

## GENERAL INFORMATION

1-380 1K UV Primer is a one-component, light grey, Ultra Violet curing primer surfacer that is suitable for rapid repairs in the car refinish market. It has excellent UV drying and sanding properties and is compatible with DeBeer Refinish base coats. This product has been designed to accelerate your processing.

**This TDS is about the liquid version.**

## MIXING RATIO



Packaged ready-to-use.

**Mechanically shake or stir to make sure no settling has occurred.**

## GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HE	1,2 - 1,4	2/29
HVLP	1,2	2/29

## APPLICATION



Apply 2 coats at a distance of 15 cm - max 2 coats 100 - 115 µm (3,9 - 4,5 mil).

Make sure to cover the spray cup to protect from light exposure.

Allow first coat to flash 30 seconds. Ready to cure 15 seconds after final coat.

This coating is transparent, it is recommended not to attempt to achieve complete full hiding.

**Do not apply till coverage or cure in between.**

## DRY & CURE TIMES AND DISTANCE



Ready to cure 15 seconds after final coat.

We recommend to use a UV-LED Light (wavelength is 395 nm). Consult lamp manufacturer or see UV lamp manual for specifications.

UV light only cures what is in the direct line of sight. Check coverage area of the UV light.

The cure time is 90 seconds.

## POTLIFE



Unlimited, store product in UV resistant containers.

## COMPONENTS



## ADDITIVES



## SUBSTRATES



Properly cleaned and sanded aluminium, steel, galvanised steel, OEM paint system, SMC /GRP Glass Fibre Reinforced Polyester laminates and Bare Metal. Properly cleaned OEM E-Coat panels.

**All common plastic types currently used to produce OEM exterior parts and used in the automotive refinish industry. Always use an Plastic Primer (1-60) on plastic substrates.**

**NOTE: Do not use with polyethylene (PE) and pure polypropylene (PP).**

## SURFACE PREPARATION



Pre clean the surface with 1-951 Silicone Remover, wipe on and wipe dry. Sand surface with P500 - P600 grit abrasive. Remove all sanding debris with sanding vacuum & clean with 1-951 Silicone Remover, wipe on and wipe dry.



## NEXT LAYER



MM 900 - 9999 WaterBase 900\* Series  
MM 500 - 5999 BeroBase 500 Series

**Apply a matching grey shade for optimal results.**

## PHYSICAL DATA

EU REGULATIONS 1-380 1K UV Primer		
VOC Code		2004/42/IIIB(e)(840)280
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product		IIIB/e. Special finishes - All types. EU limit values: 840 g/l. (2007). This product contains a maximum of 280 g/l VOC.
Chemical Base	Special resins	
Physical Properties	Viscosity (RT5)	20 - 22 Dincup 4 / 20°C
	Specific Gravity (kg/l)	1.109
	Flash Point Closed Cup	-4°C / 24°F
	Volume % Solids	74,9
	Economy	10 m²/L/100 µm
		403,8 ft²/Gal
	Gloss	Matt
	Colour	Transparent

## PROTECTION



Use suitable respiratory protection (*fresh air supply respirator is strongly recommended*).

For more detailed information please visit the following link for the Safety Data Sheet:

[SDS DeBeer](#)

**It is necessary to use suitable UV protection for eyes and skin.**

## CLEANUP



Cleaning the Equipment / Per local regulations.

## STORAGE/SHELF LIFE



The up-to-date shelf life overview can be found by clicking on the following link:

[Shelf life overview DeBeer](#)

## NOTES



This product is designed for UV curing only. Curing speed is determined by:

- Lamp intensity and UV irradiance.
- Distance of lamp to surface.
- Coating thickness.

Dry between layers if higher layer thickness is required.

Close the product properly in original packaging with the associated lid after opening/use.