Mipa 2K-EP-Expressprimer EPX

Technical data sheet

Intended use

Mipa 2K-EP-Expressprimer EPX is a fast drying, chromate-free wet-on-wet filler based on epoxy resins and designed for application in vehicles construction and car refinish. Very good flow, very fast drying and the outstanding overspray absorption ensure fast overcoatability after only 20 -30 minutes and optimum gloss at the same time.
If necessary, Mipa 2K-EP-Expressprimer EPX can be sanded after only 3 - 4 hours drying at 20 °C.

The drying periods to become overcoatable and sandable depend on the applied dry film thickness:

In case of one spray pass of approx. 25 µm DFT: overcoatable after 20 min./20 °C, sandable after 3 h/20 °C.

In case of 2 spray passes approx. 50 µm DFT: overcoatable after 30 min./20 °C, sandable after 4 h/20 °C.

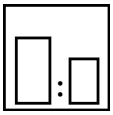
Perfectly suitable as primer before applying polyester body filler and polyester spray filler. Adhesion on steel, aluminium and zinced substrates. Ready for use after having added the hardener.

Spreading rate: 13,0 - 13,5 m²/l (for 25 µm DFT)

Processing instructions

Colour

light grey



Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
Mipa 2K-EP-Expresshärter EPH	--	1 : 1

Hardener

for complete paintwork	for partial paintwork
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Pot life

approx. 4 h at 20 °C

Thinner

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Spray viscosity

ready for use after having added the hardener

gravity spray gun	Airmix/Airless
16 - 22 s 4 mm DIN	--

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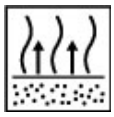
Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
gravity spray gun (high pressure)	--	1,6 - 2	1,3 - 1,6	1 - 2	0
HVLP (low pressure)	--	1,6 - 2	1,3 - 1,6	1 - 2	0
HVLP / internal nozzle pressure	--	0,7	--	--	--



Flash-off time

5 - 8 min between coats

10 - 15 min before oven drying

Dry coat thickness

25 - 50 µm

Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	10 - 15 min	1,5 - 2 h	--	3 - 4 h	20 - 30 min
60 °C	--	30 min	--	30 min	--

Note

Storage: at least 3 years in unopened original containers

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 humidity. Ensure adequate ventilation.

Processing instructions: The substrate must be clean, dry and free from grease.

Substrate preparation: All substrates must be pre-cleaned with Mipa Silikonentferner. Zinced substrates must be pre-treated with an ammoniac wetting agent. Pre-treatment: Sand aluminium with P 220, steel with P 120. After sanding clean again thoroughly with Mipa Silikonentferner.

It can be coated with body filler or putty after 30 minutes at 60 °C or after 12 hours at room temperature. When coating with body filler or putty or when using Mipa P 60 S PE-Spritzfüller do not exceed the coat thickness of max. 25 µm (one spray pass). If higher coat thicknesses are required, it's possible to apply Mipa 2K-EP-Expressprimer EPX also in dry film thickness of up to 120 µm. In this case, it's absolutely necessary to observe a drying time of at least 16 hours at room temperature.

After a drying of more than 48 hours, the priming coat must be sanded.

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 using the sanding paper P 500/ 600 for dry sanding and P 800/ 1000 for wet sanding.

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