

### Intended use

Mipa 4+1 Acrylfiller HS has very good filling properties and is very 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 4+1 Acrylfiller HS white or light grey is tintable in red, green, blue and different grey shades with our Mipa Multi Tint pastes. (see tech sheet Mipa Multi Tint)

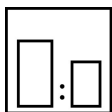
Spreading rate: 325 - 385 sp.ft/gal by 2 mil.

### General informations



#### Colour

white, black  
light grey (7035), dark grey (7011)



#### Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
Mipa 2K-/ H- and MS-Hardeners	--	4 : 1
Mipa 2K-HS Hardeners	--	6 : 1
Mipa 2K-MS-Hardener LV (VOC < 3.5 lb/gl)	--	4 : 1



#### Hardener

##### for complete paintwork

Mipa 2K-MS-Hardener MS 25  
Mipa 2K-HS-Hardener HS 25  
Mipa 2K-MS Hardener MS 25 LV

##### for partial paintwork

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



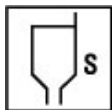
#### Pot life

1 h with Mipa 2K-Hardener H 5 / HS 5 at 70 °F (20 °C)  
1,5 h with Mipa 2K-Hardener H 10 / HS 10 at 70 °F (20 °C)  
2 h with Mipa 2K-Hardener MS 25 / MS 25 LV / HS 25 at 70 °F



#### Thinner

5 - 20 % Mipa 2K-Thinner V 10 fast  
5 - 20 % Mipa 2K-Thinner V 25 normal  
5 - 20 % Mipa 2K-Thinner V 40 slow  
5 - 20% Mipa ZERO VOC Thinner



#### Spray viscosity

add 10 - 20 % of thinner when using it as compact filler. (25 - 30 s /4 mm Din)  
add 5 - 10 % of thinner when using it as high-build filler. (35 - 45 s /4 mm Din)

#### gravity spray gun

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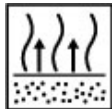
#### Airmix/Airless

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### Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
HVLP	–	23 - 29 psi	1,3 - 2	2 - 3	5 - 20
HVLP	–	1,6 - 2 bar	1,3 - 2	2 - 3	5 - 20
HVLP / internal nozzle pressure	–	0,7 bar	–	–	5 - 20



### 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 12 mil (300 µm) high-build filler



### 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)	–	–	–	30 - 40 min.	–
Infrared drying shortwave	–	–	–	8 - 15 min.	–
Infrared drying mediumwave	–	–	–	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 432 g/l / 3.6 lb/gl  
with exempt solvents 432 g/l / 3.6 lb/gl  
VOC as applied:  
4:1 with H5, H10, H25 + 20% 2K Thinner < 570 g/l / 4.8 lb/gl.  
6:1 with HS 5, HS10, HS 25 + 20% 2K Thinner < 545 g/l / 4.55 lb/gl  
4:1 with MS10 LV, MS25 LV + ZERO VOC Thinner < 410 g/l / 3.4 lb/gl.

#### 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 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 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. 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.

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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