

Intended use

Mipa 2K-HS-Grundfiller F 54 is an extra fast drying and easy sandable 2K primer-surfacer of excellent filling power, anticorrosion protection and good adhesion properties. Developed specially for car refinishing with universal adhesion on bare metal (steel, aluminium and zinc). It is also suitable to fill partial areas (spot repair) without sinkage or visible marks in the outer rim.

Mipa 2K-HS-Grundfiller F 54 white can be tinted in red, blue, green and different grey shades with our Mipa Multi Tint pastes. (see tech sheet Mipa Multi Tint)

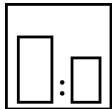
Spreading rate: 325 - 375 sq.ft /gal by 2 mil dry coat thickness

General informations



Colour

grey (ca. RAL 7001)
dark grey (ca. RAL 7011)
black, white



Mixing ratio

Hardener

Mipa 2K-Hardener H 5 / H 10 / MS 10

by weight (lacquer : hardener)

--

by volume (lacquer : hardener)

4 : 1

Mipa 2K Hardener H 25 / MS 25

--

4 : 1



Hardener

for complete paintwork

Mipa 2K-Hardener H 25 / MS25

for partial paintwork

Mipa 2K-Hardener H 5 / H10 / MS 10



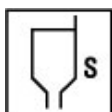
Pot life

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



Thinner

5 - 15 % Mipa 2K-Thinner V 10 / V25 / V40



Spray viscosity

30 - 55 s 4 mm DIN

gravity spray gun

--

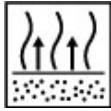
Airmix/Airless

--



Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
HVLP (low pressure)	--	28 - 35 psi	1,3 - 1.8	1 - 3	5 - 15
HVLP (low pressure)	--	2 - 2,5 bar	1,3 - 1.8	1 - 3	5 - 15
HVLP / internal nozzle pressure	--	0,7 bar	--	--	--



Flash-off time

5 - 8 min. between the coats

10 - 15 min. before oven drying

Dry coat thickness

2 - 8 mil 50 - 200 µm



Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
70 °F 20 °C	--	--	--	2 - 5 h	--
140 °F 60 °C	--	--	--	30 - 40 min.	--
Infrared drying shortwave	--	--	--	8 min.	--
Infrared 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 458 g/l / 3.8 lb/gl
with exempt solvents 458 g/l / 3.8 lb/gl
VOC as applied:
4:1 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:

Prime beforehand bare metal surfaces with a Mipa adhesion promoter (e.g. Mipa 1K Fastfiller, 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 single stage 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 400/ 500 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 works and priming coats.

Dry and sanding Information:

Medium coat 2 - 4 mil 1 - 2 h / 70 °F (20 °C), 20 - 30 min. / 140 °F (60 °C)

High build 4 - 8 mil. 2 - 5 h / 70 °F (20 °C), 30 - 40 min. / 140 °F (60 °C)

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

3 American Way, Suite 15, Spotswood, NJ 08884 www.mipa-usa.com
fleetwood@mipa-usa.com. 732-416-9590 Phone, 732-416-9592 Fax.