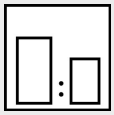
AK 225-30 Synthetic Single-layer HB Topcoat satin matt

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	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

Processing viscosity

gravity spray gun	Airmix/Airless
20 - 30 s 4 mm DIN	50 - 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	1,3 - 1,5	2 - 3	15 - 20 %
Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,28 - 0,4	1 - 2	0 - 5 %
paint brush, roller	--	--	--	--	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	--	24 h
--	60 °C	--	--	90 min	--	--

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

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Note

Characteristics:	binder base:	alkyd resine
	solids content (% by weight):	~ 68
	solids content (% by volume):	~ 49
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	~ 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 : ~ 37,7 m²/kg for 10 µm dry film thickness
~ 48,8 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: < 466 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

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

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Special notes:

*This product contains the following maximum VOC-values:
- Applied by brush/ roller: < 490 g/l of VOC.

**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.

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.

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