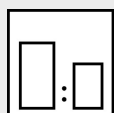


Intended use

Fast drying high-build synthetic paint with active protection against corrosion (zinc phosphate) to coat steel parts, cast parts, containers, machines, chassis, switchboards, transportation racks and so on. For interior and exterior use.

Processing instructions



Mixing ratio

hardener

by weight (lacquer : hardener)

by volume (lacquer : hardener)

—

—

—



Hardener

—



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

40 - 50 s 4 mm DIN



Application mode

application mode

hardener

pressure
(bar)

nozzle (mm)

spray
passes

dilution

gravity spray gun /
HVL

—

2,0 - 2,5

1,3 - 1,5

2 - 3

15 - 20 %

Airmix / Airless
compound pressure

—

1,0 - 2,0
100 - 120

0,23 - 0,33

1 - 2

0 - 5 %



Drying time

hardener

object
temperature

dust dry

set to
touch

ready for
assembly

sandable

recoatable

—

20 °C

10 - 15 min

30 - 35 min

12 h

—

12 h

—

60 °C

—

—

90 min

—

—

Fully cured after 6 - 7 days (at 20 °C).

Note

Characteristics:

binder base:

alkyd resin

solids content (% by weight):

~ 59

solids content (% by volume):

~ 38

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):

> 80 glossy

Properties:	highly resistant to UV and weathering can be applied in thick layers active corrosion protection (zinc phosphate) very short drying time 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 :	~ 32,5 m ² /kg for 10 µm dry film thickness ~ 38,4 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:	< 500 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 232-90 with 80 - 100 µm dry film thickness 2-Schicht-Aufbau steel: priming coat: *AK 105-20 with 50 - 60 µm dry film thickness finishing coat: AK 232-90 with 80 - 100 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 shade prior to application.
Cleaning of tools:	Clean tools immediately after use with Mipa Nitroverdünnung.