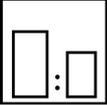


Intended use

Fast drying nitro combination lacquer to coat metal (machines, tools, constructions) for interior and exterior use and wood (furniture, wooden parts) for interior use.

Processing instructions

	Mixing ratio						
	hardener		by weight (lacquer : hardener)	by volume (lacquer : hardener)			
	--		--	--			
	Hardener						
	--						
	Pot life						
	--						
	Thinner						
	Mipa UN-Verdünnung						
	Mipa Verdünnung UN 21						
	Processing viscosity						
	gravity spray gun		Airmix/Airless				
	20 - 25 s 4 mm DIN		30 - 40 s 4 mm DIN				
	Application mode						
	application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution	
	gravity spray gun / HVLP	--	2,0 - 2,5	1,2 - 1,3	2 - 3	40 - 50 %	
	Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,23 - 0,28	1	15 - 20 %	
	Drying time						
	hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
	--	20 °C	5 - 10 min	15 - 20 min	1 h	--	--
	--	60 °C	--	--	15 min	--	--

Fully cured after 2 - 3 days (at 20 °C).

Note

Characteristics:	binder base:	nitro acrylic combination
	solids content (% by weight):	~ 40
	solids content (% by volume):	~ 26
	delivery viscosity DIN 53211 4 mm (in s):	80 - 100
	density DIN EN ISO 2811 (kg/l):	~ 1,1
	gloss level ISO 2813 at 60° (GU):	10 - 20 matt

Properties:	very fast drying highly UV- and weather-resistant high hardness, sandable and polishable after a short time heat resistance: - short-term heat exposure: 150 °C - permanent heat exposure: 120 °C
Theoretical spreading rate :	~ 26,6 m ² /kg for 10 µm dry film thickness ~ 26,9 m ² /l for 10 µm dry film thickness
Storage:	For at least 1 year 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:	< 610 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 wood (wood moisture: max. 15 %): - pre-sand with grit P 180 - P 280 and remove dust thoroughly
Proposed coating structure:	steel: priming coat: *AK 100-20 / AK 105-20 with 50 - 60 µm dry film thickness finishing coat: CN 200-10 with 20 - 30 µm dry film thickness wood for interior use: priming coat: CN 200-10 with 10 - 15 µm dry film thickness finishing coat: CN 200-10 with 20 - 30 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. 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.