Intended use

Fast drying special paint based on plastic reinforced synthetic resins that is particularly resistant to saltwater and humidity.

Colours: DB 7350 novagrau SG, RAL 9005 black GL, RAL 9011 MAN graphite-black SG. Further colour shades on request.

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
18 - 22 s 4 mm DIN	40 - 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	1,2 - 1,5	2 - 3	15 - 20 %
Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,23 - 0,28	2	10 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	30 - 60 min	5 - 6 h	16 h	--	--
--	60 °C	10 - 15 min	40 - 60 min	after cooling	--	--

Before drying at higher temperature, allow flash-off of 10 - 15 minutes

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Note

Characteristics:	binder base:	modified alkyd resins
	solids content (% by weight):	~ 55
	solids content (% by volume):	~ 47
	delivery viscosity DIN 53211 4 mm (in s):	100 - 120
	density DIN EN ISO 2811 (kg/l):	~ 1,2
	gloss level ISO 2813 at 60° (GU):	depends on the colour

Properties:

Short drying time
Good hiding power
Highly UV- and weather-resistant
Excellent vertical stability
Excellent flow, high final hardness, stable gloss
Resistant to fuels and diesel if exposed temporarily
Particularly resistant to saltwater and humidity
Heat resistance:
- Short-term heat exposure: 150 °C
- Permanent heat exposure: 130 °C

Theoretical spreading rate:

~ 45,2 m²/kg for 10 µm dry film thickness.
~ 46,4 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:

< 500 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:

Steel:
Priming coat: *AK 100-20 / AK 105-20 with 50 - 60 µm dry film thickness.
Finishing coat: Mipalin FG-Spezial-Chassislack with 50 - 60 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 DB 7350 novagrau SG. 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.

Depending on the colour, the delivery viscosity may vary. Adjust the viscosity by adding thinner.

Check colour before use.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.

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