Intended use

Mipa P 67 S PE-Spritzfüller is a two-component body filler with outstanding filling properties that has been especially developed to level out colourlessly imperfections on synthetic fibre substrates (e. g. glass or carbon fibre reinforced composites) before applying a clearcoat. Thanks to its excellent filling properties, porous surfaces and surface defects, which emerge often on composite substrates, can be levelled quickly and effectively. Once the required surface smoothness has been achieved, Mipa 2K-HS-Carbonic-Klarlack can be applied as high-quality finishing. Mipa P 67 S PE-Spritzfüller and Mipa 2K-HS-Carbonic-Klarlack guarantee high UV protection which protects effectively substrates that prone to yellowing (also carbon substrates) from discolouration caused by weather. Adhesion on carbon and other composite substrates, steel plate, zinced sheets, aluminium as well as on timber. If required, the filler can be tinted with Mipa PMI pastes.

Spreading rate: 4,0 - 6,0 m²/l

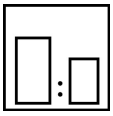
Processing instructions



Colour

transparent,

if required, add Mipa PMI pastes to tint, up to max. 10% possible



Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
Mipa MEKP-Härter	2,5 %	--



Hardener

for complete paintwork	for partial paintwork
--	--



Pot life

20 min with Mipa Härter MEKP at 20 °C



Thinner

0 - 5 % Mipa PE-Verdünnung



Spray viscosity

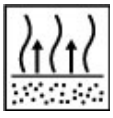
ready for use after addition of hardener; thin if necessary

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 - 3	--



Flash-off time

3 - 5 min between coats

10 - 15 min before oven drying

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Dry coat thickness

150 - 300 µm

maximum 800 µm



Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	1 h	--	--	6 h	--
60 °C	--	--	--	30 min	--
Infrared drying (distance approx. 80 cm and max. 80 °C)	--	--	--	10 - 15 min	--

Note

Storage:

At least 1 year 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.175 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:

Due to the system Mipa P 67 S PE-Spritzfüller has a light green inherent colour which disappears after the hardener has been added. On carbon substrates, the Mipa P 67 S PE-Spritzfüller coating looks clear and transparent with the usual dry film thickness.

General notes on the subject of "colourless carbon coating":

The paint structure and the number of work steps in the colourless coating of carbon substrates depend basically on the following factors:

1. Substrate quality of the carbon layer: The coarser the carbon texture and the porosity is, the more layers of clear lacquer with intermediate sanding are necessary to ensure optimum levelling by means of clear coating, or a colourless filling of deeper pores and imperfections with Mipa P 27 Crystal PE-Transparentspachtel is required. If the filling power is required to be as high as possible to smooth the carbon texture, Mipa P 67 S PE-Spritzfüller should be used as a colourless filler layer.

Furthermore, it has to be taken into account that composite substrates have a system-related sagging behaviour which (depending on the substrate quality) can be more or less pronounced and which can have a negative effect on the appearance of the clearcoat afterwards.

2. Desired finish: The higher the requirements for the clearcoat, the higher the workload for coating. Depending on the carbon surface quality and for example in case of low requirements for the clearcoat surface, 3 coats of clearcoat including intermediate sanding may be sufficient. However, if a piano lacquer finish is desired, this may require 4 to 6 clearcoat layers including intermediate sanding. In addition, a final polishing step is required to ensure a flat and absolutely perfect clearcoat layer.

3. Since carbon substrates have a strongly varying surface quality due to the production process and since release agents are used for de-moulding, adhesion problems can generally occur. We therefore recommend doing a test coating with subsequent adhesion testing to ensure good adhesion. If you observe delamination, we recommend using the adhesion promoter Mipa 1K-Haftpromoter.

In the following, various colourless carbon coating structures are presented, which, depending on the quality of the carbon texture or on the requirements on the final coating quality, consist of several painting steps:

Pre-treatment:

Carbon substrates must be clean, dry, free from dust, oil and grease and free from all adhesion inhibiting substances (e.g. release agents). Therefore clean thoroughly with Mipa Silikonentferner.

Dry sand the carbon surfaces with grit P 240 up to P 400. Care must be taken that the carbon surface is not sanded through to the fibre layer.

In case of heavy dust formation during sanding, use oil- and water-free compressed air to blow it away from the carbon substrates. Afterwards, clean thoroughly using Mipa Silikonentferner.

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Clear coating structure: Mipa 2K-HS-Carbonic-Klarlack

A. filling coat with clearcoat Mipa 2K-HS-Carbonic-Klarlack

1. apply uniformly and generously 2 to 3 coats
2. 10 - 30 min. flash-off at room temperature
3. 15 min. intermediate drying at 60 °C or 25 min. at 40 °C (if Mipa 2K-HS-Härter HS 25 is used) + cooling + dry intermediate sanding with grit P 240 to P 400

Optionally, intermediate sanding can be omitted if the carbon base is very smooth or quality requirements do not require intermediate sanding.

Alternatively, drying at room temperature can be carried out instead of oven drying. In this case, overcoating is possible at the earliest after 1 hour at 20°C. If the first coating/ filling coat has dried for more than 10 - 12 hours, dry intermediate sanding with grit P 240 to P 400 is necessary.

B. clear top coating with Mipa 2K-HS-Carbonic-Klarlack

1. apply uniformly and flowing 2 to 3 coats
2. 10 - 30 min. flash-off at room temperature
3. 15 min. intermediate drying at 60 °C or 25 min. at 40 °C (if Mipa 2K-HS-Härter HS 25 is used) + cooling

Alternatively, drying at room temperature can be carried out instead of oven drying. In doing so, we recommend drying overnight.

Note regarding possible DFT:

Per spray pass, a dry film thickness of approx. 25 - 30µm of clearocat can be applied, which will be reduced by sagging (especially when applied as filling coat) and by sanding. Hence, we can not recommend a specific dry film thickness to achieve an optimum clear coating. Instead, it is necessary, depending on the nature of the carbon substrates, to apply a number of clearcoat layers required to achieve the desired clearcoat finish. In order to ensure optimum UV protection, however, the colourless carbon coating must have a total dry film thickness of at least 80 µm.

C. Polishing

Optionally, it is possible to include a final polishing step to achieve the best possible clearcoat finish. In this process, the final clearcoat layer can be polished in the following gradation after the specified drying and (dry or wet) sanding process:

1. pre-sanding: P 800 / P 1000
2. intermediate sanding: P 1500 / P 2000
3. final sanding: P 3000

Recommended gradation of polishing agents:

1. removal of sanding marks: MP Cut White
2. polishing: MP One Blue
3. high gloss polish: MP Finish Black

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Putty + clearcoat:

A. puttying: Mipa P 27 Crystal PE-Transparentspachtel

1. use Mipa P 27 Crystal PE-Transparentspachtel to close pores and to even imperfections on the carbon surface
2. after drying for approx. 2 h at room temperature, dry intermediate sanding with grit P 220 to P 360, final sanding with P 400 to P 600

B. filling cleacoat layer: Mipa 2K-HS-Carbonic-Klarlack

1. apply uniformly and generously 2 - 3 coats
2. 10 - 30 min. flash-off at room temperature
3. 15 min. intermediate drying at 60 °C or 25 min. at 40 °C (when using the hardener Mipa 2K-HS-Härter HS 25) + cooling + dry intermediate sanding with grit P 240 to P 400

Optionally, intermediate sanding can be omitted if the carbon base is very smooth or quality requirements do not require intermediate sanding.

Alternatively, drying at room temperature can be carried out instead of oven drying. In this case, overcoating is possible at the earliest after 1 hour at 20°C. If the first coating/ filling coat has dried for more than 10 - 12 hours, dry intermediate sanding with grit P 240 to P 400 is necessary.

C. clear topcoat: Mipa 2K-HS-Carbonic-Klarlack

1. apply uniformly 2 to 3 flowing coats
2. 10 - 30 min. flash-off at room temperature
3. 15 min. intermediate drying at 60 °C or 25 min. at 40 °C (when using the hardener Mipa 2K-HS-Härter HS 25) + cooling

Alternatively, drying at room temperature can be carried out instead of oven drying. In doing so, we recommend drying overnight.

D. Polishing

Optionally, it is possible to include a final polishing step to achieve the best possible clearcoat finish. In this process, the final clearcoat layer can be polished in the following gradation after the specified drying and (dry or wet) sanding process:

1. pre-sanding: P 800 / P 1000
2. intermediate sanding: P 1500 / P 2000
3. final sanding: P 3000

Recommended gradation of polishing agents:

1. removal of sanding marks: MP Cut White
2. polishing: MP One Blue
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Putty + filler + clearcoat:

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2. after drying for approx. 2 h at room temperature, dry intermediate sanding with grit P 220 to P 360, final sanding with P 400 to P 600

B. filling: Mipa P 67 S PE-Spritzfüller

1. apply uniformly and generously 2 to 3 coats
2. 10 - 15 min. flash-off at room temperature
3. 30 min. intermediate drying at 60 °C + cooling + dry intermediate sanding with grit P 240 to P 400

Alternatively, drying at room temperature for 6 hours can be carried out instead of oven drying.

C. clear topcoat: Mipa 2K-HS-Carbonic-Klarlack

1. apply uniformly 2 to 3 flowing coats
2. 10 - 30 min. flash-off at room temperature
3. 15 min. intermediate drying at 60 °C or 25 min. at 40 °C (when using the hardener Mipa 2K-HS-Härter HS 25) + cooling

Alternatively, drying at room temperature can be carried out instead of oven drying. In doing so, we recommend drying overnight.

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Recommended gradation of polishing agents:

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Filler + clearcoat:

A. filling layer: Mipa P 67 S PE-Spritzfüller

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3. 30 min. intermediate drying at 60 °C + cooling + dry intermediate sanding with grit P 240 to P 400

Alternatively, drying at room temperature for 6 hours can be carried out instead of oven drying.

B. clear topcoat: Mipa 2K-HS-Carbonic-Klarlack

1. apply uniformly 2 to 3 flowing coats
2. 10 - 30 min. flash-off at room temperature
3. 15 min. intermediate drying at 60 °C or 25 min. at 40 °C (when using the hardener Mipa 2K-HS-Härter HS 25) + cooling

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