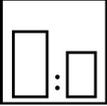


### Intended use

High-quality, weather-, UV- and yellowing-resistant thermal curing acrylic-melamine enamel to coat vehicles and machines.

### Processing instructions

	<b>Mixing ratio</b>						
	<b>hardener</b>		<b>by weight (lacquer : hardener)</b>	<b>by volume (lacquer : hardener)</b>			
	--	--	--	--			
	<b>Hardener</b>						
	--						
	<b>Pot life</b>						
	--						
	<b>Thinner</b>						
	Mipa 2K-Verdünnung V 10, V 25, V 40						
	<b>Processing viscosity</b>						
	<b>gravity spray gun</b>			<b>Airmix/Airless</b>			
	--	--	--	--			
	<b>Application mode</b>						
	<b>application mode</b>	<b>hardener</b>	<b>pressure (bar)</b>	<b>nozzle (mm)</b>	<b>spray passes</b>	<b>dilution</b>	
	gravity spray gun/ HVLP	--	2,0 - 2,5	1,3 - 1,5	2 - 4	20 - 25 %	
	Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,28 - 0,33	1	0 %	
	<b>Drying time</b>						
	<b>hardener</b>	<b>object temperature</b>	<b>dust dry</b>	<b>set to touch</b>	<b>ready for assembly</b>	<b>sandable</b>	<b>recoatable</b>
	--	120 °C	--	--	45 min	--	--
	--	140 °C	--	--	30 min	--	--
	--	160 °C	--	--	20 min	--	--
	--	180 °C	--	--	10 min	--	--

Before stoving allow a flash-off time of 5 -10 min at 20°C and after the stoving allow a cooling period.

## Note

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<b>Characteristics:</b>	binder base: solids content (% by weight): solids content (% by volume): delivery viscosity DIN 53211 4 mm (in s): density DIN EN ISO 2811 (kg/l): gloss level ISO 2813 at 60° (GU):	acrylic melamine system ~ 60 ~ 42 40 - 60 ~ 1,3 50 - 65 satin gloss
<b>Properties:</b>	electrostatic application possible highly UV- and weather-resistant resistant to solvents heat resistance: - short-term heat exposure: 180 °C - permanent heat exposure: 150 °C adhesion on steel	
<b>Theoretical spreading rate:</b>	~ 36,9 m <sup>2</sup> /kg for 10 µm dry film thickness ~ 42,6 m <sup>2</sup> /l for 10 µm dry film thickness	
<b>Storage:</b>	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.	
<b>VOC:</b>	< 520 g/l.	
<b>Processing conditions:</b>	From + 10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.	
<b>Substrate preparation:</b>	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: - de-rust with hand and power tools to degree of cleanliness St 3 - degrease with Mipa WBS Reiniger or Mipa Silikonentferner - When using chemical pre-treatment observe manufacturer's instructions.	
<b>Proposed coating structure:</b>	single coat system steel: SE 200-70 with 20 - 40 µm dry film thickness	
<b>Special notes:</b>	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 (e.g. for facades) are available on demand.  Check colour shade prior to application.	
<b>Cleaning of tools:</b>	Clean tools immediately after use with Mipa Nitroverdünnung.	