



## **Spectraprime AP20-54 UV/sunlight Activated Filler/Bondo**

### Product Data/Application Instructions

---

Intended Uses:	A one component UV/sunlight cured filler/bondo
----------------	--

---

Product Description:	High build, fast drying, spray application. Good adhesion to metal, weather resistant. Good topcoat holdout. Improved surface drying in sun activated cure and UVA lamps
----------------------	--

---

Remarks:	Film will build rapidly with this product, do not spray to hiding, follow film thickness instructions. Do not apply more than two coats. If cleaning of the primer filler is desired prior to sanding, wipe surface with xylene, butyl acetate, dipropylene glycol methyl ether Do not apply in direct sunlight, as the product cures in sunlight Do not apply in the rain or extremely humid conditions Prepare and clean surface accordingly
----------	---

---

Product Information:	
Color	Gray
VOC Ready to Use	2.3 lbs/gal, 275 gm/liter
Mix Ratio	One Pack, ready to spray (MIX WELL BEFORE USE!!)
Spray Viscosity	~ 200 - 250 cps, equivalent DIN 4 cup at 68°F/20°C 16 – 18 sec
Gravity Cup/ Spraying Pressure	HVLP: 1.0 – 1.5 mm / 10 psi at air cap
Number of Spray Coats	Conventional: 1.0 – 1.5 mm / 45 – 60 psi
Film Thickness per Coat	No more than two
Thinner	1.5 – 5.0 mils (8 mils maximum) Not Required

Flash-off prior to UV/sunlight Cure	Temperature 68°F/20°C 1 – 2 min minimum flash between coats 3 – 5 min minimum flash before final UV/sun cure
Curing/Drying Mechanism	UV/Visible Light Irradiation with UVA lamp 3 – 10” away for no less than 3 min  Primer Filler can be cured by sunlight WARNING. Sunlight varies in intensity depending on location, weather, season and time of day. Exposure time is dependent on UV intensity under particular conditions, on average 5 – 20 min, but no less than 5 min. Surface cure may vary in sunlight and will indicate the extent of overall cure. Allow complete flash (see above) before exposing to sunlight.
Surface Cure	Very slight pull to the touch
Dry and Wet Sanding	320 – 500 sandpaper <hr/> Surface will be almost tackfree, and can be sanded without wiping, and will not load sandpaper when wet sanded. <hr/>

**Spectra Group Limited, Inc.**  
**27800 Lemoyne Rd, Ste J**  
**Millbury, OH 43447**  
**Ph (419) 837-9783; Fax (419) 837-6816**