

Intended use

Mipa 1K-UV-Spachtel is a high-quality, UV drying fine putty for fast and efficient filling of small damages. It can be sanded after only 5 minutes of irradiation with a UV LED lamp or Hg lamp (mercury vapour lamp). 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-Spachtel are:

1K-System, ready for spraying. Therefore, it can be used immediately, no hardener needs to be added, and it does not produce any paint waste because of pot life-related hardening.

Substrates do not need to 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.

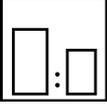
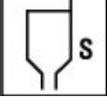
After curing, this putty provides a very hard surface with excellent sanding properties.

Outstanding mechanical and chemical resistance of the putty surface.

Mipa 1K-UV-Spachtel is particularly suitable for small car damage repairs and for use in spot repairs as a fine putty with a maximum dry film thickness of approx. 60 mil (1500 µm). Very good adhesion to steel, iron, aluminium, galvanised substrates, GRP and wood. In addition, it provides direct adhesion to the following plastics: ABS, PVC and PC.

Spreading rate: --

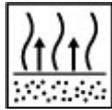
General informations

	Colour grey-greenish transparent		
	Mixing ratio Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
	--	--	--
	Hardener for complete paintwork		for partial paintwork
	--		--
	Pot life none, if stored in a lightproof area		
	Thinner --		
	Spray viscosity gravity spray gun		Airmix/Airless
	--		--



Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	dilution (%)
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Flash-off time

without flash-off time prior to UV curing

Dry coat thickness

max. 60 mil (1500 µm)



Drying time

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

Storage:

In tightly closed original containers at least 2 years shelf life.
Storage temperature range 50 - 86°F (10 - 30 °C)
Protect package from direct sunlight and heat.

VOC Information:

VOC as packaged and applied:
less exempt solvents 24 g/l / 0,2 lb/gl
with exempt solvents 24 g/l / 0,2 lb/gl

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:

Drying:

UV LED-Light: approx. 5 min.

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

Drying by means of sunlight is not permitted.

The dry film thickness of max. 60 mil (1500 µm) must not be exceeded, otherwise through drying problems will 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 8 - 12 inch (20 - 30 cm).

If the light field of the UV LED-Light is too little to cover at once the putty 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 60 mil (1500 µm) must absolutely be observed. 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 putty 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. Do not apply on thermoplastic or acid products (etch primer).

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

Plastics:

Degrease the surface thoroughly with Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.

Sand thoroughly with MP Softpad super fine using Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.

Clean again with Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.

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.

Application:

Apply putty with a dry film thickness of up to max. 1500 µm. No intermediate flash-off time is required before UV drying, afterwards 5 min. UV drying.

Information about sanding the putty:

After drying, dry sand with sanding paper P 150 / 240. Sand the entire surface with dry sandpaper P 240 / 360 to a matt finish before applying the filler.

In case of filling work on non-ferrous metals (e.g. aluminium, galvanised surfaces) it is possible to apply a priming coat with Mipa EP-Primer-Surfacer to ensure an optimal adhesion before applying the body filler.

Do not overcoat without having isolated the surface with 1K or 2K filler. In order to improve the corrosion protection, e.g. when restoring vintage cars, prime with Mipa EP-Primer-Surfacer (see technical data sheet of Mipa EP-Primer-Surfacer).

Body filler can only be dry sanded.

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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