

Intended use

Mipa 2K-Acryl-Grundierfiller is an easy-to-sand primer with high filling properties and excellent corrosion protection. It can be used as wet-on-wet filler, sanding filler or adhesion promoter with excellent adhesion on iron, steel, aluminium and zinc substrates.

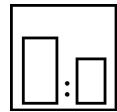
Spreading rate: 6,0 - 8,0 m²/l (for 50 µm DFT)

Processing instructions



Colour

light grey



Mixing ratio

Hardener

Mipa 2K-Härter H 5

by weight (lacquer : hardener)

10 : 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

2 - 3 h at 20 °C



Thinner

15 - 20 % Mipa 2K-Verdünnung V 25



Spray viscosity

gravity spray gun

18 - 22 s 4 mm DIN

Airmix/Airless

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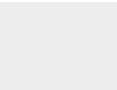
Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
gravity spray gun (high pressure)	--	1,6 - 2	1,3 - 1,5	2 - 3	15 - 20
HVLP (low pressure)	--	1,6 - 2	1,3 - 1,5	2 - 3	15 - 20
HVLP / internal nozzle pressure	--	0,7	--	--	--

Flash-off time

5 - 8 min between the coats

10 - 15 min before oven drying



Dry coat thickness

25 - 80 µm



Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	25 - 30 min	50 - 60 min	–	3 - 4 h	25 min
60 °C	5 - 10 min	30 min	–	30 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 at most 540 g/l of VOC.

Processing conditions: from +10 °C and up to 80 % relative air humidity. Ensure sufficient ventilation.

Processing instructions: The substrate must be clean, dry and free from grease. Substrate preparation: All substrates must be cleaned beforehand with Mipa Silikonentferner. It is recommended to wash zinc-coated substrates with an ammoniac wetting agent. Pre-treatment: Sand aluminium with P 220, steel with P 120. After sanding clean again thoroughly with Mipa Silikonentferner. When applied as adhesion promoter on hard aluminium observe a dry film thickness of 20-25 µm. Do not recoat with solvent-based two-layer basecoats (Mipa BC).