

**Intended use**

Mipa 1K-UV-Füller is a high-quality, UV-drying filler for fast and economic refinishes, which can be sanded already after 5 minutes irradiation by a UV LED-Light or mercury vapour lamp. Alternatively, sanding is also possible after a 4 - 5 minutes exposure to direct sunlight. It is therefore possible to save significantly heating-related costs. In the same time, cycle times are reduced since the painting process is not interrupted by heating intervals. Further advantages of Mipa 1K-UV-Füller are as follow:

One-component system, ready for use. Therefore it can be used immediately and does not produce any paint waste because of pot life-related hardening.

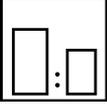
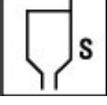
Substrates do not need be heated, which protects especially plastic substrates from deforming and overheating. In addition, there is no need to observe a cooling phase prior to sanding.

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

Mipa 1K-UV-Füller is perfectly suitable for partial car coatings and spot repairs. Very good adhesion on steel, iron, aluminium and galvanized substrates. In addition, it offers direct adhesion on following plastic substrates: PU, ABS, PVC, PC and PS. Further types of plastic can be recoated 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-Adhesion-Promoter).

Spreading rate: 285 - 325 sp.ft/gal by 1 mil.

**General informations**

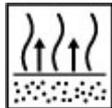
	<b>Colour</b> grey glazing		
	<b>Mixing ratio</b>		
	<b>Hardener</b>	<b>by weight (lacquer : hardener)</b>	<b>by volume (lacquer : hardener)</b>
	--	--	--
	<b>Hardener</b>		
	<b>for complete paintwork</b>		<b>for partial paintwork</b>
	--		--
	<b>Pot life</b> none, if stored in a lightproof area		
	<b>Thinner</b> --		
	<b>Spray viscosity</b>		
	ready for use		
	after a longer period of time, stir the material thoroughly		
	after a longer period of time in the gravity cup, stir the material thoroughly		
	<b>gravity spray gun</b>		<b>Airmix/Airless</b>
	16 - 18 s 4 mm DIN		--

This technical data sheet is supplied for informational purposes only! According to our information, all data and recommendations correspond to the state of art and are based on years of experience in manufacturing our products. They do not exempt the user from his obligation to verify professionally, on his own responsibility, the suitability of our products to the intended purpose under prevailing conditions. Safety data sheets and warnings on packaging must be observed. We reserve the right to modify and to complete the information content at any time, without prior notice or obligation to update.



**Application mode**

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	dilution (%)
HVLP (low pressure)	–	1,6 - 2	1,0 - 1,2	2, max. 3	–
HVLP (low pressure)	–	1,6 - 2	1,0 - 1,2	2, max. 3	–
HVLP / internal nozzle pressure	–	0,7	–	–	–



**Flash-off time**

in case of 2 coats without intermediate flash-off  
in case of 3 coats: prior to 3rd coat  
5 min. UV curing + intermediate sanding  
final flash-off: 5 min prior to UVcuring

**Dry coat thickness**

3 - 4 mil for 2 coats  
max. 6 mil for 3 coats  
Do not apply covering. Avoid the application of too thick layers!



**Drying time**

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
–	–	–	–	–	–

**Note**

**Storage:** At least 1 year at room temperature 70° F (20°C) in unopened original container.

**VOC Information:** VOC as packaged:  
Less exempt solvents < 400 g/l / 3.3 lb/gal  
With exempt solvents < 400 g/l / 3.3 lb/gal  
Always check local VOC laws to ensure that the use of Mipa products is compliant in your area.

**Processing conditions:** From 50 °F (10 °C) and up to 80 % relative air humidity.  
Ensure an adequate supply and exhaust air ventilation.

**General informations:**

Due to the system, storage causes phase separation of the material in the container. This is specific to the product and can be removed by thorough mixing. Phase separation may also happen when this product is kept in the gravity cup for a longer period. Therefore, it is necessary to thoroughly stir the filler.

Drying:

UV LED-Light: approx. 5 min.

Hg-Lamp (mercury vapour lamp) approx. 5 min.

Direct sunlight: approx. 4 - 5 min., please observe: When drying with sunlight, the dry film thickness of 3 mil (75 µm) must not be exceeded, otherwise through-drying problems may occur.

Note:

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. 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 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 all partial areas are irradiated sufficiently for a homogeneous through drying of the entire surface.

The UV drying time depends generally on following factors:

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

The recommended dry film thickness of 3 mil for 2 coats must be observed. If higher coat thicknesses are required (max. 6 mil), it is necessary to do an intermediate UV-drying after the application of the 2nd coat. When drying with LED lamps, especially in case of thicker layers, the drying time of 5 minutes must be observed or, if necessary, extended to ensure complete curing of the filler layer. 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 grease. Sand slightly the surface and degrease with Mipa Silikonentferner. Remove non adhering old paintworks and primers.

Sand aluminium and galvanized substrates with grain P 220, steel with P 120. After sanding clean again thoroughly with Mipa WBS Cleaner LV.

Plastics:

Before application, reheat the parts to be painted for 60 minutes at 140 °F (60 °C).

Degrease the surface thoroughly with Mipa WBS Cleaner LV.

Sand thoroughly with MP Softpad super fine using Mipa WBS Cleaner LV.

Clean again.

Allow parts to dry completely.

ATTENTION: Mould release agents must be removed completely! After the aforesaid preparation we recommend doing a wetting test with water. If the water rolls off quickly repeat the pre-treatment.

Important: Do not exceed the maximum dry film thickness of 4 mil on plastics.

Application:

apply 2 coats (dry film thickness 3 mil) without intermediate flash-off +  
5 min. flash-off at room temperature +  
5 min. UV drying

3 coats (dry film thickness max. 6 mil):  
apply 2 coats without intermediate flash-off +  
5 min. flash-off at room temperature +  
5 min. UV drying +  
intermediate sanding with P 400 - 500 +  
apply 3rd coat +  
5 min. flash-off at room temperature +  
5 min. UV drying +

Important: Mipa 1K-UV-Füller must not be applied covering, The application of too thick layers must be avoided, otherwise adhesion and curing problems may occur.

Information about sanding of the filler:

In case of one-layer topcoat use sanding paper P 400 for dry sanding or P 600 for wet sanding. In case of a two-layer topcoat we recommend to use the sanding paper P 500 / 600 for dry sanding and P 800 / 1000 for wet sanding.

Safety aspect:

For professional use only. Not for sale to or use by the general public. Before opening the packages be sure you understand the warning Messages on the Labels and Safety Data Sheets of all components since the mixture will have the hazards of all of its parts. The manufacturer recommends the use of an air supplied Respirator when exposed to vapors or spray mist.

Medical Response:

Emergency Medical or Spill Control Information 011 49(0)700 24112112 (MIP)  
US Emergency Phone Number (for transportation incidents only) 1-800-535-5053  
(Infotrac)

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