Mipa EP-Grundierfiller

Technical data sheet

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 promoter. 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, zinced 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.

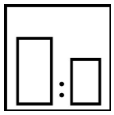
Spreading rate: 5,0 - 6,0 m²/l (for 40 - 50 µm DFT)

Processing instructions



Colour

pebble grey (approx. RAL 7032)



Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
Mipa EP-Härter E 10 kurz / 25 normal	--	2 : 1



Hardener

for complete paintwork	for partial paintwork
Mipa EP-Härter E 25 normal	Mipa EP-Härter E 10 kurz



Pot life

10 h at 20 °C



Thinner

0 - 10 % Mipa EP-Verdünnung



Spray viscosity

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

gravity spray gun	Airmix/Airless
18 - 22 s 4 mm DIN	40 - 50 s

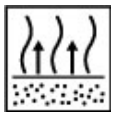


Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	dilution (%)
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

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.

MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49 8703 92 20 · Fax: +49 8703 92 21 00 · mipa@mipa-paints.com · www.mipa-paints.com



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.

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