Mipa EP-Primer-Surfacer

Technical data sheet

Intended use

Mipa EP-Primer-Surfacer is a chromate-free wet-in-wet filler based on epoxy resin designed to coat commercial vehicles and to refinish cars. Very good flow, very fast drying and the outstanding overspray absorption ensure fast overcoatability after only 30-45 minutes and optimum gloss retention at the same time. Perfectly suitable as primer for polyester body fillers and polyester spraying filler. Adhesion to steel, aluminium and zinced substrates.

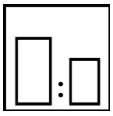
Spreading rate: 9,0 - 10,0 m²/l (for 35 µm DFT)

Processing instructions



Colour

light grey



Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
Mipa Härter E 5	--	2 : 1



Hardener

for complete paintwork	for partial paintwork
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Pot life

5 h with Mipa Härter E 5 at 20 °C



Thinner

10 - 25 % Mipa 2K-Verdünnung



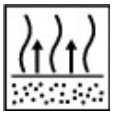
Spray viscosity

Gravity spray gun	Airmix/Airless
16 - 22 s 4 mm DIN	--



Application method

Application method	Hardener	Pressure (bar)	Nozzle (mm)	spray passes	Thinner
gravity spray gun (high pressure)	--	1,6 - 2	1,3 - 1,6	1 - 2	10 - 25
HVLP (low pressure)	--	1,6 - 2	1,3 - 1,6	1 - 2	10 - 25
HVLP / internal nozzle pressure	--	0,7	--	--	--



Flash-off time

5 - 8 min between coats

10 - 15 min before oven drying

Dry coat thickness

25 - 50 µm

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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Drying time

Object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	10 - 15 min	--	--	--	30 - 45 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: 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. It can be coated with body filler or putty after 30 minutes at 60 °C or after 12 hours at room temperature. When coating with body filler or putty or when using Mipa P 60 S PE-Spritzfüller do not exceed the coat thickness of max. 25 µm (one thin layer). If higher coat thicknesses are needed it's possible to apply Mipa EP-Primer-Surfaces also in dry film thickness of up to 120 µm. In this case it's absolutely necessary to observe a drying time of at least 16 hours at room temperature. After a drying time of more than 48 hours it's necessary to sand the priming coat.

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