

### Intended use

Mipa 1K-UV-Dickschichtfüller is a high-build, UV-drying filler for fast and efficient refinishing, which can be sanded after only 5 minutes of irradiation with a UV LED lamp or Hg lamp (mercury vapour lamp) even in case of high film thicknesses. Alternatively, sanding is also possible after a 4-5 minutes exposure to direct sunlight. It is therefore possible to save significantly heating-related costs. At the same time, cycle times are reduced since the painting process is not interrupted by heating intervals. Further advantages of Mipa 1K-UV-Dickschichtfüller are as follows:

1K system, ready for use. Therefore it can be used immediately and does not produce any paint waste caused by 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.


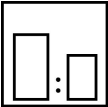




After curing, this filler provides a very hard surface with excellent sanding properties.

Outstanding mechanical and chemical resistance of the filler surface.

Mipa 1K-UV-Dickschichtfüller perfectly suitable for partial car coatings and spot repairs. Very good adhesion to steel, iron and galvanised Substrates.

Spreading rate: 5,5 - 6,5 m<sup>2</sup>/l (at 100 µm DFT)

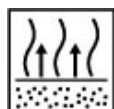
### Processing instructions

	<b>Colour</b> grey transparent		
	<b>Mixing ratio</b>	<b>by weight (lacquer : hardener)</b>	<b>by volume (lacquer : hardener)</b>
	<b>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. If necessary, thin with Mipa Aceton. 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> 30 - 40 s 4 mm DIN	<b>Airmix/Airless</b> --	



### Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
gravity spray gun / HVLP	--	1,6 - 2	1,3 - 1,6	1 - 2	--
HVLP (low pressure)	--	1,6 - 2	1,3 - 1,6	1 - 2	--
HVLP / internal nozzle pressure	--	0,7	--	--	--



### Flash-off time

3 - 5 min intermediate flash-off time  
5 min final flash-off time prior to UV curing

### Dry coat thickness

100 - 200 µm  
Do not apply covering coats. Avoid the application of too thick layers!



### Drying time

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

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

**VOC Regulation :** EU limit value for this product (category B/c): 540 g/l  
This product has max. 250 g/l of VOC.

**Processing conditions:** From +15 °C and up to 80 % relative air humidity. Ensure an adequate air ventilation.

### Processing instructions:

Due to the system, storage causes phase separation of the material in the container. This is specific to the product and can be remedied by thorough mixing. Phase separation may also occur 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 200 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
- dimension of the refinished area

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 galvanised substrates with grain P 220, steel with P 120. After sanding clean again thoroughly with Mipa Silikonentferner.

Important: Mipa 1K-UV-Dickschichtfüller must not applied as a covering coat. Avoid excessive coating, otherwise adhesion and curing problems will 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 using the sanding paper P 500/ 600 for dry sanding and P 800/ 1000 for wet sanding.