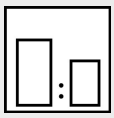
AK 233-60 Synthetic Single-layer Topcoat HS satin gloss

Intended use

This low-solvent, oxidation-curing high-build one-layer paint with active protection against corrosion is suitable for coatings on steel constructions, cast parts, containers, machines, chassis, switchboards and so on which are made of steel, zinced steel and aluminium. Due to its special formulation, the product can already be exposed to moisture after drying for approx. 30 minutes at 20 °C.

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 Härterverdünnung

Thinner

Mipa UN-Verdünnung

Mipa Verdünnung UN 21

Mipa Härterverdünnung

Processing viscosity

gravity spray gun	Airmix/Airless
thixotropic	thixotropic

Application mode

application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
gravity spray gun/ HVLP	--	2,0 - 2,5	1,7 - 2,5	2 - 3	10 - 15 %
Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,36 - 0,54	1	0 - 10 %
paint brush, roller	--	--	--	--	0 - 10 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	30 - 40 min	ca. 5 h	12 h	--	--
--	60 °C	--	--	1 h	--	--

Fully cured after 8 - 10 days (20 °C).

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Note

Characteristics:	binder base:	modified alkyd resins
	solids content (% by weight):	~ 75
	solids content (% by volume):	~ 56
	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):	60 - 70 satin gloss

Properties:

Highly UV- and weather-resistant
After only 30 min/20 °C resistant to moisture
Heat resistance:
- Short-term heat exposure: 150 °C
- Permanent heat exposure: 130 °C

Adhesion to steel, zinced substrates and aluminium

Theoretical spreading rate:

~ 38,8 m²/kg for 10 µm dry film thickness.
~ 56,5 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:

< 380 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.

Zinced substrates:
- Clean the surface with the ammonia solution Mipa Zinkreiniger.
- Sweep blast.

Aluminium:
- Degrease with Mipa 2K-Verdünnung, sand thoroughly with sandpaper P 360/400 and clean subsequently with Mipa Silikonentferner.

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Proposed coating structure:

Single coat system
Steel, zinced substrates, aluminium:
AK 233-60 with 60 - 80 µm dry film thickness.

2-coat system
Steel:
Priming coat: *AK 105-20 with 50 - 60 µm dry film thickness.
Finishing coat: AK 233-60 with 60 - 80 µm dry film thickness.

Zinced substrates:
Priming coat:: *EP 100-20 with 50 - 60 µm dry film thickness.
Finishing coat: AK 233-60 with 60 - 80 µm dry film thickness.

Aluminium:
Priming coat:: *EP 100-20 with 25 - 30 µm dry film thickness.
Finishing coat: AK 233-60 with 60 - 80 µm dry film thickness.

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.

Check colour shade prior to application.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.

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