Mipa Zink-Alu-Spray

Item no 682135500

Technical data sheet

Intended use

Mipa Zink-Alu-Spray is a high-quality zinc dust coating with high corrosion protection for use on steel and ferrous metals and is perfectly suited for refinishing hot-dip galvanised steel parts in compliance with DIN EN ISO 1461. Since the colour shade is matched to that of the hot-dip galvanized surface, it is easier to visually adapt the repaired areas. Due to the corrosion protection properties of Mipa Zink-Alu-Spray, the coating is highly resistant to moisture and has a corrosion resistance of > 450 hours in salt spray tests according to DIN EN ISO 9227. Mipa Zink-Alu-Spray is also resistant to high temperatures of up to 300 °C, can be spot-welded and if required, can be overcoated with Mipa 1K paints. For indoor and outdoor use.

Processing instructions

Substrates

Iron and steel.

Pre-treatment / cleansing

Pre-clean with Mipa Silikonentferner.
Please refer to the section "Substrate preparation" for detailed information.

Characteristics

Especially suitable for spot welding
High zinc content, therefore high corrosion protection
Resistant to chemical agents and physical stress
Heat-resistant up to at least 300 °C
Allows refinishes conforming to standards as per DIN EN ISO 1461
Fast drying

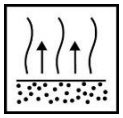
Colour / gloss level silver-aluminium, visually similar to hot-dip galvanising

Preparation

Before use, shake can vigorously for 1 - 2 minutes!

Application

Spray to test - spray distance approx. 15 - 20 cm
2 - 3 coats, dry film thickness: 30 - 40 µm



Flash-off time

2 - 3 min between coats

After use

After use, turn can upside down and spray until the valve is clean, this prevents the valve from clogging up.

MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49(0)87 03/922-0 · Fax: +49(0)87 03/922-100 · mipa@mipa-paints.com · www.mipa-paints.com

Drying times at 20 °C	
Dust dry after approx.	15 min
Set to touch after approx.	1 h
Overcoatable after approx.	4 - 6 h

Processing conditions	From +10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.
Storage	Can be stored for 2 years in cool and dry places.
VOC-regulation	EU limit value for the product (cat. B/e): 840 g/l This product contains max. 650 g/l of VOC.
Safety information	See safety data sheet

Substrate preparation:

The substrate must be clean and dry. Remove oil, grease, rust, corrosion as well as any other substances impairing the function of the coating!

Steel substrates:
Blast to cleaning degree Sa 2½, remove blast residues and overcoat promptly.

Alternatively:

1. Pre-clean with Mipa Silikonentferner.
2. Then de-rust with hand and power tools to degree of cleanliness St 3.
3. Afterwards, degrease with Mipa Silikonentferner.

Refinishing galvanised substrates (batch galvanising / discontinuous hot-dip galvanising / strip galvanising / continuous hot-dip galvanising and electrogalvanising):
1. Pre-clean the repaired area with Mipa Silikonentferner.
2. Then dry sand with P 220.
3. Afterwards, degrease with Mipa Silikonentferner.

Note: When repairing damaged galvanised areas, the dry film thickness of Mipa Zink-Alu-Spray must be approx. 30 µm higher than the existing zinc layer.

MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49(0)87 03/922-0 · Fax: +49(0)87 03/922-100 · mipa@mipa-paints.com · www.mipa-paints.com