

### Intended use

Mipa 2K-Multifiller is a fast drying, multi-purpose sanding and wet-on-wet filler in one.

Universal adhesion: applicable directly on steel, iron, aluminium and zinc substrates as well as on commonly used plastics in the automotive industry (.e.g. PP-EPDM, ABS, PC, ABS-PC, PMMA, PUR, PVC and GRP). Furthermore, it is possible to overcoat intact, sound cataphoretic coatings without any pre-sanding.

Mipa 2K-Multifiller can be overcoated without intermediate sanding within 5 days.

Universal application: it can be used as sanding filler as well as wet-on-wet filler.

This product combines the characteristics of sanding filler, wet-on-wet filler and filler for plastics. A lot of different fillers and their additives are replaced by one product and this leads to a simplification of routines in paint shops. Recoatable with Mipa 1K and 2K lacquers.

Spreading rate: 5,0 - 7,0 m<sup>2</sup>/l (for 45 µm DFT)

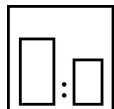
### Processing instructions



#### Colour

light grey (approx. RAL 7047)

dark grey (approx. RAL 7011)



#### Mixing ratio

##### Hardener

##### by weight (lacquer : hardener)

##### by volume (lacquer : hardener)

Mipa 2K-Härter H 10

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4 : 1

Mipa 2K-HS-Härter HS 10

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6 : 1



#### Hardener

##### for complete paintwork

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##### for partial paintwork

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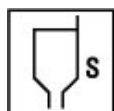
#### Pot life

1 h with Mipa 2K-Härter H 10 / HS 10 at 20 °C



#### Thinner

Mipa 2K-Verdünnung V 25



#### Spray viscosity

Addition of thinner if used as

sanding filler: 0 - 5 % (Mipa 2K-Härter H 10) 5 - 10 % (Mipa 2K-HS-Härter HS 10)

wet-on-wet filler / plastic filler: 10 - 15 % (Mipa 2K-Härter H 10) 25 - 30 % (Mipa 2K-HS-Härter HS 10)

##### gravity spray gun

20 - 30 s 4 mm DIN sanding filler

15 - 20 s 4 mm DIN wet-on-wet filler

15 - 20 s 4 mm DIN plastic filler

##### Airmix/Airless

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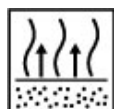
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**Application mode**

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
gravity spray gun (high pressure)	–	1,6 - 2	1,2 - 1,8	1 - 3	0 - 30
HVLP (low pressure)	–	1,6 - 2	1,2 - 1,8	1 - 3	0 - 30
HVLP / internal nozzle pressure	–	0,7	–	–	–



**Flash-off time**

5 - 8 min between the coats  
10 - 15 min before oven drying

**Dry coat thickness**

20 - 180 µm, depending on use:  
sanding filler: 60 - 180 µm  
wet-on-wet filler: 40 - 60 µm  
plastic filler: 20 - 30 µm



**Drying time**

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	–	–	–	4 - 5 h	15 - 20 min
60 °C	–	–	–	30 - 40 min	–

**Note**

- Storage:** at least 3 years in unopened original containers
- VOC Regulation :** EU limit value for this product (category B/c): 540 g/l  
This product contains at most 533 g/l of VOC.
- Processing conditions:** from +10 °C and up to 80 % relative air humidity. Ensure sufficient ventilation.

**Processing instructions:**

The substrate must be clean, dry and free from grease.

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

Substrate preparation: All substrates must be cleaned beforehand with Mipa Silikonentferner. It is recommended to wash zinc substrates with an ammoniac wetting agent. Pre-treatment: Sand aluminium with P 220, steel with P 120. After sanding clean again thoroughly with Mipa Silikonentferner.

In case of coating plastics: Before application, reheat the object to be painted for 60 minutes at 60°C. Degrease the surface thoroughly with Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner. Sand with MP Softpad super fine using Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner. Clean again with Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner. Allow parts to dry completely.

ATTENTION: Separating substances must be removed completely! After the aforesaid preparation we recommend to do a wetting test with water. If the water rolls off quickly repeat the pre-treatment. Due to the most different kinds of plastic and compounds on the market we recommend pre-testing the product on original plastic parts.