Intended use

Mipa 2K-HS-Express-Filler FX 6 is a high-quality, universally applicable 2K filler for fast and efficient refinishing (express technology) that generally does not require oven drying.

Thanks to its special formulation, Mipa 2K-HS-Express-Filler FX 6 cures very quickly even at room temperature (20 °C) and can be sanded after only approx. 30 - 40 minutes of drying (depending on humidity, thick layers and temperature). This means that significant savings are possible by eliminating heating-related costs. At the same time, very fast cycle times are possible because the painting work does not have to be interrupted by heating intervals.

If necessary, drying in an oven is also possible, in which sandability is achieved after drying for approx. 10 minutes at 60 °C plus a cooling phase.

Very good adhesion on steel, iron, aluminium and galvanised substrates.

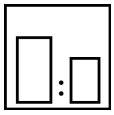
Mipa 2K-HS-Express-Filler FX 6 can also be used as a wet-on-wet filler that is quickly recoatable after only 15 minutes at 20 °C. Mipa 2K-HS-Express-Filler FX 6 can be reworked without intermediate sanding within 24 hours.

Spreading rate: 5,3 - 5,7 m²/l (at 80 µm dry coat thickness)

Processing instructions

Colour

grey



Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
Mipa 2K-Härter H 10	--	4 : 1

Hardener

for complete paintwork	for partial paintwork
--	--

Pot life

60 min at 20 °C

Thinner

Mipa 2K-Verdünnung V 25

Spray viscosity

Sanding filler insert: mixing ratio by volume 4 : 1 + 20 % 2K-Verdünnung V 25

Wet-on-wet insert: mixing ratio by volume 4 : 1 + 40 % 2K-Verdünnung V 25

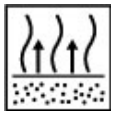
gravity spray gun	Airmix/Airless
Sanding filler insert: 18-23 s 4 mm DIN	--
Wet-on-wet insert: 15-20 s 4 mm DIN	--

This technical data sheet is supplied for informational purposes only! According to our information, all data and recommendations correspond to the state of art and are based on years of experience in manufacturing our products. They do not exempt the user from his obligation to verify professionally, on his own responsibility, the suitability of our products to the intended purpose under prevailing conditions. Safety data sheets and warnings on packaging must be observed. We reserve the right to modify and to complete the information content at any time, without prior notice or obligation to update.

MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49 8703 92 20 · Fax: +49 8703 92 21 00 · mipa@mipa-paints.com · www.mipa-paints.com

Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	dilution (%)
Gravity spray (high pressure technology)	--	1,6 - 2	1,3 - 1,6	2 - 4	--
HVLP (Niederdrucktechnik)	--	1,6 - 2	1,3 - 1,6	2 - 4	--
HVLP (low-pressure technology)	--	0,7	--	--	--
wet-on-wet method	--	2	1,3	1	--



Flash-off time

Allow the first coat to dry matt, then process

without intermediate and final flash-off times

for wet-on-wet process 1 spray coat

Dry coat thickness

80 - 160 µm with sanding filler insert

30 - 40 µm with wet-on-wet insert

Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	5 - 10 min	15 - 20 min	--	30 - 40 min	15 min
60 °C	--	--	--	10 min	--

Note

Storage: At least 3 years in the original sealed container.

VOC Regulation: EU limit for product category B/c 540 g/l.
This product contains max. 540 g/l.

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

This technical data sheet is supplied for informational purposes only! According to our information, all data and recommendations correspond to the state of art and are based on years of experience in manufacturing our products. They do not exempt the user from his obligation to verify professionally, on his own responsibility, the suitability of our products to the intended purpose under prevailing conditions. Safety data sheets and warnings on packaging must be observed. We reserve the right to modify and to complete the information content at any time, without prior notice or obligation to update.

MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49 8703 92 20 · Fax: +49 8703 92 21 00 · mipa@mipa-paints.com · www.mipa-paints.com

Processing instructions:

Substrate preparation:

The substrate must be clean and dry.

Remove oil, grease, rust, mill scale and other substances that could affect the function and coating.

Steel substrates:
1. Pre-clean with Mipa Silikonentferner.
2. Then sand dry with P 120.
3. Then degrease with Mipa Silikonentferner.

Aluminium substrates + galvanised substrates (strip galvanising / continuous hot-dip galvanising) and electrogalvanising:
1. Pre-clean with Mipa Silikonentferner.
2. Then dry sand with P 220.
3. Then degrease with Mipa Silikonentferner.

Galvanised substrates (batch galvanising / discontinuous hot-dip galvanising), ammonia wetting agent wash using Mipa Zinkreiniger:
1. Mix Mipa Zinkreiniger 1:1 with water.
2. Thoroughly sand wet with corundum plastic fleece to a matt finish.
3. Let the metallic grey suspension soak in for about 10 minutes.
4. Sand again.
5. Then thoroughly wash with water and allow the surface to dry.

GRP:
1. Before painting, anneal the parts for 60 minutes at 60 °C.
2. Degrease using Mipa Kunststoffreiniger antistatic or Mipa Silikonentferner.
3. Sand thoroughly with P 240 - P 320.
4. Clean again with Mipa Kunststoffreiniger antistatic or Mipa Silikonentferner.
5. Let the parts dry thoroughly.
6. Recommended to neutralise electrostatic charge: Blowing off the surfaces with MP Ionisierungspistole X-ION, cleans and neutralises in one step, reduces dust inclusions during painting. It also prevents pigment misalignment when overpainting with metallic / effect basecoats.

ATTENTION: Release agents must be completely removed! After completing the above pre-treatment, we recommend a wetting test with water. If the water beads off strongly, repeat the pre-treatment.

Intact, sustainable old coatings, factory coatings:
1. Pre-cleaning with Mipa Silikonentferner.
2. Then sand with P 320.
3. Then degrease with Mipa Silikonentferner.

Cathodic e-coatings / shop primers:
1. Pre-cleaning with Mipa Silikonentferner.
2. Then sand with MP Softpad Superfine or with P 320.
3. Then degrease with Mipa Silikonentferner.

General information:

The substrate must be clean, dry and free of rust and grease. Sand down surfaces.

Remove any old paintwork or primers that are not cured or not sufficiently sound.

Do not use on thermoplastic substrates.

This technical data sheet is supplied for informational purposes only! According to our information, all data and recommendations correspond to the state of art and are based on years of experience in manufacturing our products. They do not exempt the user from his obligation to verify professionally, on his own responsibility, the suitability of our products to the intended purpose under prevailing conditions. Safety data sheets and warnings on packaging must be observed. We reserve the right to modify and to complete the information content at any time, without prior notice or obligation to update.

MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49 8703 92 20 · Fax: +49 8703 92 21 00 · mipa@mipa-paints.com · www.mipa-paints.com

If a grinding filler is used, sand after drying as follows:

1. for single-layer top coats, with P400 dry or P600 wet sandpaper.

2. for two-layer top coats with P 500 / 600 dry or P 800 / 1000 wet sandpaper.

3. thoroughly remove sanding dust using Mipa Silikonentferner, Mipa WBS Reiniger or Mipa WBS Reiniger FINAL. Use clean, lint-free cloths.

It is recommended that the ground surfaces and/or joints, grooves, etc. be thoroughly blown out using oil-free compressed air.

4. Finally, the surfaces to be painted are cleaned with Mipa Silikonentferner, Mipa WBS Reiniger or Mipa WBS Reiniger FINAL using a fresh cloth.

Once the cleaners have dried completely and without streaks, the top coat can be applied.

For wet-on-wet use:

When applied wet-on-wet, only one even, flowing spray coat should be applied to ensure the best possible flow.

If there are any more absorbent areas in the surface to be painted (e.g. putty marks), these can be pre-primed with 1 spray pass and after a short intermediate flash-off time of approx. 2 - 3 min. at 20 °C, the final spray pass can then be applied over the entire surface.

This technical data sheet is supplied for informational purposes only! According to our information, all data and recommendations correspond to the state of art and are based on years of experience in manufacturing our products. They do not exempt the user from his obligation to verify professionally, on his own responsibility, the suitability of our products to the intended purpose under prevailing conditions. Safety data sheets and warnings on packaging must be observed. We reserve the right to modify and to complete the information content at any time, without prior notice or obligation to update.

MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49 8703 92 20 · Fax: +49 8703 92 21 00 · mipa@mipa-paints.com · www.mipa-paints.com