Mipa 4+1 Acrylfiller HS

Technical data sheet

Intended use

Mipa 4+1 Acrylfiller HS has very good filling properties and is very easy to sand. This filler can be used as compact as well as high-build filler. It is also suitable to fill partial areas (Spot repair) without sinkage or visible marks in the outer rim.

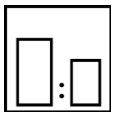
Spreading rate: 5,0 - 6,0 m²/l (for 50 - 80 µm DFT)

Processing instructions



Colour

white, oxide yellow, black, light grey (ca. 7035), dark grey (ca. 7011)



Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
Mipa 2K-/ und MS-Härter	--	4 : 1
Mipa 2K-HS-Härter	--	6 : 1



Hardener

for complete paintwork	for partial paintwork
Mipa 2K-MS-Härter MS 25	Mipa 2K-Härter H 5 / 10
Mipa 2K-HS-Härter HS 25	Mipa 2K-HS-Härter HS 5 / 10



Pot life

1 h with Mipa 2K-Härter H 5 / HS 5 at 20 °C

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

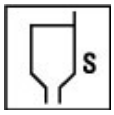
2 h with Mipa 2K-Härter MS 25 / HS 25 at 20 °C



Thinner

0 - 10 % Mipa 2K-Verdünnung kurz V 10

0 - 10 % Mipa 2K-Verdünnung V 25



Spray viscosity

add 5 - 10 % of thinner when using it as compact filler
do not dilute when using it as high-build filler

Gravity spray gun	Airmix/Airless
25 - 30 s 4 mm DIN (compact filler)	--

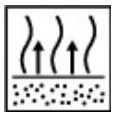


Application method

Application method	Hardener	Pressure (bar)	Nozzle (mm)	spray passes	Thinner
gravity spray gun (high pressure)	--	1,6 - 2	1,3 - 2	2 - 3	0 - 10
HVLP (low pressure)	--	1,6 - 2	1,3 - 2	2 - 3	0 - 10
HVLP / internal nozzle pressure	--	0,7	--	--	--
Airmix / Airless	--	100 - 120	0,23 - 0,33	1 - 2	0 - 5

This technical data sheet is supplied for informational purposes only! According to our information, all data and recommendations correspond to the state of art and are based on years of experience in manufacturing our products. They do not exempt the user from his obligation to verify professionally, on his own responsibility, the suitability of our products to the intended purpose under prevailing conditions. Safety data sheets and warnings on packaging must be observed. We reserve the right to modify and to complete the information content at any time, without prior notice or obligation to update.

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Flash-off time

5 - 8 min between the coats

10 - 15 min before oven drying

Dry coat thickness

50 - 80 µm (compact filler)

up to 300 µm (high-build filler)



Drying time

Object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	--	--	--	3 - 5 h	--
60 °C	--	--	--	30 - 40 min	--
Infrared drying shortwave	--	--	--	8 min	--
Infrared drying mediumwave	--	--	--	10 - 15 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. 500 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: Prime beforehand bare metal surfaces with a Mipa adhesion promoter (e.g. Mipa Rapidprimer, Mipa Aktivprimer or Mipa WBS 1K-Grundierfiller). Small iron and steel surfaces which are not larger than a hand can be directly recoated. 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. Do not apply on thermoplastic substrates. The substrate must be clean, dry and free from grease. Sand surfaces slightly. Remove not cured old paint works and priming coats.

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