

### Intended use

Mipa 1K-Fast-Filler is an acidic 1-component repair filler with excellent filling power for the automotive industry. It can be applied on sanded old 2K-paintworks, shop primers and directly on steel, aluminium and zinc substrates. This product offers time savings thanks to fast drying and sandability. Free from chromate and lead. Quick and easy to sand. Do not apply on old thermoplastic coatings.

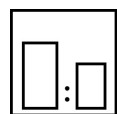
Spreading rate: 5,0 - 7,0 m<sup>2</sup>/l

### Processing instructions



#### Colour

grey



#### Mixing ratio

##### Hardener

by weight (lacquer : hardener)    by volume (lacquer : hardener)

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#### Hardener

for complete paintwork

for partial paintwork

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#### Pot life

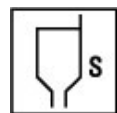
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#### Thinner

50 - 70 % Mipa 2K-Verdünnung V 25

50 - 70 % Mipa Verdünnung UN / UN 21



#### Spray viscosity

Gravity spray gun

Airmix/Airless

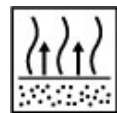
18 - 22 s 4 mm DIN

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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 - 1,8	2 - 3	50 - 70
HVLP (low pressure)	--	1,6 - 2	1,3 - 1,8	2 - 3	50 - 70
HVLP / internal nozzle pressure	--	0,7	--	--	--



#### Flash-off time

5 - 8 min between the coats

10 - 15 min prior to oven drying

#### Dry coat thickness

40 - 50 µm



**Drying time**

Object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	15 min	--	--	wet sanding (P 600 - P 800): 45 min	--
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**Note**

- Storage:** at least 3 years in unopened original container
- VOC Regulation :** EU limit value for this product (category B/c): 780 g/l  
 This product contains max. 780 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. Do not apply on thermoplastic substrates. Remove non-cured old paintworks and priming coats. Do not apply polyester-based materials. Sand surfaces slightly. Galvanized substrates must be pre-treated with an ammoniac wetting agent (Mipa Zinkreiniger).