

**Intended use**

2-component polyurethane wet-on-wet filler which can be already recoated after approx. 15 minutes without loss of gloss. Especially designed for car repair. Also suitable for applications on commercial vehicles as well as in the industrial sector for platform gates, driver's cab, machines a. s. o.

Fast re-coatability and excellent gloss retention. After the drying of approx. 15 minutes it's already possible to remove dirt inclusions by sanding. Very good flow and excellent spray mist absorption go hand in hand with very good edge coverage and vertical stability.

This product can be applied directly on steel and iron. Furthermore, it is possible to overcoat intact, sound cataphoretic coatings without any pre-sanding.

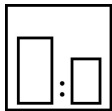
Mipa 2K-HS-Fillprimer can be overcoated within 5 days without intermediate sanding.

Spreading rate: 15,0 - 15,5 m<sup>2</sup>/l (for 20 µm DFT)

**Processing instructions****Colour**

light grey (approx. RAL 7047)

dark grey (approx. RAL 7024)

**Mixing ratio****Hardener****by weight (lacquer : hardener)****by volume (lacquer : hardener)**

Mipa 2K-Härter H 10

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5 : 1

Mipa 2K-MS-Härter MS 10 / 25

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5 : 1

**Hardener****for complete paintwork**

Mipa 2K-MS-Härter MS 25

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**for partial paintwork**

Mipa 2K-Härter H 10

Mipa 2K-MS-Härter MS 10

**Pot life**

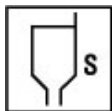
4 h with Mipa 2K-Härter H 10 at 20 °C

4 h with Mipa 2K-MS-Härter MS 10 at 20 °C

5 h with Mipa 2K-MS-Härter MS 25 at 20 °C

**Thinner**

20 - 25 % Mipa 2K-Verdünnung normal V 25

**Spray viscosity****gravity spray gun**

18 - 22 s 4 mm DIN

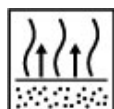
**Airmix/Airless**

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### Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	dilution (%)
gravity spray gun (high pressure)	–	1,6 - 2	1,3 - 1,5	1 - 2	20 - 25
HVLP (low pressure)	–	1,6 - 2	1,3 - 1,5	1 - 2	20 - 25
HVLP / internal nozzle pressure	–	0,7	–	–	–



### Flash-off time

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

### Dry coat thickness

20 - 30 µm



### Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C with H 10 / MS 10	5 - 10 min	2 h	–	–	15 - 20 min
60 °C with H 10 / MS 10	5 min	25 min	–	–	5 - 10 min
20 °C with MS 25	10 - 15 min	2,5 h	–	–	25 - 35 min
60 °C with MS 25	10 min	30 min	–	–	10 - 15 min

### Note

<b>Storage:</b>	at least 3 years in unopened original container
<b>VOC Regulation:</b>	EU limit value for this product (category B/c): 540 g/l This product contains max. 540 g/l of VOC.
<b>Processing conditions:</b>	From +10 °C and up to 80 % relative air humidity. Ensure an adequate supply and exhaust air ventilation
<b>Processing instructions:</b>	The substrate must be clean, dry and free from grease. Use Mipa Aktivprimer as adhesion promoter for aluminium and zinc substrates.