

### Intended use

Mipa E 65 S is a two-component spray filler based on epoxy resin to be applied on iron, zinc, aluminium, GRP, wood, plastics and mineral substrates. Mipa E 65 S is seawater proof and adheres also on slightly damp substrates. This product is especially suitable to fill in one operation irregularities, deep sanding marks and rough pre-repair work. Fast drying and very good vertical stability also in case of higher film thicknesses (> 300 µm).

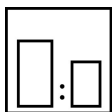
Spreading rate: 6,0 - 6,5 m<sup>2</sup>/l (for 150 µm DFT)

### Processing instructions



#### Colour

grey



#### Mixing ratio

##### Hardener

Mipa E 65 S Component B

by weight (lacquer : hardener)

5 : 1

by volume (lacquer : hardener)

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#### Hardener

for complete paintwork

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for partial paintwork

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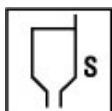
#### Pot life

30 - 40 min with Mipa E 65 S Component B at 20 °C



#### Thinner

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#### Spray viscosity

Ready for spraying after addition of hardener, do not add any further thinner, otherwise it won't cure!

Gravity spray gun

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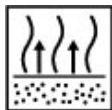
Airmix/Airless

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#### Application method

Application method	Hardener	Pressure (bar)	Nozzle (mm)	spray passes	Thinner
gravity spray gun (high pressure)	—	1,6 - 2	2 - 2,5	2 - 5	—
brush, roller*	—	—	—	—	—



#### Flash-off time

5 - 8 min between coats

10 - 15 min before oven drying

#### Dry coat thickness

150 - 300 µm

max. 1000 µm



**Drying time**

Object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	--	--	--	24 h	24 h
60 °C	--	--	--	1 h	1 h
Infrared drying shortwave	--	--	--	8 min	8 min
Infrared drying mediumwave	--	--	--	10 - 15 min	10 - 15 min

**Note**

**Storage:** at least 3 years in unopened original container

**VOC Regulation :** EU limit value for this product (category B/b): 250 g/l  
This product contains max. 58 g/l of VOC.

**Processing conditions:** From +10 °C and up to 80 % relative air humidity. Ensure an adequate air ventilation.

**Processing instructions:** \*appropriate roller: e. g. mohair, nap, velour, Glattfilt, Rolloplan, not appropriate: foam paint roller.  
The substrate must be clean, dry and free from grease. Sand surface slightly. Remove not fully cured old paintworks and priming coats. Do not apply on thermoplastic or acid products (Reaktionsprimer). Overdosage of hardener may lead to bad curing and sandability. Clean and degrease the whole surface to be painted with Mipa Silikonentferner before every operation. De-rust defective spots to bare metal and dry sand with sanding paper P 80/ 150.