Intended use

This 2K polyurethane wet-in-wet filler can be quickly overcoated and provides universal adhesion: directly applicable on steel, iron, aluminium and galvanized substrates as well as on commonly used plastics in the automotive industry (e.g. PP-EPDM, ABS, PC, ABS-PC, PUR, PVC, GRP). Please observe the detailed pre-treatment instructions for this purpose in the section Processing Instructions / Plastic Substrates on page 3.

Furthermore, it is possible to overcoat intact, sound e-coatings without any pre-sanding. Mipa 2K-HS-NiN-Füller F 37 can be overcoated without intermediate sanding within 5 days (at a temperature of 20 °C).

Mipa 2K-HS-NiN-Füller F 37 can be overcoated after a drying time of only 15 minutes at 20°C without loss of gloss and ensures outstanding overspray absorption at the same time. Especially designed for cars refinishing. Suitable also for commercial vehicle and industrial sector for van bodies, platform gates, cabs, machines, and so on.

Spreading rate: 11,5 - 12,0 m²/l (for 25 µm DFT)

Processing instructions

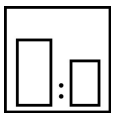


Colour

light grey (approx. RAL 7047)

dark grey (approx. RAL 7011)

white



Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
Mipa 2K-Härter H 10	--	5 : 1
Mipa 2K-MS-Härter MS 10	--	5 : 1
Mipa 2K-MS-Härter MS 25	--	5 : 1



Hardener

for complete paintwork	for partial paintwork
--	Mipa 2K-Härter H 10, Mipa 2K-MS-Härter MS 10
--	at higher temperatures or larger passenger car surfaces:
--	Mipa 2K-MS-Härter MS 25



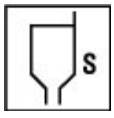
Pot life

2 h at 20 °C



Thinner

25 - 30 % Mipa 2K-Verdünnung normal V 25



Spray viscosity

gravity spray gun	Airmix/Airless
16 - 18 s 4 mm DIN	--

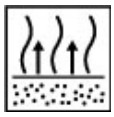
This technical data sheet is supplied for informational purposes only! According to our information, all data and recommendations correspond to the state of art and are based on years of experience in manufacturing our products. They do not exempt the user from his obligation to verify professionally,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

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Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	dilution (%)
gravity spray gun (high pressure)	--	1,6 - 2	1,3 - 1,5	1	25 - 30 %
HVLP (low pressure)	--	1,6 - 2	1,3 - 1,5	1	25 - 30 %
HVLP / internal nozzle pressure	--	0,7	--	--	--



Flash-off time

--

Dry coat thickness

25 - 40 µm



Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	--	--	--	--	15 - 20 min
--	--	--	--	--	20 - 30 min when using MS 25

Note

Storage: At least 3 years in unopened original container.

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

Processing conditions: From +10° C and up to 80 % relative air humidity. Ensure an adequate air ventilation.

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Processing instructions:

In general, apply only 1 uniform, flowing coat in order to ensure the best possible flow. If there are strongly absorbent areas in the surface to be painted (e.g. body filler spots), prime these areas beforehand by applying just a spray coat. After a short flash-off time of approx. 2 - 3 minutes at 20 °C, apply the final coat on the whole surface.

Substrate preparation:

The substrate must be clean, dry and free from grease.

Steel substrates: pre-clean with Mipa Silikonentferner, afterwards sand with P 120 and subsequently degrease with Mipa Silikonentferner.

Aluminium substrates: pre-clean with Mipa Silikonentferner, afterwards sand with P 220 and subsequently degrease with Mipa Silikonentferner.

Zinced substrates (batch galvanising/ discontinuous hot-dip galvanizing): clean the surface with the ammonia solution Mipa Zinkreiniger

Zinced substrates (strip galvanising / continuous hot-dip galvanising) and electrogalvanising: pre-clean with Mipa Silikonentferner, afterwards sand with P 220 and subsequently degrease with Mipa Silikonentferner.

Plastic substrates:

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

Degrease the surface thoroughly with Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.

Sand 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: Releasing agents must be removed completely! After the aforesaid preparation we recommend to do a wetting test with water. If the water rolls off quickly repeat the pre-treatment.

Adheres directly to the following plastics: PP-EPDM, ABS, PC, ABS-PC, PUR, PVC and GRP.

These and other plastics can generally, or in case of doubt, be pre-treated with Mipa 1K-Kunststoffprimer or Mipa 1K-Haftpromoter to avoid possible adhesion problems.

Due to very different kinds of plastics and mixtures available on the market, we recommend testing beforehand on the original plastic substrate.

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