

Intended use

Mipa 2K-HS-Grundfiller F 54 is a fast sandable 2K primer surfacer with high filling power, anticorrosion protection and good adhesion properties. Mipa 2K-HS-Grundierfüller F54 is suitable for painting small areas up to complete painting. In addition, spot repair work / partial varnishing can be carried out reliably and without sagging or the formation of edges.

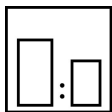
Spreading rate: 5,0 - 6,0 m²/l

Processing instructions



Colour

grey (ca. RAL 7001)
dark grey (ca. RAL 7022)
black, white



Mixing ratio

Hardener

Mipa 2K-Härter H 5 / H 10
Mipa 2K-MS-Härter MS 10

by weight (lacquer : hardener)

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by volume (lacquer : hardener)

4 : 1
4 : 1



Hardener

for complete paintwork

Mipa 2K-Härter H 10
Mipa 2K-MS-Härter MS 10

for partial paintwork

Mipa 2K-Härter H 5
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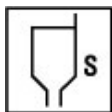
Pot life

1 h with Mipa 2K-Härter H 5 at 20 °C
2 h with Mipa 2K-Härter H 10 at 20 °C
2 h with Mipa 2K-MS-Härter MS 10 at 20 °C



Thinner

5 - 10 % Mipa 2K-Verdünnung kurz V 10
5 - 10 % Mipa 2K-Verdünnung normal V 25



Spray viscosity

gravity spray gun

30 - 55 s 4 mm DIN

Airmix/Airless

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Application mode

Application mode

gravity spray gun (high pressure)
HVLP (low pressure)
HVLP / internal nozzle pressure

Hardener

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pressure (bar)

1,6 - 2
1,6 - 2
0,7

nozzle (mm)

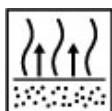
1,3 - 2
1,3 - 2
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spray passes

1 - 3
1 - 3
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dilution (%)

5 - 10
5 - 10
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Flash-off time

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

Dry coat thickness

60 - 180 µm



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 medium wave	--	--	--	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. 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: Prime beforehand bare metal surfaces with a Mipa adhesion promoter (e.g. Mipa Rapidprimer, Mipa Aktivprimer or Mipa WBS 1K-Grundierfüller). Smaller sanded-through areas or smaller bare steel and iron surfaces the size of the palm of your hand, on the other hand, can be painted over directly using Mipa 2K-HS-Grundierfüller F54 without prior priming. 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.