

Intended use

Mipa 2K-HS-Filler F 250 LV 2.1 has very good filling properties and is easy to sand. This filler can be used as compact as well as high-build filler. It is also suitable to fill partial areas (Spot repair) without sinkage or visible marks in the outer rim.

Mipa 2K-HS-Filler F 250 LV 2.1 is specially developed according to VOC Regulation VOC < 2.1 lbs/gal (250 g/l).

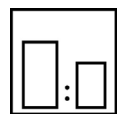
Spreading rate: 315 - 375 sq.ft/gal by 2 mil.

General informations



Colour

light grey



Mixing ratio

Hardener

Mipa Hardener MS 10 LV

Mipa Hardener MS 25 LV

by weight (lacquer : hardener)

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by volume (lacquer : hardener)

4 : 1

4 : 1



Hardener

for complete paintwork

Mipa 2K-MS-Hardener MS 25 LV

for partial paintwork

Mipa 2K-MS-Hardener MS 10 LV



Pot life

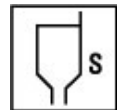
1,5 h with Mipa 2K-Hardener MS 10 LV at 70 °F (20 °C)

2 h with Mipa 2K-Hardener MS 25 LV at 70 °F (20 °C)



Thinner

0 %



Spray viscosity gravity spray gun

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Airmix/Airless

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Application mode

Application mode

HVLP

HVLP

HVLP / internal nozzle
pressure

Hardener

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pressure (bar)

23 - 29 psi

1,6 - 2 bar

0,7 bar

nozzle (mm)

1,3 - 1,8

1,3 - 1,8

1,3 - 1,8

spray passes

2 - 2,5

2 - 2,5

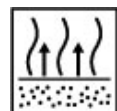
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Thinner

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Flash-off time

5 - 8 min between the coats

10 - 15 min before oven drying

Dry coat thickness

2 - 3 mil (50 - 75 µm) compact filler
up to 8 mil (200 µm) high-build filler



Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
70 °F (20 °C)	10 - 15 min.	30 - 45 min.	–	3 - 5 h	–
140 °F (60 °C)	5 - 10 min.	45 - 60 min.	–	30 - 40 min.	–
Infrared drying shortwave	5 min.	8 - 10 min.	–	8 - 15 min.	–
Infrared drying mediumwave	5 - 8 min.	8 - 12 min.	–	10 - 20 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 280 g/l / 2.3 lb/gal
with exempt solvents 460 g/l / 3.8 lb/gal

VOC Regulation:

RTS Combinations	2K Hardener MS 10 LV	2K Hardener MS 25 LV	
Mixing ratio by volume	4 : 1 by volume	4 : 1 by volume	
Actual VOC (g/L)	533	534	
Regulatory VOC (g/L)	249	249	
Volatiles wt. %	35,8	35,8	
Water wt. %	-	-	
Exempt wt. %	24,2	24,3	
Density (g/L)	1,49	1,49	

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.
2K acrylic refinish product does not cure perfect at a temperature of below 50 °F.

General informations:

Prime beforehand bare metal surfaces with Mipa Aktivprimer or Mipa WBS 1K-Grundierfiller. Small iron and steel surfaces which are not larger than a hand can be directly recoated. In case of one-layer topcoat use sanding paper P 400 for dry sanding or P 600 for wet sanding. In case of a basecoat / clearcoat application we recommend to use the sanding paper P 500/ 600 for dry sanding and P 800/ 1000 for wet sanding. Do not apply on thermoplastic substrates. The substrate must be clean, dry and free from grease. Sand surfaces slightly. Remove not cured old paint work.

For wet-in-wet application without sanding we recommend to use until 20 % ZERO VOC Thinner.

Tools should be cleaned immediately after use.

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)

Exclusive Importer: Fleetwood Products

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