

### Intended use

This 2K polyurethane wet-in-wet filler can be quickly overcoated and provides universal adhesion: directly applicable on steel, iron, aluminium and galvanized substrates as well as on commonly used plastics in the automotive industry (e.g. PP-EPDM, ABS, PC, ABS-PC, PUR, PVC, GRP). Please observe the detailed pre-treatment instructions for this purpose in the section Processing Instructions / Plastic Substrates on page 3.

Furthermore, it is possible to overcoat intact, sound e-coatings without any pre-sanding. Mipa 2K-HS-WIW-Filler F 37 can be overcoated without intermediate sanding within 5 days.

Mipa 2K-HS-Wet-in-Wet-Filler F 37 can be overcoated after a drying time of only 15 minutes at 70°F (20°C) without loss of gloss and ensures outstanding overspray absorption at the same time. Especially designed for cars refinishing. Suitable also for commercial vehicle and industrial sector for van bodies, platform gates, cabs, machines, and so on.

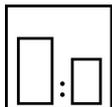
Spreading rate: 655 sq ft/gal. by 1 mil dry coat

### General informations



#### Colour

light grey  
dark grey



#### Mixing ratio

##### Hardener

Mipa 2K-Hardener H 10  
Mipa 2K-MS-Hardener MS 10  
Mipa 2K-MS-Hardener MS 25

##### by weight (lacquer : hardener)

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##### by volume (lacquer : hardener)

5 : 1  
5 : 1  
5 : 1



#### Hardener

##### for complete paintwork

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##### for partial paintwork

Mipa 2K-Hardener H 10, Mipa 2K-MS-Hardener MS 10  
at higher temperatures or larger passenger car surfaces:  
Mipa 2K-MS-Hardener MS 25



#### Pot life

2 h at 70 °F (20 °C)



#### Thinner

25 - 30 % Mipa 2K-Thinner normal V 25



#### Spray viscosity gravity spray gun

16 - 18 s 4 mm DIN

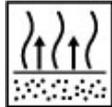
#### Airmix/Airless

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### Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	dilution (%)
gravity spray gun (high pressure)	–	1,6 - 2	1,3 - 1,5	1	25 - 30 %
HVLP (low pressure)	–	1,6 - 2	1,3 - 1,5	1	25 - 30 %
HVLP / internal nozzle pressure	–	0,7	–	–	–



### Flash-off time

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### Dry coat thickness

1 - 1,2 mil (25 - 30 µm)



### Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
70 °F (20 °C)	–	–	–	–	15 - 20 min
–	–	–	–	–	20 - 30 min when using MS 25

### 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 397 g/l / 3.31 lb/gl  
with exempt solvents 397 g/l / 3.31 lb/gl  
VOC as applied:  
5:1 with MS Hardeners LV + ZERO VOC Thinner < 420 g/Ltr. / 3.5 lb/gl,  
5:1 with MS Hardeners LV + 2K Thinner V25 < 566 g/Ltr. / 4.27 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:

In general, apply only 1 uniform, flowing coat in order to ensure the best possible flow. If there are strongly absorbent areas in the surface to be painted (e.g. body filler spots), prime these areas beforehand by applying just a spray coat. After a short flash-off time of approx. 2 - 3 minutes at 70 °F, apply the final coat on the whole surface.

#### Substrate preparation:

The parts have to be free from wax and grease.

Steel substrates: pre-clean with Mipa Silikonentferner, afterwards sand with P 120 and subsequently degrease with Mipa Silikonentferner.

Aluminium substrates: pre-clean with Mipa Silikonentferner, afterwards sand with P 240 and subsequently degrease with Mipa Silikonentferner.

Zinc substrates (batch galvanising/ discontinuous hot-dip galvanizing): clean the surface with the ammonia solution Mipa Zinkreiniger

Zinc substrates (strip galvanising / continuous hot-dip galvanising) and electrogalvanising: pre-clean with Mipa Silikonentferner, afterwards sand with P 240 and subsequently degrease with Mipa Silikonentferner.

#### Plastic substrates:

Degrease the surface thoroughly with Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.

Sand with MP Softpad super fine using Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner. Clean again with Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.

Allow parts to dry completely.

ATTENTION: Releasing agents must be removed completely! After the aforesaid preparation we recommend to do a wetting test with water. If the water rolls off quickly repeat the pre-treatment.

Adheres directly to the following plastics: PP-EPDM, ABS, PC, ABS-PC, PUR, PVC and GRP.

These and other plastics can generally, or in case of doubt, be pre-treated with Mipa 1K-Kunststoffprimer or Mipa 1K-Adhesion Promoter to avoid possible adhesion problems.

Due to very different kinds of plastics and mixtures available on the market, we recommend testing beforehand on the original plastic substrate.

#### 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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This technical data sheet is supplied for informational purposes only! According to our information, all data and recommendations correspond to the state of art and are based on years of experience in manufacturing our products. They do not exempt the user from his obligation to verify professionally, on his own responsibility, the suitability of our products to the intended purpose under prevailing conditions. Safety data sheets and warnings on packaging must be observed. We reserve the right to modify and to complete the information content at any time, without prior notice or obligation to update.

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