

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 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.


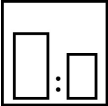





After curing, this putty provides a very hard surface with excellent sanding properties.

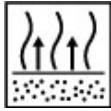
Outstanding mechanical and chemical resistance of the putty surface.

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. 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: --

Processing instructions

	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	Thinner
	--	--	--	--	--	--



Flash-off time

without flash-off time prior to UV curing

Dry coat thickness

max. 1500 µm



Drying time

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

Storage:

at least 2 years at room temperature (20°C) in unopened original container
Immediately close the container light-proof after each use. Always protect the product from direct sunlight.

VOC Regulation :

EU limit value for this product (category B/b): 250 g/l
This product contains max. 3 g/l of VOC.

Processing conditions:

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

Processing instructions:

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. 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 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 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 (Wash primer).

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

Plastics:

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

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.