## Mipa 2K-HS-Grundfiller F 54

Technical data sheet



## Intended use

Mipa 2K-HS-Grundfiller F 54 is a fast sandable 2K primer surfacer with high filling power, anticorrosion protection and good adhesion properties. Mipa 2K-HS-Grundierfüller F54 is suitable for painting small areas up to complete painting. In addition, spot repair work / partial varnishing can be carried out reliably and without sagging or the formation of edges.

Spreading rate: 5,0 - 6,0 m²/l

## Processing instructions

	<b>Colour</b> grey (ca. RAL 7001) dark grey (ca. RAL 7022 black, white	2)						
	<b>Mixing ratio</b> Hardener Mipa 2K-Härter H 5 / H Mipa 2K-MS-Härter MS	10 -	by weight (lacquer : hardener)  		<b>by volume (lacquer : hardener)</b> 4 : 1 4 : 1			
Ø	Hardener for complete paintwor Mipa 2K-Härter H 10 Mipa 2K-MS-Härter MS		<b>for partial paintwork</b> Mipa 2K-Härter H 5 –					
	Pot life 1 h with Mipa 2K-Härter H 5 at 20 °C 2 h with Mipa 2K-Härter H 10 at 20 °C 2 h with Mipa 2K-MS-Härter MS 10 at 20 °C							
	<b>Thinner</b> 5 - 10 % Mipa 2K-Verdünnung kurz V 10 5 - 10 % Mipa 2K-Verdünnung normal V 25							
<b>∏</b> s	Spray viscosity gravity spray gun 30 - 55 s 4 mm DIN	gun Airmix/Airless						
	Application mode Application modegravity spray gun (high pressure)HVLP (low pressure)HVLP / internal nozzle pressure	Hardener  	<b>pressure (bar)</b> 1,6 - 2 1,6 - 2 0,7	<b>nozzle (mm)</b> 1,3 - 2 1,3 - 2 –	spray passes 1 - 3 1 - 3 	<b>dilution (%)</b> 5 - 10 5 - 10		
$\frac{1}{1}$	Flash-off time 5 - 8 min between the c	coats						



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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.

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## Dry coat thickness

60 - 180 µm

$\bigcirc$	Drying time object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable			
100000	20 °C			-	3 - 5 h				
	60 °C			_	30 - 40 min				
	Infrared drying shortwave			-	8 min				
	Infrared drying medium wave	-		-	10 - 15 min	_			
Note									
Storage:		at least 3 years in unopened original container							
VOC Regulation:		EU limit value for this product (category B/c): 540 g/l This product contains max. 540 g/l of VOC.							
Processing conditions:		From +10 $^\circ\mathrm{C}$ and up to 80 $\%$ relative air humidity. Ensure an adequate supply and exhaust air ventilation.							
Processing instructions:		Prime beforehand bare metal surfaces with a Mipa adhesion promoter (e.g. Mipa Rapidprimer, Mipa Aktivprimer or Mipa WBS 1K-Grundierfiller). Smaller sanded-through areas or smaller bare steel and iron surfaces the size of the palm of your hand, on the other hand, can be painted over directly using Mipa 2K-HS-Grundierfüller F54 without prior priming. 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 paint works and priming coats.							

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