

Intended use

Mipa 1K-UV-Klarlack is a high-quality UV-curing clearcoat system for fast and efficient refinishing of small damages and for spot repair. It cures only 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 when using Mipa 1K-Klarlack are as follows:

1K-System, ready for spraying. Therefore it can be used immediately and does not produce any paint waste because of pot life-related hardening.


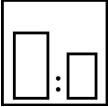




After curing, this clearcoat provides a very hard clearcoat surface with excellent polishing properties.

The clearcoat surface is very resistant to mechanical stress and chemical agents.

Mipa 1K-UV-Klarlack is perfectly suitable to overcoat cured Mipa WBC and BC basecoats.

Spreading rate: 11,0 - 12,0 m²/l (for 50 µm DFT)

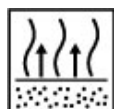
Processing instructions

	Colour colourless		
	Mixing ratio		
	Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
	--	--	--
	Hardener		
	for complete paintwork		for partial paintwork
	--		--
	Pot life none, if stored lightproof		
	Thinner --		
	Spray viscosity ready for spraying gravity spray gun 13 - 15 s 4 mm DIN		Airmix/Airless --



Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
gravity spray gun (high pressure)	--	2 - 2,5	1,0 - 1,2	2	--
HVLP (low pressure)	--	2 - 2,2	1,0 - 1,2	2	--
HVLP / internal nozzle pressure	--	0,7	--	--	--



Flash-off time

applicable without intermediate flash-off
 final flash-off 5 min prior to UV-curing

Dry coat thickness

50 - 60 µm
 The maximum dry film thickness must not be exceeded!



Drying time

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

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

VOC Regulation : EU limit value of the product (cat.B/e): 840 g/l
 This product contains max. 385 g/l of VOC.

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

Processing instructions: When using Mipa 1K-UV-Klarlack, it is necessary to add 2K hardener to the Mipa 2K basecoats. The amounts to be added are as follows:

Mipa BC + 10 % (10:1) Mipa 2K-MS-Härter MS 10 or 2K-HS-Härter HS 10

Mipa WBC + 5 % (20:1) Mipa WBC-Härter

Drying:

UV LED-Lampe approx. 5 min

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

Observe the drying time of maximum 5 minutes! If the lamp intensity differs, carry out a test coating in advance to determine the maximum exposure time.

Shortly after UV curing, the clear coat has a yellowish tint, especially on light-coloured substrates. However, due to the so-called photo bleaching effect, the clearcoat film is bleached out again by daylight and thus becomes "more bluish". In order to be able to estimate the resulting shade, create an appropriate colour sample in advance.

Note:

When drying, consider also the time, which is necessary 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.

The recommended lamp distance to the object should be 20 -30 cm.

If the clearcoat area to be dried is too large to be covered all at once by the exposure field of the UV LED-lamp, 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 sufficiently long to ensure homogeneous drying of the entire surface.

The UV-curing speed generally depends on the following factors:

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