

## 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 refinishing 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.**

## GUN SETUP



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

## APPLICATION



Max 2 full coats 100 - 150 µm (3,9-5,9 mil)  
**Do not apply till coverage or cure in between.**

## 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.**

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

## POTLIFE



Unlimited, store mixed product in UV resistant containers.

## COMPONENTS



1-351 UV Primer Thinner

## ADDITIVES



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## 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.



## 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.**

### 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



## PHYSICAL DATA

EU REGULATIONS 1-350 Ultra Velocity Primer		
VOC Code	2004/42/IIIB(e)(840)455	
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)	20 - 22 Dincup 4 / 20°C
	Specific Gravity (kg/l)	1,267
	Flash Point Closed Cup	-15°C / 5°F
	Volume % Solids	77,6
	Economy	5,2 m <sup>2</sup> /L/150 µm 210,8 ft <sup>2</sup> /Gal
	Gloss	Matt
	Colour	Translucent Grey

## PROTECTION



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

[https://sds.de-beer.com/en/debeer/choose\\_localization](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.