

GENERAL INFORMATION

PA35 UV Active Primer is a single component, light grey, translucent Ultra Violet curing primer surfacer aerosol developed for spot / rapid repairs in the car refinish market. It has excellent UV drying and sanding properties and is compatible with all Octoral Refinish top coats, including the B00 - B999 Octobase System and W00 - W999 Octobase Eco Plus System. This product is designed to accelerate your processing times.

This TDS is about the aerosol version.

MIXING RATIO



Shake well after you hear the marble inside the can is starting to make noise. It can take some time before the material loosens and starts to mix.

GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HE	-	-

SUBSTRATES



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



All common plastic types currently used to produce OEM exterior parts and used in the automotive refinish industry. Do not use with Polyethylene (PE) and pure Polypropylene (PP). Always use an adhesion promoter on plastic substrates.

SURFACE PREPARATION



Pre clean the surface with TD20 Silicone Remover, wipe on and wipe dry. Sand surface with P180 - P240 grit abrasive. Remove all sanding debris with sanding vacuum & clean with TD20 Silicone Remover, wipe on and wipe dry.

APPLICATION



1 - 2 full coats 50 - 100 µm (1,9-3,9 mil)

Apply 1st coat over entire area, blow dry for 30 seconds. Apply 2nd coat to inner 80% of repair area, blow dry for 30 seconds.



After use, invert aerosol and press nozzle for 2 - 3 seconds.

POT LIFE



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COMPONENTS



TA910 Uni Thinner Medium

FLASH-OFF AND DRY TIMES



Flash off between coats	2 minutes
Flash off before curing with UV-A	5 minutes



The PA35 UV Active Primer must be cured with a UV-A light, UV light only dries what is in the direct line of sight. Check coverage area of the UV light.

DRY TIMES AND DISTANCE



1 coat application

COATS	FLASH TIME	55W	100W	250W
1 coat	5 minutes	90 sec @ 5 cm	60 sec @ 5 cm	2 min @ 30 cm

2 coat application

COATS	FLASH TIME	55W	100W	250W
First coat	2 minutes	No cure required	No cure required	No cure required
Second coat	5 minutes	3 min @ 5 cm	2 min @ 5 cm	4 min @ 30 cm

We recommend to use a UV lamp with a range of 320nm - 400nm. See light manufacturer for specifications, for distance and also irradiance.

UV PRIMER / SURFACER CLEANING AFTER CURING



After curing clean the surface thoroughly with Octoral TA910 Uni Thinner Medium. Wipe on and wipe dry.

ADDITIVES



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SANDING



It is best practice to guide coat the PA35 UV Active Primer. Final sanding P400 - P600.

NEXT LAYER



W00 - W999 Octobase Eco Plus System
B00 - B999 Octobase System

Apply a matching grey shade for optimal results.

STEP 1



Surface Preparation

Pre clean the surface with TD20 Silicone Remover wipe on and wipe dry. Sand surface with P180-P240 grit abrasive. Remove all sanding debris with vacuum or compressed air, and finally clean with TD20 Silicone Remover, wipe on and wipe dry.



Masking

Mask entire vehicle to eliminate unwanted overspray.

STEP 2



Preparation

Prior to use, thoroughly shake the aerosol can. Once you hear the marble inside the can is starting to make noise, continue to shake for at least 2 minutes.



Application

Apply 1 or 2 full coats. Apply the PA35 UV Active Primer at a distance 25 cm - 35 cm. The first coat should be larger than the second, this is called "Outside in Application". Do not apply till coverage this product needs to be translucent in order to achieve full curing



Clean up

After use, invert aerosol and press nozzle for 2 - 3 seconds.



Flash-off

Allow a flash-off time of 30 seconds to 2 minutes between coats. The PA35 UV Active Primer must be cured with a UV-A light. Check coverage area of the UV light.

STEP 3



Dry times and distance

When drying the PA35 UV Active Primer always dry the entire area including overspray. Without UV radiation overspray will not cure.

1 coat application

COATS	FLASH TIME	55W	100W	250W
1 coat	5 minutes	90 sec @ 5 cm	60 sec @ 5 cm	2 min @ 30 cm

2 coat application

COATS	FLASH TIME	55W	100W	250W
First coat	2 minutes	No cure required	No cure required	No cure required
Second coat	5 minutes	3 min @ 5 cm	2 min @ 5 cm	4 min @ 30 cm

We recommend to use a UV lamp with a range of 320nm - 400nm. See light manufacturer for specifications, for distance and also irradiance.

STEP 4



Cleaning

After curing the PA35 UV Active Primer requires cleaning with TA910 Uni Thinner Medium using two cloths, wipe on and wipe dry.

Sanding

It is best practice to guide coat the PA35 UV Active Primer. Block sand with P320 - P360. Final sanding P400 - P600.

Notes

- This product is designed for UV-A curing only.
- Curing speed is determined by:
 - Light intensity and UV irradiance.
 - Distance of lamp to surface.
 - Film thickness.
 - Coverage area of the UV-A light
- Keep the repair area to a size maximum 20cm in diameter. This product is designed for small repairs only.
- Apply a matching grey shade for optimal results.

EU REGULATIONS		
VOC Code	2004/42/IIIB(e)(840)565	
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 565 g/l VOC.	
Chemical Base	Special resins	
Physical Properties	Viscosity (RTS)	-
	Specific Gravity (kg/l)	-
	Flash Point Closed Cup	42°C / 107°F
	Volume % Solids	-
	Economy	-
	Gloss	Mat
	Colour	Translucent Grey

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.octoral.com

CLEANUP



STORAGE / SHELF LIFE

Minimum 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).