

Intended use

Mipa EP-Primer-Surfacer is a chromate-free wet-in-wet filler based on epoxy resin designed to coat commercial vehicles and to refinish cars. Very good flow, very fast drying and the outstanding overspray absorption ensure fast overcoatability after only 30-45 minutes and optimum gloss retention at the same time. Perfectly suitable as primer for polyester body fillers and polyester spraying filler. Adhesion to steel, aluminium and zinc substrates.

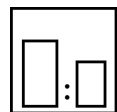
Spreading rate: 646 sq ft/gal. by 1 mil dry coat thickness

General informations



Colour

light grey



Mixing ratio

Hardener

Mipa Hardener E 5

by weight (lacquer : hardener)

–

by volume (lacquer : hardener)

2 : 1



Hardener

for complete paintwork

–

for partial paintwork

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Pot life

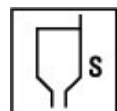
5 h with Mipa Hardener E 5 at 70 °F (20 °C)



Thinner

10 - 25 % Mipa 2K-Thinner

10 - 25 % Mipa ZERO VOC Thinner



Spray viscosity

gravity spray gun

16 - 22 s 4 mm DIN

Airmix/Airless

–



Application mode

Application mode

HVLP (low pressure)

Hardener

–

pressure
(bar)

14 - 28 psi

nozzle (mm)

1,3 - 1,6

spray
passes

1 - 2

Thinner

10 - 25

HVLP (low pressure)

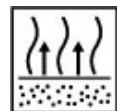
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1,6 - 2 bar

1,3 - 1,6

1 - 2

10 - 25



Flash-off time

5 - 8 min. between coats

10 - 15 min. before oven drying

Dry coat thickness

1 - 2 mil (25 - 50 µm)



Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
70 °F (20 °C)	10 - 15 min.	--	--	--	30 - 45 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 407 g/l / 3.4 lb/gl
with exempt solvents 407 g/l / 3.4 lb/gl

VOC as applied:
with Mipa 2K Thinner max. 581 g/l, or 4.85 lb/gl
with Mipa ZERO VOC Thinner max. 485 g/l, or 4.05 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. Substrate preparation: Zinced substrates must be pre-treated with an ammoniac wetting agent. Pre-treatment: Sand aluminium with P 240, steel with P 120. After sanding clean again thoroughly. It can be coated with body filler or putty after 30 minutes at 140 °F (60 °C) or after 12 hours at room temperature. When coating with body filler or putty or when using Mipa P 60 S PE-Spritzfüller do not exceed the coat thickness of max. 1 mil (25 µm) in one thin layer. If higher coat thicknesses are needed it's possible to apply Mipa EP-Primer-Surfaces also in dry film thickness of up to 120 µm. In this case it's absolutely necessary to observe a drying time of at least 16 hours at room temperature. After a drying time of more than 48 hours it's necessary to sand the priming coat.

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)

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