

### Intended use

Wet-on-wet filler in HS quality. Free from chromate, high stability, optimum flow, excellent finish.

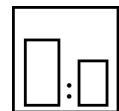
Spreading rate: 12,0 - 15,0 m<sup>2</sup>/l (for 40 - 50 µm DFT)

### Processing instructions



#### Colour

grey



#### Mixing ratio

##### Hardener

Mipa 2K-HS-Härter HS 5 / 10

by weight (lacquer : hardener)

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by volume (lacquer : hardener)

3 : 1



#### Hardener

for complete paintwork

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for partial paintwork

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#### Pot life

2 h with Mipa 2K-HS-Härter HS 5 at 20 °C

3 h with Mipa 2K-HS-Härter HS 10 at 20 °C



#### Thinner

0 - 5 % Mipa 2K-Verdünnung V 25



#### Spray viscosity

gravity spray gun

14 - 16 s 4 mm DIN

Airmix/Airless

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#### Application mode

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



#### Flash-off time

5 - 8 min between the coats

10 - 15 min before oven drying

#### Dry coat thickness

40 - 60 µm



### Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	10 - 20 min	--	--	--	30 min

### Note

- Storage:** at least 3 years in unopened original container
- VOC Regulation :** EU limit value for this product (category B/c): 540 g/l  
This product contains max. 533 g/l of VOC.
- Processing conditions:** From +10 °C and up to 80 % relative air humidity. Ensure an adequate supply and exhaust air ventilation.
- Processing instructions:** Prime beforehand bare metal surfaces with a Mipa adhesion promoter (e.g. Mipa Rapidprimer, Mipa Aktivprimer or Mipa WBS 1K-Grundierfiller). Small iron and steel surfaces which are not larger than a hand can be directly recoated. 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. If necessary, Mipa 2K-HS-Directfiller F 31 can be sanded wet with P 1000 after a drying of approx. 4 hours at room temperature.