

Intended use

Mipa 2K-Acrylfiller EL has very good filling properties and is very easy to sand with excellent adhesion on iron, steel, Aluminium and zinc substrates for use in car refinishing. It is also suitable to fill partial areas (Spot repair) without sinkage or visible marks in the outer rim.

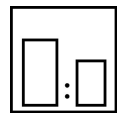
Spreading rate: 325 - 375 sq.ft /gal by 2 mil dry coat thickness

General informations



Colour

grey



Mixing ratio

Hardener

Mipa 2K-Härter H5

Mipa 2K-Härter H 10

by weight (lacquer : hardener)

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by volume (lacquer : hardener)

5 : 1

5 : 1



Hardener

for complete paintwork

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for partial paintwork

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Pot life

1 h with Mipa 2K-Hardener H 5 at 70 °F (20 °C)

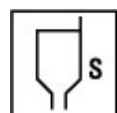
1,5 h with Mipa 2K-Hardener H 10 at 70 °F (20 °C)



Thinner

10 - 15 % Mipa 2K-Thinner fast V 10

10 - 15 % Mipa 2K-Thinner normal V 25



Spray viscosity

gravity spray gun

25 - 35 s 4 mm DIN

Airmix/Airless

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Application mode

Application mode

HVLP (low pressure)

HVLP (low pressure)

Hardener

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pressure (bar)

23 - 29 psi
1,6 - 2 bar

23 - 29 psi
1,6 - 2 bar

nozzle (mm)

1,3 - 2

1,3 - 2

spray passes

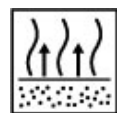
2 - 4

2 - 4

Thinner

10 - 15

10 - 15



Flash-off time

5 - 8 min between the coats

10 - 15 min before oven drying

Dry coat thickness

2 - 6 mil



Drying time	dust dry	set to touch	ready for assembly	sandable	recoatable
object temperature					
70 °F (20 °C)	--	--	--	2,5 h	--
140 °F (60 °C)	--	--	--	30 min.	--
Infrared drying shortwave	--	--	--	8 - 10 min.	--
Infrared drying mediumwave	--	--	--	10 - 15 min.	--

Note

Storage:

In tightly closed original containers at least 3 years shelf life.
Storage temperature range 50 - 86°F (10 - 30 °C)
Protect package from direct sunlight and heat.

VOC Information:

VOC as packaged:
less exempt solvents 428 g/l / 3.6 lb/gal
with exempt solvents 428 g/l / 3.6 lb/gal
VOC as applied:
5:1 with H or MS hardeners + 15 % 2K Thinner < 575 g/l / 4.8 lb/gl

Always check local VOC laws to ensure that the use of Mipa products is compliant in your area.

Processing conditions:

from 50 °F (10 °C) and up to 80 % relative air humidity.
Ensure an adequate supply and exhaust air ventilation.

General informations:

Do not apply on thermoplastic substrates. The substrate must be clean, dry and free from grease. Sand slightly the surface. Remove non adhering old paintworks and primers.

In case of one-layer topcoat use sanding paper P 400 for dry sanding or P 600 for wet sanding. In case of a two-layer topcoat we recommend to use the sanding paper P 500 / 600 for dry sanding and P 800 / 1000 for wet sanding.

Substrate preparation:

All substrates must to be cleaned.

It is recommended to wash zinced substrates with an ammoniac wetting agent.

Pretreatment: Sand aluminium with P 220, steel with P 120.

After sanding clean again thoroughly.

To improve curing and hardness of the filler you can also mix in a mixing ratio of 4:1.

Safety aspect:

For professional use only. Not for sale to or use by the general public. Before opening the packages be sure you understand the warning Messages on the Labels and Safety Data Sheets of all components since the mixture will have the hazards of all of its parts. The manufacturer recommends the use of an air supplied Respirator when exposed to vapors or spray mist.

Medical Response:

Emergency Medical or Spill Control Information 011 49(0)700 24112112 (MIP)
US Emergency Phone Number (for transportation incidents only) 1-800-535-5053
(Infotrac)

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