

Intended use

Mipa 2K-Multifiller is a fast drying, multi-purpose sanding and wet-on-wet filler in one product.

This product combines the characteristics of sanding filler, wet-on-wet filler and filler for plastics. A lot of different fillers and their additives are replaced by one product and this leads to a simplification of routines in paint shops. Recoatable with Mipa 1K and 2K lacquers.

Universal adhesion: applicable directly on steel, iron, aluminium and zinc substrates as well as on commonly used plastics in the automotive industry (.e.g. PP-EPDM, ABS, PC, ABS-PC, PMMA, PUR, PVC and GRP). Furthermore, it is possible to overcoat intact cathophoretic coatings without any pre-sanding.

Mipa 2K-Multifiller light grey is tintable in red, blue, green and different grey shades with Mipa Multi Tint pastes. (see tech sheet Mipa Multi Tint)

Mipa 2K-Multifiller can be overcoated without intermediate sanding within 5 days.

Spreading rate: 244 - 325 sp.ft/gal by 2 mil.

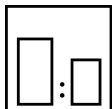
General informations



Colour

light grey (approx. RAL 7047)

dark grey (approx. RAL 7011)



Mixing ratio

Hardener

by weight (lacquer : hardener)

by volume (lacquer : hardener)

Mipa 2K-Härter H 10

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4 : 1

Mipa 2K-HS-Härter HS 10

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6 : 1



Hardener

for complete paintwork

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for partial paintwork

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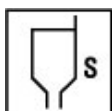
Pot life

1 h with Mipa 2K-Härter H 10 / HS 10 at 70 °F (20 °C)



Thinner

Mipa 2K-Thinner V 25, ZERO VOC Thinner



Spray viscosity

Addition of thinner if used as

sanding filler: 5 - 10 % (Mipa 2K-Härter H 10) 10 - 15 % (Mipa 2K-HS-Härter HS 10)

wet-on-wet filler / plastic filler: 15 - 20 % (Mipa 2K-Härter H 10) 20 - 25 % (Mipa 2K-HS-Härter HS 10)

25 - 35 s 4 mm DIN sanding filler

15 - 18 s 4 mm DIN wet-on-wet and plastic-filler

gravity spray gun

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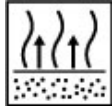
Airmix/Airless

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Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
HVLP (low pressure)	H10	23 - 29 psi 1,6 - 2 bar	1,2 - 1,8	1 - 3	0 - 20
HVLP (low pressure)	HS 10	23 - 29 psi 1,6 - 2 bar	1,2 - 1,8	1 - 3	0 - 25



Flash-off time

5 - 8 min. between the coats
10 - 15 min. before oven drying

Dry coat thickness

1 - 6 mil. (25 - 150 µm)
sanding filler: 2 - 6 mil (50 - 150 µm)
wet-on-wet: 1 - 1,4 mil (25 - 35 µm)
plastic filler: 1 - 1,4 mil (25 - 35 µm)



Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
70 °F (20 °C)	--	--	--	4 - 5 h	15 - 20 min.
140 °F (60 °C)	--	--	--	30 - 40 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 10 + 20 % 2K Thinner V 25 < 575 g/l / 4.8 lb/gl
6:1 with HS 10 + 25 % 2K Thinner V25 < 570 g/l / 4.76 lb/gl
6:1 with HS 10 + 25% ZERO VOC Thinner < 420g/l / 3.5 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:

The substrate must be clean, dry and free from grease.

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 be cleaned. It is recommended to wash zinced substrates with an ammoniac wetting agent. Pre-treatment: Sand aluminium with P 220, steel with P 120. After sanding clean again thoroughly.

In case of coating plastics: Before application, degrease the surface thoroughly with Mipa WBS Cleaner LV. Sand with MP Softpad super fine using Mipa WBS Cleaner LV. Clean again with Mipa WBS Cleaner LV. Allow parts to dry completely.

ATTENTION: Separating substances 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. Observe the technical data sheet L 7 "coating plastics". Due to the most different kinds of plastic and compounds on the market we recommend pre-testing the product on original plastic parts.

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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