

### Description

1K UV-curable primer filler with possibility to apply in high thickness, easy to apply and fast drying with UV-LED, UV mercury vapour lamps or even with exposure to sunlight. The surfacer only needs 5 minutes of curing by UV light. The surfacer can be used for fast and economic refinishes.

### Features & Benefits

- Dries with UV light (UV-LED lamps, Mercury vapour lamps or exposure to sunlight)
- For temperature sensitive parts (electric cars, plastic parts ...)
- Easy to sand
- Fast drying: 5 minutes of curing with UV light
- Unlimited potlife
- Smooth surface: superb topcoat appearance, no sagging
- Direct to metal application, adhesion on steel, iron, Zinc-platted and Aluminium substrates
- Possible to apply on plastic parts

### Other features and benefits

M15 is a one-component system that does not produce waste as a result of potlife related curing.

### Safety information

Before using 7150 M15 Surfacer, important information is needed to safely handle the UV equipment and to protect the user.

#### Personal protection

Eyes: Avoid looking directly into the source of UV light. Always wear UV protective safety goggles.

Skin: Make sure exposed skin is covered.

#### UV equipment

UV equipment is safe to use when operated according to the manufacturers' guidelines and instructions.

General recommendations are:

- Avoid unnecessary exposure to UV light
- Never use a lamp with a broken UV glass filter
- Never look directly into UV light
- Never point the UV light at someone else
- Always use the recommended personal and operational protective measures
- Experimenting with different light sources is associated with severe health risks

#### Maintenance

Regular inspection and cleaning of UV emitting light sources is crucial because of safety and because of performance itself. Refer to manufacturers' guidelines and instructions

### Substrate preparation

Clean, dry, and degrease the surface with a suitable anti-silicone cleaner. Before application of the primer filler on bare steel/metal, sand the surface. Bare Steel should be lightly abraded and completely rust free before application.

Note: 7150 M15 Surfacer is not intended for large areas of bare metal. It will however provide adequate adhesion if applied directly to small metal areas. For small bare metal areas, aluminium and galvanized steel which must meet the highest standards, we advise application of appropriate primer (epoxy, etc.). Do not apply 7150 M15 Surfacer over acid containing wash primers.

Remove non adhering old paintworks and primers.

New parts/panels sand with grit P320/dry or P800/wet.

Old coatings sand with grit P280 - P320/dry or P800/wet.

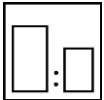



GRP or Fiberglass sand with grit P320/dry.





Polyester Fillers sand with grit P120-P320/dry.

Zn and Alu: Scuffing pad + matting paste

Before applying water-based basecoat clean with an appropriate water based antsilicone cleaner as also suggested by the producer of water basecoat.

### Application

	<p><b>Mixing ratio</b> 7030/7050 Acrylic thinner      0 – 5% (vol.)</p>
	<p><b>Spray gun set /air inlet</b> Gravity feed 1.2 - 1.4 mm      1.5 – 2.0 bar Suction feed      Verify manufacturer's info</p>
	<p><b>Application</b> Number of coats:      1 – 3 coats</p> <p>Do not spray until full hiding/coverage. Too much layer thickness may cause adhesion failures due to insufficient through cure.</p> <p>Do not apply 7150 M15 Surfacer bellow temperature 15°C(60°F). At lower temperature solvent retention in the coating is higher and may cause loss of gloss in time.</p> <p>Flash off between coats:      2 min *There is no risk for over-cure by longer cure times and shorter lamp distances.</p> <p>Flash off before UV curing:      5 min</p> <p>Total dry film build:      100 – 150 microns</p>
	<p><b>Drying</b> Using UV LED:      5 min Using a Hg (Mercury) lamp:      5 min + 3 min to heat up the lamp Direct sunlight:      30 min</p>

	<b>Lamp type</b>	<b>Lamp to panel distance:</b>
	UV-A LED (250-400 W)	< 20 cm
	UV-A LED (800 W)	20 – 40 cm depending on job size
	Mercury vapour lamps	< 90
	<p>Curing of the filler will be faster if the movement with the UV lap across the painted area will be done faster and with more passes than slower and stopping at the same spot longer.</p> <p>If the light field of the UV LED-Light is too small to cover the complete painted surface, the UV lamp must be moved overlapping the area already dried. Care must be taken to ensure that all partial areas are irradiated sufficiently for a homogeneous through drying of the entire surface.</p> <p>All primer must be fully illuminated by the UV lamp for 4 – 5 minutes to ensure sufficient UV energy for a full and homogeneous cure.</p>	
	<p><b>Sanding</b></p> <p>Before sanding a special UV Activator (art.no. 1150-0,4) needs to be used to remove uncured surface primer residue and overspray. By spraying and wiping the UV Activator from surface of the primer the glossiness of the primer will be decreased. At the same time, the surface will not be tacky anymore and sanding paper will not clog. By not using the UV Activator, significant difference in paper clogging will be observed.</p> <p>Pre sanding by hand with P320 - P400. Observe maximum sanding steps of 100 grit or less between the single sanding steps.</p> <p>Final machine sanding with P500</p> <p>Note: Separate cloths should be used for application and removal of 1150 Activator and precleaning agents (like antisilicone cleaner).</p>	
	<p><b>Potlife</b> (20°C/68 °F) - Unlimited within the shelf life of the product, in a closed container, protected from UV-light.</p> <p>Due to the complexity of the 1K system, long term storage can cause phase separation of the material in the can. This is specific to this UV product and can be removed by mixing the product very good. Phase separation may also happen when this product is kept in the gravity spray cup for a longer period. Therefore, it is necessary to thoroughly stir the product.</p>	

### Complementary products

7050, 7030 Acrylic thinner

1150-0,4 UV Activator

Prod. Nr.	Description	Volume	Packaging Box
7150-0,5	Light Beige	500 ml	6

### Testing of the material

Any kind of testing of the applied material (adhesion test, stone-chip test, chemical resistance, salt chamber test ...) must be done at least 15 days after the application.

### VOC

2004/42/IIB(c) (540) <540

### Shelf life

Min. 12 months from the production date under normal storage conditions and unopened can.

### Technical information

Spreading rate: 7 – 8 m<sup>2</sup>/L

### Processing instructions – Painting plastics

Before application, reheat the object to be painted for 60 minutes at 60°C. Degrease the surface with Silco antisilicone degreaser. Sand/matt with matting paste. Clean again with Silco antisilicone degreaser. Allow parts to dry completely. ATTENTION: Sanded material must be removed completely! After this preparation we recommend doing a wetting test with water. If the water rolls off quickly repeat the pre-treatment. Additionally, use of Antistatic Degreasing Wipe (art.no. 2215) is recommended. Due to the most different kinds of plastic and compounds on the market we recommend pre-testing the product on original plastic parts (application and adhesion).

### Additional Information

FOR PROFESSIONAL USE ONLY!

Always read the instructions.

IMPORTANT: This product contains hazardous substances at work, so it is necessary to always use/wear appropriate protective equipment. For further instructions, check the label on the product and safety data sheet. A person who uses the product for any purpose other than recommended in this technical data sheet, acts at his own risk. It is the user's responsibility to take all necessary steps to fulfil the local legislation.

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public.

Information and methods described are based on the best information and practices known to us and serve merely as guidelines for optimal use, without liability to performance, results or fitness for any intended use. We do not accept any responsibility for the behaviour of the product or damage arising from the use of the product. Before using the product, the user must check if this is the latest version.

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