

# MIPA 4 + 1 ACRYLFILLER HS- TECHNICAL DATA SHEET

## DESCRIPTION

Mipa 4 + 1 Acrylfiller HS is a two component high solid filler which can be used as high build primer surfacer or compact filler.

## PHYSICAL DATA

### VOC'S:

as packaged white	417.1 grms/ltr	3.48 lbs/gal
as packaged grey	430.7 grms/ltr	3.59 lbs/gal
as packaged black	442.6 grms/ltr	3.69 lbs/gal

ready to spray - 4:1:0%	477 grms/ltr	3.98 lbs/gal
ready ro spray - 4:1:10%	504 grms/ltr	4.29 lbs/gal

Coverage: 5-6 m<sup>2</sup>/ltr

### Recommended Dry Film Thickness:

as compact filler 50-80 microns in 2/3 coats  
as primer filler (thick coat) 300 microns

Solid content by weight - 74.9 % as packaged white  
Solid content by weight - 74.1% as packaged grey  
Solid content by weight- 70.4% as packaged black  
Pot life: 3 hours

## SUBSTRATES

Cured paint substrates after thorough cleaning and sanding, polyester putties after complete drying and sanding, washprimers, epoxy primers

## MIXING

Ratios: 4:1 by volume



	<u>4+1</u>	<u>Hardener</u>	<u>Thinner</u>
as compact filler	4	1	10%
as primer filler	4	1	0%

Hardeners: Mipa 2K-Harter H5, H10

Thinners: Mipa 2K-Verdunnung slow, normal, fast

Spraying Viscosity at 20<sup>0</sup>C/68<sup>0</sup>F :



Compact filler	25-30 s 4 mm DIN
Primer filler	no thinner

## APPLICATION

Apply 2-3 coats

Flash off time between coats 15 minutes depending on climatic/envirmental conditions.



Gun set up:		<u>Nozzle</u>	<u>Pressure</u>
gravity HVLP		1.5-1.7mm	2.5-3 bar

## DRYING

	<u>20<sup>0</sup>C/68<sup>0</sup>F</u>	<u>60<sup>0</sup>C/140<sup>0</sup>F</u>
compact filler	3-5 hours	30-40 min
primer filler	3-5 hours	30-40 min

 wet flat with P600-800  
dry flat with P320 after force drying

## IMPORTANT INFORMATION

Working conditions from 10<sup>0</sup>C/50<sup>0</sup>F and up to 75% humidity. Products should be adapted to suit local conditions and environment beyond our control. Please refer to relevant Material Safety Data Sheets.

## SAFETY REMARKS

The products described herein are produced and sold exclusively for professional use and consumption, and only with proper and safe equipment. Please refer to relevant Material Safety Data Sheets.

All products should be disposed of in relation to the regulations of the environmental health authorities.

This data sheet is for information purpose only. To our knowledge the data provided complies with the latest standard and is based on years of experience in the manufacture of our products. However the data is not binding and without warranty.

