

### 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. Mipa 2K-HS-Grundierfüller F54 is suitable for painting small areas up to complete painting. In addition, spot repair work / partial varnishing can be carried out reliably and without sagging or the formation of edges.

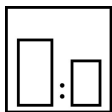
Spreading rate: 5,0 - 6,0 m<sup>2</sup>/l

### Processing instructions



#### Colour

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



#### Mixing ratio

##### Hardener

##### by weight (lacquer : hardener)

##### by volume (lacquer : hardener)

Mipa 2K-Härter H 5 / H 10

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4 : 1

Mipa 2K-MS-Härter MS 10

–

4 : 1



#### Hardener

##### for complete paintwork

Mipa 2K-Härter H 10  
Mipa 2K-MS-Härter MS 10

##### for partial paintwork

Mipa 2K-Härter H 5  
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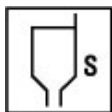
#### Pot life

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

##### Application mode

##### Hardener

##### pressure (bar)

##### nozzle (mm)

##### spray passes

##### Thinner

gravity spray gun (high pressure)

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1,6 - 2

1,3 - 2

1 - 3

5 - 10

HVLP (low pressure)

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1,6 - 2

1,3 - 2

1 - 3

5 - 10

HVLP / internal nozzle pressure

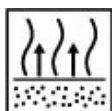
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0,7

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#### Flash-off time

5 - 8 min between the coats  
10 - 15 min before oven drying

**Dry coat thickness**

60 - 180 µm

**Drying time**

<b>object temperature</b>	<b>dust dry</b>	<b>set to touch</b>	<b>ready for assembly</b>	<b>sandable</b>	<b>recoatable</b>
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-Grundierfüller). Smaller sanded-through areas or smaller bare steel and iron surfaces the size of the palm of your hand, on the other hand, can be painted over directly using Mipa 2K-HS-Grundierfüller F54 without prior priming. 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.