

### Intended use

Mipa 2K-HS-Filler EF 42 is a high-fill and very easy to sand filler for car refinishing using renewable raw materials. Mipa 2K-HS-Filler EF 42 is suitable for the painting of small areas up to the complete coating, even the filler of partial areas (spot repair) is possible without sagging and edge formation.

The proportion of renewable raw materials in the ready-to-spray mixture is 25 % when used with Mipa 2K-MS-Hardener EMS 25 or Mipa 2K-HS-Hardener EHS 25.

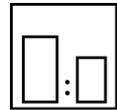
Spreading rate: 8 - 8,5m<sup>2</sup>/Ltr. or 325 - 350sq ft/gal. by 2 mil dry

### General informations



#### Colour

light grey



#### Mixing ratio

##### Hardener

Mipa 2K-MS-Hardener EMS 25

Mipa 2K-HS-Hardener EHS 25

by weight (lacquer : hardener)

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by volume (lacquer : hardener)

4 : 1

6 : 1



#### Hardener

##### for complete paintwork

Mipa 2K-MS-Hardener EMS 25

Mipa 2K-HS-Hardener EHS 25

##### for partial paintwork

Mipa 2K-MS-Hardener EMS 25

Mipa 2K-HS-Hardener EHS 25



#### Pot life

50 - 60 min with Mipa 2K-MS-Hardener EMS 25

50 - 60 min with Mipa 2K-HS-Hardener EHS 25



#### Thinner

0 - 10 % Mipa 2K-Thinner fast V 10

0 - 10 % Mipa 2K-Thinner normal V 25



#### Spray viscosity

##### gravity spray gun

15 - 25 s 4 mm DIN

##### Airmix/Airless

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#### Application mode

##### Application mode

HVLP (low pressure technology)

HVLP (low pressure technology)

HVLP / internal nozzle pressure

##### Hardener

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##### pressure (bar)

1,6 - 2

1,6 - 2

0,7

##### nozzle (mm)

1,4 - 1,8

1,4 - 1,8

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##### spray passes

2 - 3

2 - 3

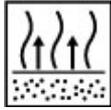
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##### dilution (%)

0 - 10

0 - 10

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### Flash-off time

5 - 8 min between the spray passes

10 - 15 min before oven drying

### Dry coat thickness

2,4 - 7 mil - (60 -175 µm)



### Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
70 °F (20 °C)	--	--	--	3 - 5 h	--
140 °F (60 °C)	--	--	--	20 - 30 min	--
IR-Drying (short wave)	--	--	--	8 min	--
IR-Drying (medium wave)	--	--	--	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 522 g/l / 3.17 lb/gl  
with exempt solvents 376 g/l / 3,17 lb/gl  
VOC as applied 4:1 with Mipa 2K- Hardener EMS 25 522g/l / 4,36 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.  
Acrylic-based products do not cure perfectly at a temperature of below 50 °F

### General informations:

When using on bare metal surfaces, prime beforehand with Mipa adhesion promoters (e.g. Mipa Aktivprimer or Mipa WBS 1K-Grundierfiller).

Smaller steel and iron surfaces up to the size of the palm of your hand can be painted over directly.

Can be sanded with P 400 dry or P 600 wet sandpaper for 1-coat top coats, for 2-coat top coats the use of P 500 / 600 dry or P 800 / 1000 wet sandpaper is recommended.

Do not use on thermoplastic substrates.

The substrate must be clean, dry and free of grease. Sand the surfaces. Remove uncured old paintwork or primers.

#### 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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