

Intended use

Mipa EP-Grundierfiller is a chromate-free 2K primer filler for an economic car and large vehicle coating. The product combines the properties of filler and adhesion primer. The high corrosion protection and the very good adhesion also on non-ferrous metals make this product perfectly suitable for composite substrates. Very good filling capacity and adherence to steel, aluminium, zinc steel and GRP. Shock and scratch-resistant. Mipa EP-Grundierfiller provides high protection against corrosion and resistance to weathering, very good resistance to chemical and mechanical strain. Recoatable with polyester-based body fillers after forced drying (30 minutes/ 60-80°C) for a dry film thickness up to max. 120 µm.

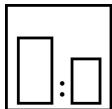
Spreading rate: 5,0 - 6,0 m²/l (for 40 - 50 µm DFT)

Processing instructions



Colour

pebble grey (approx. RAL 7032)



Mixing ratio

Hardener

Mipa Härter E 10 / 25

by weight (lacquer : hardener)

—

by volume (lacquer : hardener)

2 : 1



Hardener

for complete paintwork

Mipa Härter E 25

for partial paintwork

Mipa Härter E 10



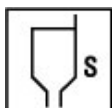
Pot life

10 h at 20 °C



Thinner

0 - 10 % Mipa EP-Verdünnung



Spray viscosity

When using the hardener Härter E 25 use the thinner Mipa EP-Verdünnung; there is no need to add any thinner when using Härter E 10.

Gravity spray gun

18 - 22 s 4 mm DIN

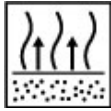
Airmix/Airless

40 - 50 s



Application method

Application method	Hardener	Pressure (bar)	Nozzle (mm)	spray passes	Thinner
gravity spray gun (high pressure)	—	1,6 - 2	1,3 - 1,8	2 - 3	0 - 10
HVLP (low pressure)	—	1,6 - 2	1,3 - 1,8	2 - 3	0 - 10
Airmix / Airless	—	100 - 120	0,23 - 0,33	1 - 2	0 - 5
brushing, rolling*	—	—	—	—	0 - 5



Flash-off time

5 - 8 min between coats

10-15 min. before oven drying

Dry coat thickness

15 - 20 µm (adhesion promoter)

40 - 50 µm (primer filler)

up to 100 µm (sanding filler)



Drying time

Object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C (E 10)	10 min	–	–	12 h	30 min
60 - 80°C (E 10)	–	–	–	30 min	–
20 °C (E 25)	30 min	–	–	12 h	1 h
60 - 80°C (E 25)	–	–	–	60 min	–

Note

Storage: at least 3 years in unopened original container

VOC Regulation : EU limit value for this product (category B/c): 540 g/l
This product contains max. 540 g/l of VOC.

Processing conditions: From +10 °C and up to 80 % relative air humidity. Ensure an adequate supply and exhaust air ventilation.

Processing instructions: *appropriate roller: e. g. mohair, nap, velour, Glattfilt, Rolloplan, not appropriate: foam paint roller.
The substrate must be clean, dry and free from grease. Substrate preparation: All substrates must be cleaned beforehand with Mipa Silikonentferner. Zinced substrates must be pre-treated 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 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. After having mixed the two components wait 15 minutes before applying.