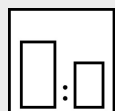


Intended use

This oxidation-curing high-build one-layer paint with active protection against corrosion is suitable to apply thick coatings on steel constructions, cast parts, containers, machines, chassis, switchboards and so on which are made of steel, zinc steel and aluminium. Also suitable for wood substrates. For interior and exterior use. Low solvent content.

Processing instructions



Mixing ratio

hardener

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by weight (lacquer : hardener)

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by volume (lacquer : hardener)

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Hardener

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Pot life

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Thinner

Mipa 2K-Verdünnung V 10, V 25, V 40



Processing viscosity

gravity spray gun

30 - 40 s 4 mm DIN

Airmix/Airless

50 - 60 s 4 mm DIN



Application mode

application mode

hardener

pressure
(bar)

nozzle
(mm)

spray
passes

dilution

gravity spray gun /
HVL

--

2,0 - 2,5

1,7 - 2,5

2 - 3

10 - 15 %

Airmix / Airless
compound pressure

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1,0 - 2,0
100 - 120

0,36 - 0,54

1

0 - 5 %

paint brush, roller

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0 - 5 %



Drying time

hardener

object
temperature

dust dry

set to
touch

ready for
assembly

sandable

recoatible

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20 °C

25 - 30 min

3 - 4 h

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

Note**Characteristics:**

binder base:	modified alkyd resins
solids content (% by weight):	~ 72
solids content (% by volume):	~ 57
delivery viscosity DIN 53211 4 mm (in s):	thixotropic
density DIN EN ISO 2811 (kg/l):	~ 1,3
gloss level ISO 2813 at 60° (GU):	60 - 80 satin gloss

Properties:

Highly UV- and weather-resistant
Can be applied in thick layers
Active corrosion protection (zinc phosphate)
Resistant to petrol and diesel if exposed temporarily
Short-term heat exposure 150 °C
Permanent heat exposure 130 °C
Adhesion on steel, zincd substrates and aluminium

Theoretical spreading rate:

~ 44,1 m²/kg for 10 µm dry film thickness.
~ 58,0 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:

< 400 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 metal 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.

Zincd 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.

Wood (wood moisture: max. 15 %):

- Pre-sand with sandpaper P 180 - P 280 and dust off thoroughly.

Proposed coating structure: Single-coat system

Steel, zincd substrates, aluminium:

AK 260-70 with 80 - 100 µm dry film thickness.

2-coat system

Steel, zincd substrates:

Priming coat: **EP 100-20 with 50 - 60 µm dry film thickness.

Finishing coat: AK 260-70 with 80 - 100 µm dry film thickness.

Aluminium:

Priming coat: **EP 100-20 with 25 - 30 µm dry film thickness.

Finishing coat: AK 260-70 with 80 - 100 µm dry film thickness.

Wood in exterior use:

Waterproofing: Mipaxyl spezial.

Priming coat: Mipa Malervorlack HS with 50 - 60 µm dry film thickness.

Finishing coat: AK 260-70 with 80 - 100 µm dry film thickness.

Wood in interior use:

Priming coat: Mipa Malervorlack HS with 50 - 60 µm dry film thickness.

Finishing ocat: AK 260-70 with 80 - 100 µm dry film thickness.

Special notes:

*This product contains the following maximum VOC-values:

- Applied by spraying: < 500 g/l of VOC.

**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.

Applying too thick layers may extend considerably the drying time.

Check colour before use.

Furthermore it's possible to mix it with neon colours which can be applied then as single-layer. Please see the technical data sheet "Mipa Neon-Farbtöne PMI single-layer paints"

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.