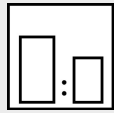


Intended use

This 2K polyurethane wet-in-wet filler can be overcoated already after approx. 15 minutes without loss of gloss. Especially developed for commercial vehicle construction. Can be used on truck box bodies, side panels, tank lorries, and so on.

Processing instructions



Mixing ratio

hardener

PU 912-XX, PU 933-XX, H

by weight (lacquer : hardener)

5 : 1

by volume (lacquer : hardener)

4 : 1



Hardener

Mipa PU 912-10, PU 912-25, PU 912-40, PU 933-05, PU 933-10, H 5



Pot life

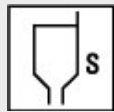
with Härter -10 approx. 2 h at 20 °C

with Härter -40 approx. 8 h at 20 °C



Thinner

Mipa 2K-Verdünnung V 10, V 25, V 40



Processing viscosity

gravity spray gun

18 - 22 s 4 mm DIN

Airmix/Airless

30 - 40 s 4 mm DIN



Application mode

application mode

gravity spray gun/
HVLP

hardener

–

pressure (bar)

2,0 - 2,5

nozzle (mm)

1,2 - 1,5

spray passes

2 - 3

dilution

20 - 25 %

Airmix / Airless
compound pressure

–

1,0 - 2,0
100 - 120

0,23 - 0,28

1

10 - 15 %



Drying time

hardener

H 5

–

-10

–

-25

–

PU 933-05

–

PU 933-10

–

object temperature

20 °C

60 °C

20 °C

60 °C

20 °C

60 °C

20 °C

60 °C

20 °C

60 °C

dust dry

3 - 5 min

–

5 - 10 min

–

10 - 15 min

–

10 - 15 min

5 - 10 min

15 - 20 min

10 - 15 min

set to touch

50 - 60 min

20 min

1,5 - 2 h

25 - 30 min

3 - 4 h

30 min

1 h

20 min

4 - 4,5 h

45 min

ready for assembly

–

–

–

–

–

–

–

–

–

–

sandable

–

–

–

–

–

–

–

–

–

–

recoatable

15 - 20 min

5 min

20 - 30 min

5 - 10 min

30 - 40 min

10 - 15 min

30 - 40 min

10 min

40 - 50 min

15 - 20 min

Note

Characteristics:	binder base: polyurethane acrylic system solids content (% by weight): ~ 77 solids content (% by volume): ~ 60 delivery viscosity DIN 53211 4 mm (in s): thixotropic density DIN EN ISO 2811 (kg/l): ~ 1,6 gloss level ISO 2813 at 60° (GU): 20 - 30 satin matt
Properties:	electrostatic application possible can quickly be overcoated very good flow excellent spray mist absorption very good edge coverage and vertical stability excellent gloss retention heat resistance: - short-term heat exposure: 180°C - permanent heat exposure: 150°C adhesion to steel and GRP
Theoretical spreading rate :	~ 37,4 m ² /kg, 5:1 by weight with PU 912-25, for 10 µm dry film thickness ~ 50,3 m ² /l, , 5:1 by weight with PU 912-25, for 10 µm dry film thickness
Storage:	For at least 3 years 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:	< 350 g/l.*
Processing conditions:	From + 10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.
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: - clean (remove completely any mould release agents), if necessary, sand slightly and degrease with Mipa Silikonentferner

Proposed coating structure: 2-coat system
steel, GRP:
wet-in-wet filler: PU 150-30 with 20 - 30 µm dry film thickness
finishing coat: **OC / PUR HS / PU 260 / PU 262 with 50 - 60 µm dry film thickness

3-coat system
steel, GRP:
wet-in-wet filler: PU 150-30 with 20 - 30 µm dry film thickness
finishing coat: **WBC / BC*** with 15 - 20 µm dry film thickness
clear coat: **2K-HS-Klarlack CC 8 with 50 - 60 µm dry film thickness

zincd substrates, aluminium:
adhesion promoter: Aktivprimer with 10 - 15 µm dry film thickness
wet-in-wet filler: PU 150-30 with 20 - 30 µm dry film thickness
finishing coat: **OC / PUR HS / PU 260 / PU 262 with 50 - 60 µm dry film thickness

4-coat system
zincd substrates, aluminium:
adhesion promoter: Aktivprimer with 10 - 15 µm dry film thickness
wet-in-wet filler: PU 150-30 with 20 - 30 µm dry film thickness
finishing coat: **WBC / BC*** with 15 - 20 µm dry film thickness
clear coat: **2K-HS-Klarlack CC 8 with 50 - 60 µm dry film thickness

Special notes:

*This product has the following maximum VOC-values:
- Applied by spraying with 2K-Härter PU 933-XX / PU 912-XX / H: < 540 g/l of VOC.

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

***When using Mipa BC as topcoat, allow PU 150-30 to dry at least 30 - 45 minutes at 60 - 80 °C. After cooling, it's possible to apply the basecoat.

For professional use only.

The details of the paragraphs - Proposed coating structure, Characteristics, Theoretical spreading rate, VOC - refer to the colour shade RAL 7035. For other colour shades, these may deviate.

If required we also offer hardeners and cleaning agents that are suitable for 2-component mixing and dosing units. Please contact your technical adviser or our application technicians.

Cleaning of tools:

Clean tools immediately after work with Mipa Nitroverdünnung.