



# UV-Filler

## 1K-Performance

**NEW FORMULAR**


### Product information

29-03-2021 V5

AP-Merit 1K-UV-Filler is a high-quality, UV-drying filler for fast and efficient refinishing, which can be sanded after only 5 minutes of irradiation by means of a UV LED lamp. Alternatively, this is also possible after 4 - 5 minutes of direct sunlight. Thus, large savings are possible due to the elimination of heating-related costs. At the same time, very fast cycle times are given, since the painting work does not have to be interrupted by heating intervals. Substrates do not have to be thermally heated, which protects plastic substrates in particular from deformation or overheating. In addition, there is no need for a cooling phase before sanding. After curing, a very hard and excellently grindable filler surface is obtained. Very high mechanical and chemical resistance of the filler surfaces.

Particularly suitable for partial car painting and use in spot repair.

Consumption: 7 - 8 m<sup>2</sup>/l (with 100 µm)

Color	grey glazing		
Dilution	ready to spray		
Pot life	None, with light-tight storage		
Processing	Pressure	Nozzle	Layers
Gravity spray gun	1,6 – 2 bar	1,0 – 1,2 mm	2
HVLP	1,6 – 2 bar	1,0 – 1,2 mm	2
Flash-off time	2 coats without intermediate flash-off 5 minutes before the oven drying		
	For 1-coat top coats, the use of sandpaper P 400 dry or P 600 wet is recommended.  For 2-coat top coats, the use of sandpaper P 500 / 600 dry or P 800 / 1000 wet is recommended.		
Dry film thickness	100-120 µm with 2 spray passes		
VOC regulation	EU limit value: Category B/c 540 g/l This product contains max. 190 g/l.		

**Always stir the container thoroughly. Simple shaking is not sufficient!**

**AP-Merit 1K-UV-Filler must not be applied covering, The application of too thick layers must be avoided, otherwise adhesion and curing problems may occur.**

We recommend using this filler only in the spot repair area. The size of the filler area should be adjusted to the exposure field of the UV LED lamp at a distance of 20-30 cm. The exposure field should cover the area at once.

**Surface:**

Very good adhesion to steel, iron, aluminum and galvanized surface.

The surface must be clean, dry and free of grease. Sand surfaces and degrease with AP-Merit Silicone Remover. Remove non-supporting old coatings or primers. Sand aluminum and galvanized surfaces with P 220, steel with P 120.

After sanding, clean again thoroughly with AP-Merit 7539 Silicone Remover.

For application on plastic, a suitable plastic primer must be used. In addition, direct adhesion is given on the following plastics: PU, ABS, PVC, PC and PS.

**Drying:**

The UV drying speed always depends on the following factors:

- Lamp intensity and UV spectrum
- Degree of wear of the lamp
- lamp distance
- applied layer thickness
- size of the repair area
  
- UV LED-Light: approx. 5 min
- Hg-Lamp (mercury vapour lamp) approx. 5 min
- Direct sunlight: approx. 4 - 5 min

**Important 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.

We recommend a UV-A LED lamp with an irradiance of  $> 6\text{mW/cm}^2$  (e.g. AP-Merit UV-LED Akku Lampe 30 Watt Nr: 75490 ) and to achieve a complete through-drying a drying time of 5 minutes.

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

The drying time must also take into account the time required to reach full light output. If the filler surface to be dried is too large to be covered by the exposure field of the UV LED lamp at once, the lamp must be moved to overlap accordingly. Care must be taken to ensure that the exposure time for all partial areas is sufficiently long to ensure homogeneous through-drying of the entire area.

Processing conditions: From  $+ 10^{\circ}\text{C}$  and up to 80 % relative humidity.

Storage: Can be stored for at least 1 year in the sealed original container.

This product sheet is for information purposes only ! To the best of our knowledge, the information given here corresponds to the state of the art and is based on many years of experience in the manufacture of our products. However, the information is nonbinding and without guarantee.

Wolfgang GesmbH. – [www.ap-merit.com](http://www.ap-merit.com) – [office@ap-merit.com](mailto:office@ap-merit.com) -Tel.: +43 5576 72330