

### GENERAL INFORMATION

PA38 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 Octoral 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 container to make sure no settling has occurred.**

**Do not put product on mixing machine.**

**Shake product before each use.**

### 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.

**After 8 hours, shake the remaining UV Primer in the spray gun cup, then pour remaining primer back into the original can and seal it completely.**

**Do not allow any unused material to be exposed to light or open air.**

### COMPONENTS



### ADDITIVES



### SUBSTRATES



Properly cleaned and sanded aluminium, steel, galvanised steel, OEM paint system, SMC /GRP Glass Fibre Reinforced Polyester laminates and Bare Metal with P240 - P320. 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 (PA65) on plastic substrates.**

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

### SURFACE PREPARATION



Pre clean the surface with TD20 Silicone Remover, wipe on and wipe dry. Block-sand the surface with P360 - P400 grit abrasive to shape and level the repair area while minimizing deep sanding scratches.



Apply a guide coat. Finish sand with P500 or finer abrasive depending on colour sensitivity and the required surface quality.

Remove all sanding dust using a sanding vacuum and clean again with TD20 Silicone Remover, wipe on and wipe dry.

### NEXT LAYER



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

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



### PHYSICAL DATA

EU REGULATIONS PA38 1K UV Primer		
VOC Code	2004/42/IIB(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	IIB/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 (RTS)	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 m <sup>2</sup> /L/100 µm 403,8 ft <sup>2</sup> /Gal
	Gloss	Matt
	Colour	Transparent

### PROTECTION



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

[SDS Octoral](#)

**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 Octoral](#)

### 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.