

### 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. Developed for car refinishing, it is also suitable to fill partial areas (Spot repair) without sinkage or visible marks in the outer rim.

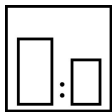
Spreading rate: 5,0 - 6,0 m<sup>2</sup>/l

### Processing instructions



#### Colour

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



#### Mixing ratio

##### Hardener

Mipa 2K-Härter H 5 / H 10

by weight (lacquer : hardener)

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by volume (lacquer : hardener)

4 : 1



#### Hardener

for complete paintwork

Mipa 2K-Härter H 10

for partial paintwork

Mipa 2K-Härter H 5



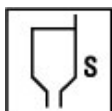
#### Pot life

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



#### Thinner

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



#### Spray viscosity

Gravity spray gun

30 - 55 s 4 mm DIN

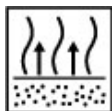
Airmix/Airless

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#### Application method

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



#### 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-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.