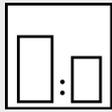
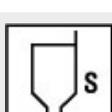


Intended use

Thixotropic, high-build monolayer paint to coat constructions (halls, pipes, doors, wall and ceiling panels, roofs, recipients, container, vehicle constructions) made of steel, zinc steel and aluminium. Suitable for brush, roller and spray application. For interior and exterior use.

Processing instructions

	Mixing ratio						
	hardener		by weight (lacquer : hardener)	by volume (lacquer : hardener)			
	--	--	--	--			
	Hardener						
	--						
	Pot life						
	--						
	Thinner						
	Mipa Verdünnung UN 21						
	Processing viscosity						
	gravity spray gun			Airmix/Airless			
	20 - 25 s 4 mm DIN			--			
	Application mode						
	application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution	
	Gravity spray gun/ HVLP	--	2,0 - 2,5	1,3 - 1,5	2 - 3	10 - 15 %	
	Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,28 - 0,33	1	0 - 10 %	
	paint brush, roller	--	--	--	--	0 - 10 %	
	Drying time						
	hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
	--	20 °C	20 min	2 h	24 h	--	--
	--	60 °C	--	--	1 h	--	--

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

Note

Characteristics:	binder base:	acrylic resin
	solids content (% by weight):	~ 68
	solids content (% by volume):	~ 48
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	~ 1,5
	gloss level ISO 2813 at 60° (GU):	20 - 40 satin matt
Properties:	good edge coverage	
	electrostatic application possible	
	non-blocking	
	heat resistance:	
	- short-term heat exposure: 150 °C	
	- permanent heat exposure: 120 °C	
	adhesion on steel, zined substrates	
	adhesion on aluminium Gt 0-1	
Theoretical spreading rate :	~ 37,5 m ² /kg for 10 µm dry film thickness	
	~ 48,9 m ² /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:	< 430 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	
	zined 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	

Proposed coating structure: single coat system
steel, zinc coated substrates, aluminium:
AY 250-30 with 70 - 90 µm dry film thickness

2-coat system
steel, zinc coated substrates:
priming coat: *VB 100-20 / EP 100-20 with 50 - 60 µm dry film thickness
finishing coat: AY 250-30 with 50 - 70 µm dry film thickness

aluminium:
priming coat: *VB 100-20 / EP 100-20 with 25 - 30 µm dry film thickness
finishing coat: AY 250-30 with 50 - 70 µm dry film thickness

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 RAL 7035. For other colour shades, these may deviate.

Especially UV-resistant pigmentations are available on demand.

Check colour prior to application.

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