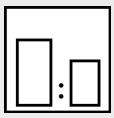
Intended use

This 1K filler with excellent filling properties can be applied to slightly sanded 2K old paintworks, shop primers and directly to steel, zinced substrates, aluminium, MDF (untreated as well as coated with primer or lacquer foil) and to plastics commonly used in automotive industry (test application is required). This product offers enormous time-savings due to fast drying and sandability. Recoatable with water-based or solvent-based Mipa 1K and 2K paints.

Processing instructions



Mixing ratio

hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
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Hardener

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Pot life

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Thinner

Mipa 2K-Verdünnung V 10, V 25, V 40

Mipa UN Verdünnung

Mipa Verdünnung UN 21

Processing viscosity

gravity spray gun	Airmix/Airless
20 - 25 s 4 mm DIN	30 - 40 s 4 mm DIN

Application mode

application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
gravity spray gun/ HVLP	--	2,0 - 2,2	1,3 - 1,8	2 - 3	50 - 70 %
Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,23 - 0,33	1	10 - 20 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	15 - 20 min	45 - 60 min	ca. 1h	wet sanding after approx. 45 min, dry sanding after approx. 1.5 - 2 h	30 min
--	60 °C	--	30 min	30 min	30 min	--

Fully cured after 2 - 3 days (at 20 °C).

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Note

Characteristics:	binder base:	one-component special resins
	solids content (% by weight):	~ 50
	solids content (% by volume):	~ 30
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	~ 1,3
	gloss level ISO 2813 at 60° (GU):	< 20 matt

Properties:

Fast drying, excellent filling properties
Can be filled in spray cans
Electrostatic application possible
Heat resistance:
- Short-term heat exposure: 150 °C
- Permanent heat exposure: 120 °C

Adhesion to steel, zinced substrates, aluminium, plastics and MDF

Theoretical spreading rate:

~ 27,4 m²/kg for 10 µm dry film thickness.
~ 30,8 m²/l for 10 µm dry film thickness.

Storage:

For at least 2 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:

< 610 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 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.

Zinced 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.

Plastics:
- Clean (remove completely any mould release agents), degrease with Mipa Kunststoffreiniger, sand slightly and degrease again with Mipa Kunststoffreiniger.

MDF:
- The substrate must be dry, proper, solid and free from grease, wax and wood dust. Pre-sand with grit P 180 - P 280 and remove dust thoroughly.

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Proposed coating structure:

Steel, zinced substrates, aluminium, plastics:
Priming coat: VB 103-20 with 40 - 50 µm dry film thickness.
Finishing coat: **PU 240-XX with 50 - 60 µm ou AY 210-XX with 30 - 40 µm dry film thickness.

MDF:
Priming coat: VB 103-20 with 40 - 50 µm dry film thickness.
Finishing coat: **PU 230-XX with 50 - 60 µm dry film thickness.

Special notes:

*This product has the following maximum VOC-values:
- Applied by spraying: < 780 g/l of VOC.

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

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.

By applying a layer of at least 50 µm, the primed objects can be stored outside for up 3 months.

Do not apply to thermoplastic substrates.

Do not recoat with products based on polyester.

To ensure a perfect insulation effect and an excellent finish, we recommend applying an insulating primer especially to edges or cut out areas of MDF-boards that have a low density.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.

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