

## Intended use

Mipa P 60 S PE-Spritzfiller is a two-component body filler based on polyester resin for steel substrates, GRP, wood or sanded, solid paintwork. This product is especially suitable for the filling of irregularities, deep sanding marks as well as rough pre-repair work in a single filling process.

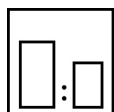
Spreading rate: 4,0 - 6,0 m<sup>2</sup>/l

## Processing instructions



### Colour

grey



### Mixing ratio

#### Hardener

Mipa Härter PS

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#### by weight (lacquer : hardener)

30 : 1

e. g. 300 g : 10 g /

450 g : 15 g / 600 g : 20 g /

750 g : 25 g / 900 g : 30 g

#### by volume (lacquer : hardener)

100 : 5

950 ml P 60 S : 50 ml

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### Hardener

for complete paintwork

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for partial paintwork

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### Pot life

30 min with Mipa Härter PS at 20 °C



### Thinner

0 - 5 % Mipa PE-Verdünnung



### Spray viscosity

ready for use after addition of hardener; thin if necessary

gravity spray gun

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Airmix/Airless

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### Application mode

#### Application mode

gravity spray gun (high pressure)

#### Hardener

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#### pressure (bar)

1,6 - 2

#### nozzle (mm)

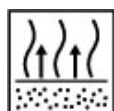
2 - 2,5

#### spray passes

2 - 5

#### dilution (%)

0 - 5



### Flash-off time

5 - 8 min between coats

10 - 15 min before oven drying

### Dry coat thickness

150 - 300 µm

maximum 1000 µm



**Drying time**

**object  
temperature**

**dust dry**

**set to  
touch**

**ready for  
assembly**

**sandable**

**recoat able**

20 °C

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—

—

2 - 3 h

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60 °C

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—

—

30 min

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Infrared drying

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10 - 15 min

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(distance approx.  
80 cm and max. 80  
°C)

**Note**

**Storage:**

At least 1 years in unopened original container.

**VOC Regulation:**

EU limit value for this product (category B/b): 250 g/l.  
This product contains max. 125 g/l of VOC.

**Processing conditions:**

From +10 °C and up to 80 % relative air humidity. Ensure an adequate supply and exhaust air ventilation. Polyester-based body filler does not cure anymore at a temperature of below +10 °C.

**Processing instructions:**

The substrate must be clean, dry and free from grease. Sand the surface slightly. Remove not cured old paint works and priming coats.

The product tends to separate the solvent. This is a characteristic of the system and it is advisable to stir the material well before use.

Do not apply to thermoplastic or acid products (Reaktionsprimer).

Under- or overdosage of hardener may cause spotting in the finishing paint layer.

Clean and degrease the whole surface to be painted with Mipa Silikonentferner before every operation.

De-rust defective spots to bare metal and dry sand with sanding paper P 80 / 150.

Zincd substrates must be insulated with Mipa EP-Grundierfiller or Mipa EP-Primer-Surfacer.

In order to improve the corrosion protection, e. g. when restoring vintage cars, prime with Mipa EP-Primer-Surfacer (see technical data sheet of Mipa EP-Primer-Surfacer).

After drying, use sanding paper P 150 / 240 for dry sanding. Sand the entire surface with dry sand paper P 240 / 360 to a matt finish before applying filler.

Body filler can only be dry sanded.

Do not overcoat without having isolated the surface with Mipa 1K or 2K filler.