

**PRODUCT:** LIGHT SPEED™ LED Cure High Build Premium Primer/Surfacer

**PART NUMBER:** 100398      **Quart**      **6 units/case**

**DESCRIPTION:** LIGHT SPEED™ LED Cure High Build Premium Primer/Surfacer is a 1K Ready To Spray UV LED Cured hybrid polyester primer surfacer that provides exceptional filling, passes 500 hours in salt spray tests (ASTM B117). Compatible with waterborne paint systems and VOC compliant. All substrates must be properly sanded and cleaned prior to primer application for optimum performance.

**SUBSTRATES:**



- Aluminum
- Fiberglass
- Galvanized Steel
- Sanded OEM Coatings
- Steel
- SMC
- Sanded Body Filler or Putty

**NOTE:** An epoxy pre-coat is **NOT** required for LIGHT SPEED™ LED Cure High Build Primer if a minimum of 2 coats with a dry film thickness of 4.5 – 6 mils (115 – 150 microns) are applied to achieve proper protection.

**CAUTION:** Do not apply over self-etch primers, acidic coatings, or after the use of acidic prep wipes as these materials can inhibit the curing process of polyester primers.

**CLEANING:**



- Surface must be clean and free of dirt, oil, grease and wax
- To solvent clean **raw, exposed fiberglass**, it is recommended to clean exposed area with **acetone**.

**PREPARATION:**

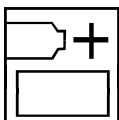


- Sand repair area with 80 grit and featheredge using 180 grit sandpaper
- Final clean with a quality wax and grease remover to remove sanding residue prior to application
- Prime carbon steel and aluminum immediately after sanding and dust removal

**Body Filler or Putty**

- Finish sanding body filler or putty with 180-220 grit sandpaper
- Featheredge surrounding area with 220 grit sandpaper
- Remove sanding dust residue with clean compressed air

**MIXING:**



- Shake the primer surfacer can thoroughly before use
- LIGHT SPEED™ LED Cure High Build Primer is ready to spray.

### APPLICATION:



- Apply **2-3** light to medium wet coats at a distance of 8-10 inches (20-25cm) allowing **1-2** minutes flash time between coats
- Allow a 5-minute purge time before activating with EVERCOAT UV LED Curing Gun
- Use the EVERCOAT UV LED Curing Gun to expose the primer for 5-6 minutes. Recommended light specs: Wavelength: 395nm, irradiance: min 30 mW/cm<sup>2</sup>.

### NOTE:

**Do not use in direct sunlight. Do not use sunlight for curing thick films as it may require longer exposure times.**

IMPORTANT SAFETY INFORMATION. The use of equipment not recommended by the manufacturer or contrary to the instructions may cause an unsafe condition.  
 READ AND FOLLOW ALL SAFETY INSTRUCTIONS with the UV/LED curing equipment manufacturer

### FINISH:



- Ready to sand after the 5-6 minutes exposure to curing light
- Sand with 220-320 grit or finer sandpaper prior to coating

*Follow coating manufacturer recommendations for final sanding specifications*

### TECHNICAL SPECIFICATIONS:

Appearance	Gray liquid
VOC	Refer to Section 9 of the Safety Data Sheet
Dry-Film-Thickness (DFT)	2.0 – 3.0 mils (50 – 75 microns) / coat
Maximum Film Build	9 mils (225 microns)
Spray Gun Setup	1.4mm – 1.8mm Fluid Nozzle
Pot Life	<b>N/A</b>
Air Dry	<b>N/A</b>
UV LED Force Dry	5-6 min exposure @ 8-10 in (20-25 cm) <b>Do not expose to sunlight for cure</b>
Recoat Window	<b>After sanding:</b> Within 7 days or light sand before coating <b>Un-sanded:</b> Within 30 days, then sand per finish procedures above
Total Solids by weight	70-80%

### SAFETY & HANDLING:

Read full instructions before use. This product contains hazardous materials and therefore appropriate personal protective equipment should always be used. Safety Data Sheets (SDS) and warnings displayed on product labels must be read carefully. SDS and product labels convey the possible health hazards, appropriate engineering controls, personal protection equipment and precautions to be observed in using the material. Copies of the SDS and product labels are available upon request. Consult your local environmental compliance agency for disposal of un-used products. Never dispose of products down the drain. If exposed, contact a POISON CONTROL CENTER IMMEDIATELY. KEEP OUT OF REACH OF CHILDREN. The information provided in this Technical Data Sheet is correct to the best of our knowledge, information and belief at the date of its publication.