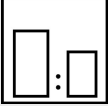








Intended use

The Mipa PL 6 Ziehspachtel is a two-component elastic body filler based on unsaturated polyester resins that offers extended open time and is especially suitable for filling work on commercial vehicles (trucks, rail vehicles, buses). Suitable for steel, zinc substrates, aluminium, GRP and commonly used plastics in vehicle construction. Due to its small grain size, this product can also be applied in very thin layers. The long pot life makes it possible to treat larger areas.

Colour: Beige.

Processing instructions

	Mixing ratio						
	hardener		by weight (lacquer : hardener)	by volume (lacquer : hardener)			
	Härter P		100 : 2 - 3	--			
	Hardener						
	Mipa Härter P						
	Pot life						
	5,5 - 6,5 minutes						
	Thinner						
	--						
	Processing viscosity						
	gravity spray gun			Airmix/Airless			
	--			--			
	Application mode						
	application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution	
	--	--	--	--	--	--	
	Drying time						
	hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
	--	20 °C	--	--	--	20 min.	--
	--	infrared heater	--	--	--	5 - 6 min.	--

Note

Characteristics:

binder base:	unsaturated polyester resin
solids content (% by weight):	100
solids content (% by volume):	--
delivery viscosity DIN 53211 4 mm (in s):	thixotropic
density DIN EN ISO 2811 (kg/l):	~ 1,7
gloss level ISO 2813 at 60° (GU):	matt

Version: en 3/1123

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.

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- Properties:** extended pot life
fast drying
adhesion to steel, zincd substrates, aluminium, GRP and plastics commonly used in vehicle construction
- Theoretical spreading rate :** –
- Storage:** For at least 1 year in the unopened original container. Optimum storage conditions between + 5 °C and + 25 °C, avoid direct sunlight. Other storage conditions may lead to undesirable properties of the material.
- VOC:** < 2 g/l.
- Processing conditions:** From + 10 °C and up to 70 % relative humidity. Ensure adequate air ventilation. Polyester-based putty does not cure anymore at a temperature of below + 10 °C.
- Substrate preparation:** Remove oil, grease, rust, mill scale, rolling skins, as well as other substances impairing the function of the coating!
- Attention: A direct adhesion cannot be taken as granted due to most different kinds of metals, alloys, metallic and conversion coatings and so on. The adhesion must therefore be tested on the original metal substrate.
- steel:
- blast to cleaning degree Sa 2½, remove blast residues and overcoat promptly
- de-rust with hand and power tools to degree of cleanliness St 3
- degrease with Mipa WBS Reiniger or Mipa Silikonentferner
- zincd substrates:
- clean the surface with the ammonia solution Mipa Zinkreiniger
- sweep blast
- aluminium:
- degrease with Mipa 2K-Verdünnung, sand thoroughly with sandpaper P 360/400 and clean subsequently with Mipa Silikonentferner
- GRP and plastics commonly used in vehicle construction:
- clean (remove completely any mould release agents), if necessary, sand slightly and degrease with Mipa Silikonentferner
- old 2K paintworks:
- clean, rough sand and degrease with Mipa Silikonentferner
- Proposed coating structure:** 3-coat system
steel, zincd substrates, aluminium, GRP, plastics commonly used in vehicle construction, old 2K paintworks:
body filler: Ziehpachtel PL 6 with 10 - 300 µm dry film thickness
insulation: *PU 150-30 with 40 - 50 µm dry film thickness
finishing coat: *PU 262-90 with 50 - 60 µm dry film thickness
- 4-coat system
steel, zincd substrates, aluminium, GRP, plastics commonly used in vehicle construction, old 2K paintworks:
priming coat: EP 100-20 with 50 - 70 µm dry film thickness
body filler: Ziehpachtel PL 6 with 10 - 300 µm dry film thickness
insulation: *PU 150-30 with 40 - 50 µm dry film thickness
finishing coat: *PU 262-90 with 50 - 60 µm dry film thickness

Special notes:

*Further Mipa insulation products and topcoats are available. Please contact your technical adviser or our application technicians.

Do not apply on thermoplastic or acid products (wash primer).

Keep out of the reach of children.

Store the container in a well ventilated place.

Keep away from food, drink and animal feeding stuffs.

Do not breathe vapour.

Avoid any contact with eyes.

If accidentally swallowed, seek medical advice and show this container or label.

Overdosage of hardener (more than 3 %) may cause spotting in the paint layer.

Mix well the body filler material with the hardener.

Only dry sand the body filler.

Cleaning of tools:

Clean tools immediately after use with Mipa Universalverdünnung. After curing, it is impossible to dissolve the body filler.