

# Mipa 1K-UV-Füller-Spray

Item no. 21377 0000

Technical data sheet

**mipa**

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## 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: 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 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



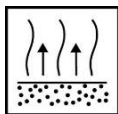
### Preparation

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



### 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 2nd full coat  
Final flash-off: 5 min prior to UV curing

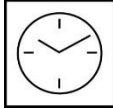
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This technical data sheet is supplied for informational purposes only! According to our information, all data and recommendations correspond to the state of art and are based on years of experience in manufacturing our products. They do not exempt 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.



### 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.

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 scale, 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.

### 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.

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.