
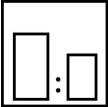







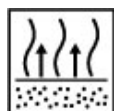
### Intended use

Mipa 2K-HS-Express-Filler FX 3 is a high-quality two-component filler for fast and economic car refinishing (express technology). Due to its special formulation Mipa 2K-HS-Express-Filler FX 3 cures very quickly already at room temperature (20° C) and can be sanded after only approx. 60 minutes of drying (depending on air humidity, layer thickness and temperature). Thus, large savings are possible by eliminating heating-related costs. At the same time, cycle times are reduced since the painting process does not have to be interrupted because of heating intervals. If required, oven drying is also possible, in which case sandability is achieved after drying for approx. 10-15 minutes at 60°C or 20-25 minutes at 40°C plus cooling phase. Alternatively, it is also possible to do 5-10 minutes infrared drying. Ready for use after the addition of hardener Mipa 2K-HS-Härter HX 10 or HS 10. Excellent adhesion on bare metals. Perfectly suitable for Spot-Repair.

Spreading rate: 6,0 - 8,0 m<sup>2</sup>/l

### Processing instructions

	<b>Colour</b> grey						
	<b>Mixing ratio</b>	<b>Hardener</b>	<b>by weight (lacquer : hardener)</b>	<b>by volume (lacquer : hardener)</b>			
		2K-HX-Härter HX 10	--	4 : 1			
		2K-Härter HS 10	--	4 : 1			
	<b>Hardener</b>	<b>for complete paintwork</b>		<b>for partial paintwork</b>			
		--		--			
	<b>Pot life</b> 45 min at 20 °C						
	<b>Thinner</b> 0 - 10 % Mipa 2K-Verdünnung V 25						
	<b>Spray viscosity</b> The appropriate viscosity for spraying is achieved after the addition of hardener. To obtain very smooth surfaces add up to 10 % of Mipa 2K-Verdünnung V 25 (thinner).	<b>gravity spray gun</b> 20 - 30 s 4 mm DIN	<b>Airmix/Airless</b> --				
	<b>Application mode</b>	<b>Application mode</b>	<b>Hardener</b>	<b>pressure (bar)</b>	<b>nozzle (mm)</b>	<b>spray passes</b>	<b>Thinner</b>
		gravity spray gun (high pressure)	--	1,6 - 2	1,3 - 1,8	1 - 2	--
		HVLP (low pressure)	--	1,6 - 2	1,3 - 1,8	1 - 2	--
		HVLP / internal nozzle pressure	--	0,7	--	--	--



### Flash-off time

2 - 5 min between the coats

10 - 15 min before oven drying

### Dry coat thickness

50 - 100 µm



### Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	5 - 10 min	25 - 30 min	–	1 h	–
60 °C	2 - 5 min	10 min	–	10 - 15 min	–
Infrared drying shortwave	–	–	–	5 min	–
Infrared drying mediumwave	–	–	–	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. 520 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.