

### Intended use

Mipa P 60 S PE-Spritzfiller styrolreduziert is a two-component body filler based on polyester resin and with a low styrene content for steel substrates, GRP, wood or sanded, solid paintwork. This product is especially suitable for filling irregularities, deep sanding traces as well as rough pre-repair work in a single filling process. The proportion of styrene of Mipa P 60 styrolreduziert is less than 10 %.

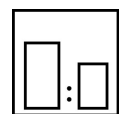
Spreading rate: 4,0 - 6,0 m<sup>2</sup>/l

### Processing instructions



#### Colour

grey



#### Mixing ratio

##### Hardener

Mipa Härter PS

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

30 : 1

z. B. 300 g : 10 g /

450 g : 15 g / 600 g : 20 g /

750 g : 25 g / 900 g : 30 g

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

100 : 5

950 ml P 60 S : 50 ml

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#### Hardener

for complete paintwork

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for partial paintwork

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#### Pot life

30 - 35 min with Mipa Härter PS at 20 °C



#### Thinner

0 - 5 % Mipa PE-Verdünnung



#### Spray viscosity

ready for use after addition of hardener; thin if necessary

gravity spray gun

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Airmix/Airless

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#### Application mode

##### Application mode

gravity spray gun (high pressure)

##### Hardener

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##### pressure (bar)

1,6 - 2

##### nozzle (mm)

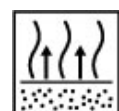
2 - 2,5

##### spray passes

2 - 5

##### dilution (%)

0 - 5



#### Flash-off time

5 - 8 min between coats

10 - 15 min before oven drying

**Dry coat thickness**

150 - 300 µm  
maximum 1000 µm



**Drying time**

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	--	--	--	3 - 4 h	--
60 °C	--	--	--	30 min	--
Infrared drying (distance approx. 80 cm and max. 80 °C)	--	--	--	10 - 15 min	--

**Note**

- Storage:** At least 1 years in unopened original container.
- VOC Regulation:** EU limit value for this product (category B/b): 250 g/l.  
This product contains max. 250 g/l of VOC.
- Processing conditions:** From +10 °C and up to 80 % relative air humidity. Ensure an adequate supply and exhaust air ventilation. Polyester-based body filler does not cure anymore at a temperature of below +10 °C.
- Processing instructions:** The substrate must be clean, dry and free from grease. Sand the surface slightly. Remove not cured old paint works and priming coats.
- The product tends to separate the solvent. This is a characteristic of the system and it is advisable to stir the material well before use.
- Do not apply to thermoplastic or acid products (Reaktionsprimer).
- Under- or overdosage of hardener may cause spotting in the finishing paint layer.
- Clean and degrease the whole surface to be painted with Mipa Silikonentferner before every operation.
- De-rust defective spots to bare metal and dry sand with sanding paper P 80 / 150.
- Zincd substrates must be insulated with Mipa EP-Grundierfiller or Mipa EP-Primer-Surfacer.
- In order to improve the corrosion protection, e. g. when restoring vintage cars, prime with Mipa EP-Primer-Surfacer (see technical data sheet of Mipa EP-Primer-Surfacer).
- After drying, use sanding paper P 150 / 240 for dry sanding. Sand the entire surface with dry sand paper P 240 / 360 to a matt finish before applying filler.
- Body filler can only be dry sanded.
- Do not overcoat without having isolated the surface with Mipa 1K or 2K filler.