1-350
Ultra Velocity Primer

GENERAL INFORMATION

1-350 Ultra Velocity 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 Berobase 500 Series and Waterbase 900+ Series. This product is designed to accelerate your processing times.

This TDS is about the aerosol version.

MIXING RATIO

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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)
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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 Plastic Primer (1-60) on plastic substrates.

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.

APPLICATION

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

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

POTLIFE

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COMPONENTS

1-151 Uni Thinner Medium

FLASH OFF AND DRY TIMES

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

The 1-350 Ultra Velocity Primer must be cured with a UV-A light. 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 DeBeer 1-151 Uni Thinner Medium. Wipe on and wipe dry.

ADDITIVES

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SANDING

It is best practice to guide coat the 1-350 Ultra Velocity Primer. Final sanding P400 - P600.

NEXT LAYER

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

Apply a matching grey shade for optimal results.

Revision Date: March 2021

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 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 1-350 Ultra Velocity 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 1-350 Ultra Velocity 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 1-350 Ultra Velocity 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 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 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/IIB(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		IIB/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	Matt
	Colour	Translucent Grey

PROTECTION

Use suitable respiratory protection *(fresh air supply respirator is strongly recommended)*.
sds.de-beer.com

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

CLEAN UP

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STORAGE/SHELF LIFE

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

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