Intended use

Mipa 1K-UV-Füller is a high-quality, UV-drying filler for fast and efficient spot repair. It can be sanded after only 5 minutes of irradiation with a UV LED lamp or Hg lamp (mercury vapour lamp). Alternatively, sanding is also possible after a 4-5 minutes exposure to direct sunlight.

Thus, significant savings can be made by eliminating heating-related costs. In the same time, cycles times are reduced since the painting process is not interrupted by heating intervals.

Further advantages of using Mipa 1K-UV-Füller-Spray are:

UV curing generates no heat, so the coated substrates remain cool. This protects substrates, particularly plastic ones, from deformation or overheating. Furthermore, no cooling-down period is required prior to sanding.

After curing, this filler provides a very hard surface with excellent sanding properties.

Outstanding mechanical and chemical resistance of the filler surface.

Mipa 1K-UV-Füller-Spray is perfectly suitable for spot repairs. Very good adhesion to smaller sanded-through areas on steel, iron, aluminium and galvanised substrates after appropriate pre-coating.

In addition, it offers direct adhesion on following plastic substrates: PU, ABS, PVC, PC and PS. Further types of plastic can be coated after the application of Mipa 1K-Kunststoffprimer or Mipa 1K-Haftpromoter (find more information about plastic types in the technical data sheets of Mipa 1K-Kunststoffprimer and Mipa 1K-Haftpromoter).

Processing instructions



Substrate

iron, steel, zinc and aluminium
plastics: PU, ABS, PVC, PC and PS

Pre-treatment / cleansing

Please refer to the section "Substrate preparation" for detailed information.

Characteristics

Fast drying
Excellent sandability
Very high filling properties
Cycle times can be reduced considerably
Excellent adhesion
Overcoatable with all common solvent- and water-based 1K and 2K topcoats
Economical because of the elimination of heating costs and long heating intervals

Colour / gloss level Grey transparent



Preparation

Before use, shake can until the metal balls inside the can rattle, then shake vigorously for another 2 - 3 minutes.



Do not subject the can to high mechanical stress!

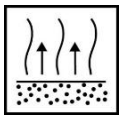
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MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49 8703 92 20 · Fax: +49 8703 92 21 00 · mipa@mipa-paints.com · www.mipa-paints.com



Application

Spray to test - spray distance approx. 20 - 30 cm
2,5 coats, dry film thickness: 60 - 70 µm



Flash-off time

30 s after the first light coat
no flash-off time between the 1st and 2 nd full coat
Final flash-off: 5 min prior to UV curing



After use

After use, turn can upside down and spray until the valve is clean, this prevents the valve from clogging up.



Drying time

UV LED-Lamp approx.	5 min
Hg-Lamp (mercury vapour lamp) approx.	5 min
Direct sun light approx.	4 - 5 min





Subsequent processing

Dry sanding:	For 1-layer topcoats P 400 For 2-layer topcoats P 500 - 600
Wet sanding:	For 1-layer topcoats P 600 For 2-layer topcoats P 800 - 1000

Processing conditions	From +15 °C and up to 80 % relative humidity. Ensure adequate air ventilation.
Storage	Can be stored for 1 year in cool and dry places.
VOC-regulation	EU limit value for the product (cat. B/e): 840 g/l This product contains max. 600 g/l of VOC.
Safety information	See safety data sheet

Processing instructions

Application: Apply 1st coat very thin (max. 10 µm DFT) and evenly, intermediate flash-off time: 30 s, then apply 2 full coats without intermediate flash-off, final flash-off time: 5 min before UV curing.

Although, the use of very powerful lamps shortens the drying time, this sudden drying can lead to severe coating damage such as wrinkling and cracking and/ or adhesion problems.

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Therefore, it is strongly recommended not to use such lamps or to make sure that the specified UV-drying times are observed.

When drying, consider also the time, which is needed to achieve full light power:

Hg-lamps (mercury vapour lamps) require a warm-up time of approx. 3 minutes and manufacturer's instructions must be observed respectively.

The recommended lamp distance to the object should be 20-30 cm.

If the light field of the UV LED-Light is too little to cover all at once the filler surface to be dried, the lamp must be moved overlapping the area already dried. Care must be taken to ensure that the exposure time for all partial areas is long enough to ensure a homogeneous drying of the entire surface.

The UV drying speed generally depends on the following factors:

- lamp intensity and UV spectrum
- rate of wear of the illuminant
- lamp distance
- applied coat thickness
- dimension of the refinished area

The recommended dry film thickness of 60 - 70 µm for two coats must be strictly observed.

When drying with LED lamps, the drying time of 5 minutes must be observed or, if necessary, extended to ensure complete curing of the filler coat.

By using mercury vapour lamps, which have a higher radiation intensity, the drying times can generally be reduced.

Substrate preparation:

The substrate must be clean, dry and free from oil, grease, rust, mill skill, rolling skin as well as other substances impairing the function of the coating!

Remove old coatings or primers that have not cured or are not sound.

Steel substrates:
1. Pre-clean with Mipa Silikonentferner.
2. Then dry sand with P 120.
3. Afterwards, degrease with Mipa Silikonentferner.

Aluminium substrates + galvanised substrates (strip galvanising / continuous hot-dip galvanising) and electrogalvanising:
1. Pre-clean with Mipa Silikonentferner.
2. Then dry sand with P 220.
3. Afterwards, degrease with Mipa Silikonentferner.

Galvanised substrates (batch galvanising / discontinuous hot-dip galvanising), surface cleansing with the ammonia solution Mipa Zinkreiniger:
1. Mix Mipa Zinkreiniger 1 : 1 with water.
2. Wet sand thoroughly with a corundum synthetic non-woven web to a matt finish.
3. Allow the resulting metallic grey suspension to work for approx. 10 minutes.
4. Sand again.
5. Afterwards, rinse thoroughly with water and allow the surface to dry.

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GRP:
1. Before painting, reheat the object to be painted for 60 minutes at 60°C.
2. Degrease with Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.
3. Sand thoroughly with P 240 - P 320.
4. Clean again with Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.
5. Allow parts to dry completely.
6. Recommended for neutralising electrostatic charges:

Blow off the surfaces by means of MP Ionisierungspistole X-ION, cleans and neutralises in one operation, reduces dust inclusions when coating. In addition, this avoids differences in pigment orientation when overcoating with metallic/ effect basecoats.

ATTENTION: Releasing agents must be removed completely! After the previously mentioned preparation, we recommend doing a wetting test with water. If the water drops roll off quickly, repeat the pre-treatment.

Intact, sound old paintworks, factory paintings:
1. Pre-clean with Mipa Silikonentferner.
2. Then sand with P 320.
3. Afterwards, degrease with Mipa Silikonentferner.

Cathodic e-coating / shop primer:
1. Pre-clean with Mipa Silikonentferner.
2. Then sand with MP Softpad Superfine or with P 320.
3. Afterwards, degrease with Mipa Silikonentferner.

Plastic substrates:
1. Before painting, reheat the object to be painted for 60 minutes at 60°C.
2. Degrease with Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.
3. Sand thoroughly with MP Softpad Superfine using Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.
4. Clean again with Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.
5. Allow parts to dry completely.
6. Recommended for neutralising electrostatic charges:
Blow off the surfaces by means of MP Ionisierungspistole X-ION, cleans and neutralises in one operation, reduces dust inclusions when coating. In addition, this avoids differences in pigment orientation when overcoating with metallic/ effect basecoats.

ATTENTION: Releasing agents must be removed completely!

After the previously mentioned preparation, we recommend doing a wetting test with water. If the water drops roll off quickly, repeat the pre-treatment.

This product provides direct adhesion to the following plastics: PU, ABS, PVC, PC and PS. W Other plastic types can be coated after application of Mipa 1K-Kunststoffprimer or Mipa 1K-Haftpromoter (for plastic types, refer to the technical data sheets of Mipa 1K-Kunststoffprimer and Mipa 1K-Haftpromoter).

Due to the wide range of plastic types and compounds available on the market, preliminary tests on original parts are indispensable.

When used as sanding filler, follow the sanding instructions below after drying:

1. For 1-layer topcoats, sand dry with P 400 or wet with P 600.

2. For 2-layer topcoats, we recommend dry sanding with P 500 / 600 or wet sanding with P 800 / 1000.

3. Thoroughly remove sanding dust using Mipa Silikonentferner or Mipa WBS Reiniger or Mipa WBS Reiniger FINAL. Use clean, lint-free wiping cloths.

It is recommended that the sanded surfaces and/ or joints, grooves etc. are thoroughly blown off with oil-free compressed air.

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4. Then clean the surface to be painted with Mipa Silikonentferner, Mipa WBS Reiniger or Mipa WBS Reiniger FINAL using a new, clean cloth.

Once the cleaners have dried completely without leaving streaks, apply the topcoat.

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