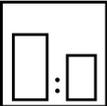


Intended use

Very fast drying, highly weather-resistant and heavy-duty synthetic paint with high vertical stability to coat commercial vehicles, machines and construction. For interior and exterior use. It can be applied by paint brush, roller and spray gun.

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
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	Thinner	Mipa UN-Verdünnung Mipa Verdünnung UN 21 Mipa Härterverdünnung
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	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	1,3 - 1,5	2 - 3	15 - 20 %
	Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,28 - 0,33	1	5 - 10 %
	paint brush, roller	--	--	--	--	0 %

	Drying time						
	hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
	--	20 °C	25 - 30 min	4 - 6 h	16 h	--	--
	--	60 °C	--	--	45 min	--	--

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

Note

Characteristics:	binder base:	modified alkyd resin
	solids content (% by weight):	~ 56
	solids content (% by volume):	~ 41
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	~ 1,2
	gloss level ISO 2813 at 60° (GU):	> 80 glossy
Properties:	very short drying time	
	highly resistant to UV and weathering	
	resistant to petrol and diesel if exposed temporarily	
	high vertical stability	
	excellent gloss retention	
	very good flow	
	short-term heat exposure 150 °C	
	permanent heat exposure 130 °C	
Theoretical spreading rate :	~ 40,4 m ² /kg for 10 µm dry film thickness	
	~ 41,5 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:	< 470 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:	steel:	
	priming coat: *AK 105-20 with 50 - 60 µm dry film thickness	
	finishing coat: AK 235-90 with 50 - 60 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.

Depending on the colour, the delivery viscosity may vary. Adjust the viscosity by adding thinner.

Check colour shade prior to application.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.