Intended use

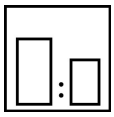
Mipa 2K-HS-Express-Filler FX 4 is a high-quality two-component filler for fast and economic car refinishing (express technology) that generally doesn't require oven drying. Mipa 2K-HS-Express-Filler FX 4 cures fast already at room temperature (20°C) and can be sanded after a drying of only 35 minutes (depending on coat thickness and temperature). It is therefore possible to save significantly heating-related costs. In the same time, cycle times are reduced since the painting process is not interrupted by heating intervals. If required, oven drying is also possible. Hereby full sandability is obtained after a drying of approx. 10 minutes at 60° C or 20 minutes at 40°C plus cooling time. Mipa 2K-HS-Express-Filler FX 4 is perfectly suitable for partial car coatings and spot repairs. After pre-treatment with Mipa Vorreiniger Express, this filler provides very good adhesion on steel, iron, aluminium and galvanized substrates.

Spreading rate: 3,8 - 4,2 m²/l (for 80 µm DFT)

Processing instructions

Colour

grey



Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
Mipa 2K-Härter H 5	--	4 : 1

Hardener

for complete paintwork	for partial paintwork
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Pot life

approx. 20 - 30 min at 20 °C

Thinner

15 % Mipa 2K-Verdünnung V 25

Spray viscosity

gravity spray gun	Airmix/Airless
15 - 20 s 4 mm DIN	--

Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
gravity spray gun (high pressure)	--	1,6 - 2	1,3 - 1,6	2 - 4	15
HVLP (low pressure)	--	1,6 - 2	1,3 - 1,6	2 - 4	15
HVLP / internal nozzle pressure	--	0,7	--	--	15

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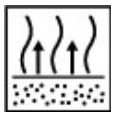

Flash-off time

allow first coat to dry to a matt finish, the subsequent coats don't require intermediate or final flash-off

Dry coat thickness

80 - 150 µm

Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	approx. 5 min	approx. 10 min	--	approx. 35 min	--
40 °C	--	--	--	20 min	--
60 °C	--	--	--	10 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 air ventilation.

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Processing instructions:

Infrared drying:

Infrared drying shortwave: approx. 5 min
Infrared drying mediumwave: approx. 10 min

Do not apply on thermoplastic substrates.

Substrate preparation:

The substrate must be clean, dry and free from grease. Sand slightly the surface. Remove non adhering old paintworks and primers.

When recoating bare metal surfaces, it's necessary to pre-treat them as follows:

Pre-treatment: Sand aluminium and galvanised substrates with P 220, steel with P 120. After sanding clean with Mipa Silikonentferner.

Then apply evenly Mipa Vorreiniger „Express" by means of MP Pre-Clean Reinigungstuch WBS in a criss-cross fashion on the bare metal and assure that the surface stays moistened for at least 1 minute to create an optimal conversion layer.

After a flash-off time of approx. 2 - 3 minutes (metal surface must have dried) recoat with Mipa 2K-HS-Express-Filler FX 4. The recoating must be done within 15 minutes.

Please consider that only one type of metal per cloth is treated. Rags that have started to dry or have dried completely must not be reused. If moist clothes are kept in a resealable box consider the following notes:

After removing a cloth, the container must be sealed again hermetically.
Already used rags are to be used up within a day and must not be returned to the original container. To prevent dehydration, these wipes can be stored separately in a plastic container or plastic bag.

If there is too much cleaning agent liquid on the bottom of the container, place the container horizontally and ensure by rolling that the cloths are soaked.

The non-use of Mipa Vorreiniger „Express" is analytically detectable.

Information about sanding of the filler:

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.

If you sand immediately after the minimum drying time, we recommend using flexible sanding discs or MP Interface Pad.

After a through drying of 1 hour at room temperature (20°C) also standard sanding discs can be used.
This additional drying time applies for all kinds of drying (drying at room temperature or in oven).

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