# Mipa Zink-Alu-Spray

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#### 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.

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	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 21/2, 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.

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