

Intended use

Sanding filler in HS quality with especially high solid content which allows the user to apply high-build coats without any risk of sinkage. Free from chromate, high vertical stability, high filling power and easy to sand. The smooth, satin gloss surface of Mipa 2K-HS-Filler F41 guarantees an excellent flow of the subsequent coatings which results in a perfect finish.

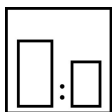
Spreading rate: 8,0 - 10,0 m²/l (for 60 - 80 µm DFT)

Processing instructions



Colour

light grey (ca. RAL 7035)



Mixing ratio

Hardener

Mipa 2K-HS-Härter

by weight (lacquer : hardener)

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by volume (lacquer : hardener)

4 : 1



Hardener

for complete paintwork

Mipa 2K-HS-Härter HS 10

for partial paintwork

Mipa 2K-HS-Härter HS 5



Pot life

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

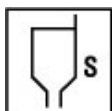
2 h with Mipa 2K-HS-Härter HS 10 at 20 °C



Thinner

0 - 5 % Mipa 2K-Verdünnung kurz V 10

0 - 5 % Mipa 2K-Verdünnung V 25



Spray viscosity

Gravity spray gun

16 - 18 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)

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1,6 - 2

1,3 - 2

2 - 4

0 - 5

HVLP (low pressure)

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1,6 - 2

1,3 - 2

2 - 4

0 - 5

HVLP / internal nozzle pressure

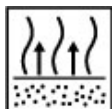
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0,7

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Flash-off time

5 - 8 min between the coats

10 - 15 min before oven drying

Dry coat thickness

60 - 250 µm

**Drying time****Object
temperature****dust dry****set to
touch****ready for
assembly****sandable****recoatable**

20 °C

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4 - 6 h

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60 °C

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30 - 40 min

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Infrared drying
shortwave

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8 min

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Infrared drying
mediumwave

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10 - 15 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): 540 g/l
This product contains max. 397 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.