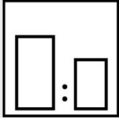








### Intended use

Mipa Multi-Filler HB 2.1 is a fast drying and easy sandable 2K-Epoxi-Filler of excellent filling power, high protection against corrosion and best adhesion on steel, aluminium and galvanized surfaces. To be used for classic cars, cars, busses and trucks. Primer and filler in one product. Tintable with Mipa Multi-Tint (universal pigment pastes) in oxide yellow, red, blue, green and different greys up to dark grey.

### Processing instructions

	<b>Mixing ratio</b>					
	hardener	1 : 1	by volume (lacquer : hardener)			
	<b>Hardener</b>	Mipa EP-Hardener HB 2.1				
	<b>Pot life</b>					
	70° F (20° C)	2 - 3 hours without dilution		1,5 - 2 hours with addition of 3% Mipa EP Acellerator by weight.		
	<b>Thinner</b>	Mipa ZERO VOC Thinners up to maximum 20 %.				
	<b>Spray viscosity</b>					
	4 mm DIN	without dilution	45 - 55 sec.			
		+ 10 % ZERO VOC Thinner	30 - 35 sec.			
		+ 20 % ZERO VOC Thinner	18 - 24 sec.			
	<b>Application method</b>					
	application method	<b>pressure (psi / bar)</b>	<b>nozzle (mm)</b>	<b>spray passes</b>		
	HLVP	28 - 36 psi / 2 - 2,5 bar	1.5 - 1.9	1 - 3		
	<b>Drying time</b>					
	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
	70° F / 20° C	20 min.	2 - 3 hours	6 - 8 hours	8 hours	30 min. - 24 hours

### Note

**Storage:** In tightly closed original containers at least 3 years shelf life.

**Storage temperature:** Storage temperature range: 50 - 86° F (10 - 30° C).

**VOC Regulation:** VOC as packaged:  
less exempt solvents 171 g/l / 1.4 lb/gl  
with exempt solvents 318 g/l / 2.67 lb/

VOC as applied: < 248 g/ Ltr. or 2.08 lbs/gal.

### VOC Regulated areas:

#### VOC Regulation:

RTS Combinations	EP-Hardener HB 2.1	EP-Hardener HB 2.1	EP-Hardener HB 2.1
Mixing ratio by volume	1:1	1:1 + 10 % Zero VOC Thinner	1:1 + 20 % ZERO VOC Thinner
Actual VOC (g/L)	454	529	588
Regulatory VOC (g/L)	212	212	212
Volatiles wt. %	30,6	36,9	42,2
Water wt. %	-	-	-
Exempt wt. %	19,4	26,6	32,8
Density (g/L)	1485	1434	1394

Always check local VOC laws to ensure that the use of Mipa products is compliant in your area.

**Mipa Multi Tint (Universal Tinting Pastes)** to tint Mipa Multi-Filler HB 2.1 in oxide yellow, red, blue, green and different grey shades. (see flyer Mipa EP Multi-Filler HB 2.1).

**Special note:** Tint only the primer. Don't tint the hardener! After tinting of Mipa Multi-Filler HB 2.1 thoroughly agitate the mixture. After tinting the primer, use mixing ratio of 1:1 by volume Mipa Multi-Filler HB 2.1 to Mipa EP-Hardener HB 2.1. Tint the primer with maximum 10% by weight with our Mipa Multi-Tint pastes.

<b>Ratio for different greys:</b>	<b>lightgrey</b>	<b>medium grey</b>	<b>dark grey</b>
Mipa Multi-Tint black in % by weight.	+ 1 %	+ 2,5 %	+ 10 %

**Maximum Ratio for tinting:** Mipa Multi-Tint oxide yellow, red, blue and green use max. 10 % by weight.

**Processing conditions:** From 50° F and up to 80% relative air humidity. Ensure and adequate supply and exhaust air ventilation.

**Substrate preparation:** The substrate must be clean, dry and free from grease.

**Mixing procedures:** Shake the hardener and stir the primer before use. Mix every component thoroughly. Make certain no pigment remains on the bottom of the can. Combine the primer with the hardener and thoroughly agitate the mixture.

**Cleaning of tools:** Tools should be cleaned immediately after use.

**Safety aspects:** 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. This product contains chemicals known to the State of California to cause cancer and birth defects or other reproductive harm.

**Medical Response:** Emergency Medical or Spill Control Information 011 49(0)700 24112112 (MIP)  
US Emergency Telephone 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.