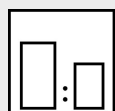


Intended use

Synthetic high-build one-coat paint with active protection against corrosion to apply thick coatings on steel parts, cast parts, containers, machines, chassis, switchboards and so on. For interior and exterior use.

Processing instructions



Mixing ratio

hardener

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by weight (lacquer : hardener)

--

by volume (lacquer : hardener)

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Hardener

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Pot life

2 days with Mipa Härterverdünnung



Thinner

Mipa UN-Verdünnung

Mipa Verdünnung UN 21

Mipa Härterverdünnung

For application by brush/ roller use Mipa KH-Verdünnung (thinner)



Spray viscosity gravity spray gun

20 - 30 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 /
HVLP

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2,0 - 2,5

1,3 - 1,5

2 - 3

15 - 20 %

Airmix / Airless

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100 - 120

0,28 - 0,4

1 - 2

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

recoatable

--

20 °C

50 - 60 min

3 - 4 h

24 h

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24 h

--

60 °C

--

--

90 min

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

Note

Characteristics:	binder base: alkyd resine solids content (% by weight): 63 - 68 solids content (% by volume): 47 - 49 delivery viscosity DIN 53211 4 mm (in s): thixotropic density DIN EN ISO 2811 (kg/l): 1,2 - 1,4 gloss level ISO 2813 at 60° (GU): 30 - 45 satin matt
Properties:	highly resistant to UV and weathering can be applied in thick layers active corrosion protection (zinc phosphate) electrostatic application possible resistant to petrol and diesel if exposed temporarily short-term heat exposure 150 °C permanent heat exposure 130 °C adhesion on steel
Theoretical spreading rate :	35,1 - 37,7 m ² /kg for 10 µm dry film thickness 47,2 - 48,8 m ² /l for 10 µm dry film thickness
Storage:	at least 3 years in unopened original container
VOC Regulation :	EU limit value according to Directive 2004/42/EC for this product (category A/i): 500 g/l This product contains the following maximum VOC-values: applied by brush/ roller: < 490 g/l of VOC
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
Proposed coating structure:	single-coat system steel AK 225-30 with 80 - 100 µm dry film thickness two-coat system steel priming coat: *AK 105-20 with 50 - 60 µm dry film thickness finishing coat: AK 225-30 with 80 - 100 µm dry film thickness * Further Mipa primers are available. Please contact your technical adviser or our application technicians.
Special notes:	For professional use only. Applying too thick layers may extend considerably the drying time. Check colour before use.

Cleaning of tools: Clean tools immediately after use with Mipa Nitroverdünnung.