

### 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. The combination with Mipa 2K-Reaktivzusatz VR allows a very quick processing followed by heat-drying or drying at room temperature. This offers saving potentials in terms of spray booth occupancy, stoving times as well as working time. It is also suitable to fill partial areas (Spot repair) without sinkage or visible marks in the outer rim.

Another application option when using Mipa 2K Reaktivzusatz VR is the wet-on-wet application, after which the surface can be overcoated after only a very short intermediate drying of only 10 minutes at room temperature.

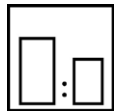
Spreading rate: 5,0 - 6,0 m<sup>2</sup>/l (for 50 - 80 µm DFT)

### Processing instructions



#### Colour

white, oxide yellow, light grey  
(approx. RAL 7035), dark grey  
(approx. RAL 7011), black



#### Mixing ratio

##### Hardener

Mipa 2K and MS-Härter  
Mipa 2K-HS-Härter  
Mipa 2K-Härter H 5 / 10 wet-on-wet

##### by weight (lacquer : hardener)

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##### by volume (lacquer : hardener)

4 : 1  
6 : 1  
3 : 1



#### Hardener

##### for complete paintwork

Mipa 2K-MS-Härter MS 25  
Mipa 2K-HS-Härter HS 25

##### for partial paintwork

Mipa 2K-Härter H 5 / 10  
Mipa 2K-HS-Härter HS 5 / 10



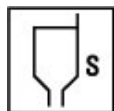
#### Pot life

50 - 60 min with Mipa 2K-Härter H 5 / HS 5 at 20 °C  
1,5 - 2 h with Mipa 2K-Härter H 10 / HS 10 at 20 °C  
2 h with Mipa 2K-Härter MS 25 / HS 25 at 20 °C  
reduced pot life when using 2K-Reaktivzusatz VR



#### Thinner

Mipa 2K-Verdünnung kurz V 10  
Mipa 2K-Verdünnung V 25  
Mipa 2K-Reaktivzusatz VR



#### Spray viscosity

for parameters see information about application

##### gravity spray gun

18 - 22 s 4 mm DIN (sanding filler)  
14 - 16 s 4 mm DIN (wet-on-wet-filler)  
25 - 30 s 4 mm DIN (high-build filler)

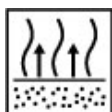
##### Airmix/Airless

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### Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
gravity spray gun (sanding filler)	–	1,6 - 2	1,6 - 1,8	2 - 3	–
HVLP (sanding filler)	–	1,6 - 2 / 0,7 interior pr.	1,3 - 1,4	2 - 3	–
gravity spray gun (wet-on-wet)	–	1,6 - 2	1,6 - 1,8	1 - 1,5	–
HVLP (wet-on-wet)	–	1,6 - 2 / 0,7 interior pr.	1,3 - 1,4	1 - 1,5	–



### Flash-off time

5 - 8 min between coats  
10 - 15 min before oven drying

### Dry coat thickness

50 - 100 µm (compact filler)  
bis 300 µm (high-build filler)  
20 - 40 µm (wet-on-wet)



### Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	–	–	–	3 h	10 min wet-on-wet
60 °C	–	–	–	20 min	–
infrared drying shortwave	–	–	–	8 min	–
infrared drying mediumwave	–	–	–	10 - 15 min	–

### Note

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

**VOC Regulation :** EU limit value for this product (category B/c): 540 g/l  
This product contains max. 500 g/l of VOC.

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

### Processing instructions:

**Note:** The above mentioned drying times refer to the use of hardener Mipa 2K-Härter H 5, HS 5, H 10 and HS 10. When using the hardener Mipa Härter MS 25 and HS 25 or in case of higher dry film thickness (when used as high-build filler), the drying times are extended accordingly. See details below:

#### 1. used as compact filler standard

4+1 Acrylfiller HS	+ hardener Mixing ratio by volume	+ 2K- Verdünnung (thinner)	spraying viscosity 4 mm DIN	spray passes	potlife 20 °C	DFT	sandable after
	H 5 4 : 1	20 %	18 - 22 s	2 - 3	50 - 60 min	50 - 100 µm	3 h / 20 °C 20 min / 60 °C
	H 10 4 : 1				1,5 - 2 h		
	HS 5 6 : 1	25 %			50 - 60 min		
	HS 10 6 : 1				1,5 - 2 h		

#### 2. used as compact filler "Express-Processing"

4+1 Acrylfiller HS	+ hardener Mixing ratio by volume	+ 2K-Reak- tivzusatz VR	spraying viscosity 4 mm DIN	spray passes	potlife 20 °C	DFT	sandable after
	H 5 4 : 1	20 %	18 - 22 s	2 - 3	30 min	50 - 100 µm	90 min / 20 °C 10 min / 60 °C
	H 10 4 : 1				50 min		
	HS 5 6 : 1	20 % additionally + 10 % 2K- Verdünnung			30 min		
	HS 10 6 : 1				50 min		

#### 3. used as wet-on-wet filler "Express-Processing"

4+1 Acrylfiller HS	+ hardener Mixing ratio by volume	+ 2K-Reak- tivzusatz VR	spraying viscosity 4 mm DIN	spray passes	potlife 20 °C	DFT	recoat after
	H 5 / H 10 3 : 1	20 %	14 - 16 s	1 - 1,5	35 - 40 min	20 - 40 µm	10 min / 20 °C

Please consider: Mipa 2K-Reaktivzusatz VR must not be used at temperatures above 25°C because of the short pot life. The added quantity must always be exactly 20% to avoid variations or reactivity. Therefore, when using HS 5 and HS 10, it's necessary to add further 10 % of thinner after having added 20% of Mipa 2K-Reaktivzusatz VR.

#### 4. used as compact filler for complete paintworks

4+1 Acrylfiller HS	+ hardener Mixing ratio by volume	+ 2K- Verdünnung (thinner)	spraying viscosity 4 mm DIN	spray passes	potlife 20 °C	DFT	sandable after
	MS 25 4 : 1	20 %	18 - 22 s	2 - 3	50 - 60 min	50 - 100 µm	5 h / 20 °C 30 - 40 min / 60 °C
HS 25 6 : 1	25 %	1,5 - 2 h					

#### 5. used as high-build filler

4+1 Acrylfiller HS	+ hardener Mixing ratio by volume	+ 2K- Verdünnung (thinner)	spraying viscosity 4 mm DIN	spray passes	potlife 20 °C	DFT	sandable after
	H 5 4 : 1	10 %	25 - 30 s	4 - 5	50 - 60 min	up to 300 µm	5 h / 20 °C 30 - 40 min / 60 °C
	H 10 4 : 1				1,5 - 2 h		
	HS 5 6 : 1	15 %			50 - 60 min		
	HS 10 6 : 1				1,5 - 2 h		

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.

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 paintworks and priming coats.