Mipa P 60 S Polyester-Dickschicht-Spritzfüller

Intended use

Mipa P 60 S Polyester-Dickschicht-Spritzfüller is a two-component body filler based on polyester resin for steel substrates, GRP, wood or sanded, solid paintwork. This product is especially suitable for the filling of irregularities, deep sanding marks as well as rough pre-repair work in a single filling process.

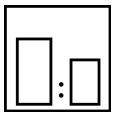
Spreading rate: 4,0 - 6,0 m²/l

Processing instructions



Colour

grey



Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
Mipa Härter PS	30 : 1	100 : 5
--	e. g. 300 g : 10 g /	950 ml P 60 S : 50 ml
--	450 g : 15 g / 600 g : 20 g /	--
--	750 g : 25 g / 900 g : 30 g	--



Hardener

for complete paintwork	for partial paintwork
--	--



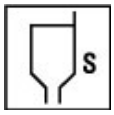
Pot life

30 min with Mipa Härter PS at 20 °C



Thinner

0 - 5 % Mipa PE-Verdünnung



Spray viscosity

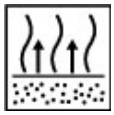
ready for use after addition of hardener; thin if necessary

gravity spray gun	Airmix/Airless
--	--



Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	dilution (%)
gravity spray gun (high pressure)	--	1,6 - 2	2 - 2,5	2 - 5	0 - 5



Flash-off time

5 - 8 min between coats

10 - 15 min before ofen drying

Dry coat thickness

150 - 300 µm

maximum 1000 µm

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Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	--	--	--	2 - 3 h	--
60 °C	--	--	--	30 min	--
Infrared drying (distance approx. 80 cm and max. 80 °C)	--	--	--	10 - 15 min	--

Note

Storage:
At least 1 years in unopened original container.
Store in a cool, dry place at 15 - 25 °C.
Protect from overheating and avoid direct sunlight.
Close the container tightly immediately after use and keep away from sources of ignition.

VOC Regulation:
EU limit value for this product (category B/b): 250 g/l.
This product contains max. 125 g/l of VOC.

Processing conditions:
From +10 °C and up to 80 % relative air humidity. Ensure an adequate supply and exhaust air ventilation. Polyester-based body filler does not cure anymore at a temperature of below +10 °C.

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Processing instructions:

The substrate must be clean, dry and free from grease. Sand the surface slightly. Remove not cured old paint works and priming coats.

The product tends to separate the solvent. This is a characteristic of the system and it is advisable to stir the material well before use.

Do not apply to thermoplastic or acid products (Reaktionsprimer).

Under- or overdosage of hardener may cause spotting in the finishing paint layer.

Clean and degrease the whole surface to be painted with Mipa Silikonentferner before every operation.

De-rust defective spots to bare metal and dry sand with sanding paper P 80 / 150.

Zinced substrates must be insulated with Mipa EP-Grundierfiller or Mipa EP-Primer-Surfacer.

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).

After drying, sand as follows:

Dry sanding with P 150 / P 240 sandpaper. Before applying the primer / filler, sand the entire surface to a matte finish using P 240 / P 360 dry sandpaper.

Alternatively, wet sanding may be performed:

Wet sanding with P 150 / P 240 sandpaper. Before applying the primer / filler, sand the entire surface to a matte finish using P 240 / P 360 wet sandpaper.

Please note: Before topcoating, ensure that any areas subjected to wet sanding have dried sufficiently to prevent residual moisture in the substrate.

Do not overcoat without having isolated the surface with Mipa 1K or 2K filler.

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