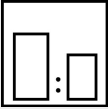








Intended use

Thixotropic satin matt synthetic paint with long open time to coat by brush or roller components and constructions which are made of wood or metal. 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 KH-Verdünnung					
		Mipa Terpentinersatz					
		Mipa Härterverdünnung					
	Processing viscosity gravity spray gun						
		20 - 25 s 4 mm DIN		Airmix/Airless			
					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	1,5 - 1,8	2 - 3	20 - 25 %	
	Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,23 - 0,33	1	10 - 15 %	
	paint brush, roller*	--	--	--	--	0 - 10 %	
	Drying time						
	hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
	--	20 °C	60 - 70 min	6 - 8 h	24 h	--	24 h
	--	60 °C	--	--	60 min	--	--

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

Note

Characteristics:	binder base: alkyd resin solids content (% by weight): ~ 71 solids content (% by volume): ~ 58 delivery viscosity DIN 53211 4 mm (in s): thixotropic density DIN EN ISO 2811 (kg/l): ~ 1,3 gloss level ISO 2813 at 60° (GU): 20 - 30 satin matt
Properties:	long open time, excellent filling properties, good edge coverage highly UV- and weather-resistant resistant to petrol and diesel if exposed temporarily short-term heat exposure 140 °C permanent heat exposure 120 °C
Theoretical spreading rate :	~ 45,9 m ² /kg for 10 µm dry film thickness ~ 52,9 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:	< 350 g/l.**
Processing conditions:	From + 10 °C and up to 70 % 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 (max. moisture: 15 %): - pre-sanding with sandpaper P 180 - P 280 and dust off thoroughly
Proposed coating structure:	steel: priming coat: ***AK 100-20 / AK 105-20 with 50 - 60 µm dry film thickness finishing coat: AK 250-30 with 50 - 60 µm dry film thickness wood in exterior use: waterproofing: Mipaxyl spezial priming coat: Mipa Malervorlack HS with 50 - 60 µm dry film thickness finishing coat: AK 250-30 with 50 - 60 µm dry film thickness wood in interior use: priming coat: Mipa Malervorlack HS with 50 - 60 µm dry film thickness finishing coat: AK 250-30 with 50 - 60 µm dry film thickness

Special notes:

*Suitable: Mipa KH-Verdünnung, Mipa Terpentinersatz; unsuitable: Mipa Härterverdünnung.

**This product contains the following maximum VOC-values:
- Applied by brush/ roller: < 420 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.

Permanent thermal stress may lead to yellowing.

Check colour shade prior to application.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.