1-350
Ultra Velocity (UV) Primer

GENERAL INFORMATION

1-350 Ultra Velocity (UV) Primer is a one component, light grey, translucent 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, the Berobase 500 Series and Waterbase 900⁺ Series. This product has been designed to accelerate your processing.

This TDS is about the liquid version.

MIXING RATIO

1 part Primer + 0 - 20% 1-351 UV Primer Thinner

Shake/stir before use.

COMPONENTS

1-351 UV Primer Thinner

GUN SETUP

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

ADDITIVES

-

APPLICATION

Max 2 full coats 100 - 150 µm (3,9-5,9 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.

Do not apply till coverage or cure in between.

POTLIFE

Unlimited, store mixed product in UV resistant containers.

SURFACE PREPARATION

Pre clean the surface with 1-951 Silicone Remover, wipe on and wipe dry. Sand surface with P180 - P240 grit abrasive. Remove all sanding debris with sanding vacuum & clean with 1-951 Silicone Remover, wipe on and wipe dry.

DRY & CURE 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	5 minutes	-	-	-
Second coat	5 minutes	3 min @ 5 cm	2 min @ 5 cm	4 min @ 30 cm

We recommend to use a UV-A lamp with a range of 320 nm – 400 nm. Consult lamp manufacturer or see UV-A lamp manual for specifications. UV light only cures what is in the direct line of sight. Check coverage area of the UV light.

NEXT LAYER

MM 900 - 9999 WaterBase 900⁺ Series
MM 500 - 5999 BeroBase 500 Series

Apply a matching grey shade for optimal results. After curing the 1-350 Ultra Velocity Primer requires cleaning with 1-151 Uni Thinner using two cloths, wipe on and wipe dry.

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. Do not use with polyethylene (PE) and pure polypropylene (PP). Always use an Plastic Primer (1-60) on plastic substrates.

Revision Date: October 2024

DEBEER REFINISH

BEST PRACTICES

1-350 Ultra Velocity Primer

STEP 1

Surface Preparation
Pre clean the surface with 1-951 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 1-951 Silicone Remover, wipe on and wipe dry.

Masking
Mask entire vehicle to eliminate unwanted overspray.

STEP 2

Preparation
Prior to use, thoroughly mix by hand.

Application
Apply 1 or 2 full coats of the 1-350 Ultra Velocity Primer. 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
Cleaning the Equipment / Per local regulations.

Flash-off
Allow a flash-off time of 5 minutes between coats. The 1-350 Ultra Velocity Primer must be cured with a UV-A light. Check coverage area of the UV light.

STEP 3

Dry & cure times and distance
When curing the 1-350 Ultra Velocity Primer always cure 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	5 minutes	-	-	-
Second coat	5 minutes	3 min @ 5 cm	2 min @ 5 cm	4 min @ 30 cm

We recommend to use a UV-A lamp with a range of 320 nm – 400 nm. Consult lamp manufacturer or see UV-A lamp manual for specifications. UV light only cures what is in the direct line of sight. Check coverage area of the UV light.

STEP 4

Cleaning
After curing the 1-350 Ultra Velocity Primer requires cleaning with 1-151 Uni Thinner using two cloths, wipe on and wipe dry.

Sanding
It is best practice to guide coat the 1-350 Ultra Velocity 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 of the radiation area of the UV-A lamp
- Apply a matching grey shade for optimal results

valspar AUTOMOTIVE

1-350
Ultra Velocity Primer

PHYSICAL DATA

1-350 Ultra Velocity Primer				
Volatile Organic Compounds (follows U.S. EPA VOC Data Sheet)				
Regulatory Data	As Packaged		As Applied	
	lb/gal	g/l	lb/gal	lb/gal
Density	7.70	923	7.5-7.7	899-923
	% by weight	% by volume	% by weight	% by volume
Total Volatiles	45.1	55.5	48-51	58-61
Water	0.0	0.0	0	0
Exempt Compounds	10.0	11.4	16.5-17.5	19-20
Percent Non-Volatile	54.9	44.5	49-52	39-42
VOC Total	2.70	323	2.6 Max	312 Max
VOC Less Exempt	3.05	365	3.2 Max	384 Max
Hazardous Air Pollutants (Clean Air Act, Section 112(b))				
	lb/gal	kg/l	lb/gal	kg/l
Volatile HAPS	0.77	0.092	0.7	0.083
VHAPS of Solids	1.73	0.207	1.73	0.207
LVP-VOC	35.10% by weight		32.3% by weight	

PROTECTION

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

https://sds.de-beer.com/en/debeer/choose_localization

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

CLEANUP

Cleaning the Equipment / Per local regulations.

STORAGE/SHELF LIFE

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

NOTES

This product is designed for UV-A 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.

Revision Date: October 2024