to preheat for at least 3 minutes Protection against UV light is required
	Application viscosity: 16 – 18 seconds (DIN CUP 4 mm / 20 °C) Application- and object temperature: 18 °C – 28 °C
	Storage life: 6 months in a closed packaging (20 °C)
	Use suitable respiratory protection
	For full technical information, please read the complete Technical Data Sheet

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FULL TECHNICAL INFORMATION



- Fast curing, only 5 min / 400w UV
- Timesaving – both in preparation and application
- Low curing costs
- No waste material
- Grey-colored surfacer
- High filling

FIELD OF APPLICATION

Suitable for the Car Refinishing industry, intended for partial repairs.

KRISTAL 1K UV Surfacers is a high filling, sandable and easy to apply high-solid, one-component, UV-curing Surfacers.

PRODUCT AND AUXILIARY PRODUCTS

	KRISTAL 1K UV Surfacers	
<i>Hardener</i>	-	
<i>Product to add</i>	-	
<i>Article numbers</i>	KRISTAL 1K UV Surfacers	5810

CHEMICAL BASIS

KRISTAL 1K UV Surfacers UV-curing polyester modified acrylates resin

SUBSTRATES

On top of degreased and sanded old layers, polyester filler and steel.
Do not use on top of thermoplastic acrylate lacquers, wash primer, aluminium and zinc.

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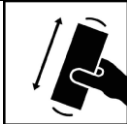
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MIXING



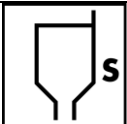
Ready for use

MIXING



Shake well for 1 minute before application

APPLICATION VISCOSITY



Application viscosity
16 - 18 seconden (DIN CUP 4 mm / 20°C)

Application- and object temperature
18°C - 28°C

EQUIPMENT SET-UP



Spray nozzle:
1.2 - 1.3 mm

Pressure:
1.8 - 2.2 bar at the air inlet

SPRAY COATS / LAYER THICKNESS



1 - 2 spray coats

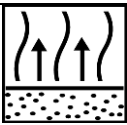
Layer thickness 60 - 80 µm (wet layer thickness)

APPLICATION



Apply the first layer over the total sanded area. Next apply the second layer within the first layer.
Do not spray covering layers. Too much layer thickness may cause adhesion failures due to insufficiently through cure.

FLASH-OFF



2 - 4 minutes between the layers
4 - 6 minutes before UV curing

Do not force-dry with air support. Flash-off between the coats is dependent on layer thickness as well as ambient temperature and airflow in the spray booth.

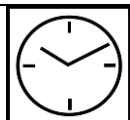
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DRYING



5 minutes with 400w UV-A lamp

- Allow the UV-A lamp to preheat for at least 3 minutes.
- The distance between the UV-A lamp and object needs to be 25 up to 60 cm.
- Curing speed is subject to lamp intensity, UV spectra and bulb life.
- UV-range: UV-A 315 nm up to 400 nm.

Protection against UV light is required

ECONOMY

8 m² per liter / 60 µm, ready to spray surfacer

CLEANING THE EQUIPMENT

KRISTAL NC Thinner 3120

PHYSICAL PROPERTIES

Density : 1,2 kg/l
Flashpoint : <5 °C
Vol.% solids : 65%

VOLATILE ORGANIC COMPOUND

VOC CODE: **2004/42/IIB(c)(540)(500)**

Product Subcategory (according directive 2004/42/EG) and max. VOC content of the ready to use product IIB(c). Primers – Surfacers/filler and general (metal) primer. EU limit values: 540 g/l. (2007)

This product contains a maximum of 500 g/l. VOC

STORAGE LIFE

Under normal storage conditions for up to 6 months in unopened tins (at 20 °C). Prevent extreme temperature changes.

TRANSPORT- AND STORAGE CONDITIONS

Do not store or transport this product at a temperature lower than 8 °C or higher than 30 °C.

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