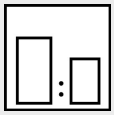
AK 230-30 Synthetic HB Topcoat satin matt

Intended use

Fast drying synthetic high-build paint to coat steel parts, cast parts, containers, machines, chassis, switchboards, transport racks and so on. For interior and exterior use.

Processing instructions



Mixing ratio

hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
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Hardener

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Pot life

2 days with Mipa Härterverdünnung

Thinner

Mipa UN-Verdünnung

Mipa Verdünnung UN 21

Mipa Härterverdünnung

Processing viscosity

gravity spray gun	Airmix/Airless
20 - 30 s 4 mm DIN	50 - 60 s 4 mm DIN

Application mode

application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
gravity spray gun / HVLP	--	2,0 - 2,5	1,3 - 1,8	2 - 3	15 - 20 %
Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,36 - 0,54	1 - 2	0 - 5 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	10 - 15 min	35 - 40 min	12 h	--	12 h
--	60 °C	--	--	90 min	--	--

Fully cured after 6 - 7 days (at 20 °C).

Note

Characteristics:

binder base:	alkyd resin
solids content (% by weight):	~ 70
solids content (% by volume):	~ 48
delivery viscosity DIN 53211 4 mm (in s):	thixotropic
density DIN EN ISO 2811 (kg/l):	~ 1,5
gloss level ISO 2813 at 60° (GU):	30 - 40 satin matt

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Properties:	Highly resistant to UV and weathering Can be applied in thick layers Very short drying time Electrostatic application possible Resistant to petrol and diesel if exposed temporarily Short-term heat exposure 150 °C Permanent heat exposure 130 °C Adhesion on steel
Theoretical spreading rate:	~ 33,9 m²/kg for 10 µm dry film thickness. ~ 48,7 m²/l for 10 µm dry film thickness.
Storage:	For at least 3 years in the unopened original container. Optimum storage conditions between + 5 °C and + 25 °C, avoid direct sunlight. Other storage conditions may lead to undesirable properties of the material.
VOC:	< 480 g/l.
Processing conditions:	From + 10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.
Substrate preparation:	Remove oil, grease, rust, mill scale, rolling skins, as well as other substances impairing the function of the coating! Attention: A direct adhesion cannot be taken as granted due to most different kinds of metals, alloys, metallic and conversion coatings and so on. The adhesion must therefore be tested on the original substrate. Steel: - Blast to cleaning degree Sa 2½, remove blast residues and overcoat promptly. - De-rust with hand and power tools to degree of cleanliness St 3. - Degrease with Mipa WBS Reiniger or Mipa Silikonentferner.
Proposed coating structure:	Single-coat system Steel: AK 230-30 with 80 - 100 µm dry film thickness. Two-coat system Steel: Priming coat: *AK 100-20 / AK 105-20 with 50 - 60 µm dry film thickness. Finishing coat: AK 230-30 with 80 - 100 µm dry film thickness.

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Special notes:

*Further Mipa primers are available. Please contact your technical adviser or our application technicians.

For professional use only.

The details of the paragraphs - Proposed coating structure, Characteristics, Theoretical spreading rate, VOC - refer to the colour shade RAL 7035. For other colour shades, these may deviate.

When alkyd resin (based) products are stored, a skin can form on the surface of the paint due to the system. This generally has no negative effects on the quality (material testing is recommended!).
If a skin has formed, it must be carefully removed before stirring (before tinting for bases) and the product must be sieved as required before application.

Applying too thick layers may extend considerably the drying time.

If necessary it's possible to add 1% by weight of Mipa AK 900-25 Sikkativkonzentrat to speed up the drying process.

Check colour before use.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.

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