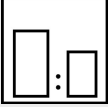



Intended use


Fast drying 2K HS zinc phosphate epoxy primer for steel, zincd substrates, aluminium and GRP. Suitable as priming coat for the top quality coating of commercial vehicles and highly stressed machines and constructions.


Colour: Grey. Further colour shades on request.


Processing instructions


	Mixing ratio		
	hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
	EP 968-25	4 : 1	4 : 1


	Hardener
	Mipa EP 968-25 2K-EP-Härter

	Pot life
	with hardener -25 approx. 6 h at 20 °C

	Thinner
	Mipa EP-Verdünnung, Mipa EP-Verdünnung lang

	Processing viscosity	
	gravity spray gun	Airmix/Airless
	–	50 - 60 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 - 2,5	2 - 3	5 %
	Airmix / Airless compound pressure	–	1,0 - 2,0 100 - 120	0,28 - 0,33	1 - 2	0 - 5 %
	brush, roller	–	–	–	–	5 %

	Drying time						
	hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
	–	20 °C	40 min	4 h	10 h	–	1 h
	–	60 °C	–	–	60 min	–	–

A flash-off phase of 15 min/20 °C is necessary before forced drying.

Note

Characteristics:	binder base: epoxy resin solids content (% by weight): ~ 77 solids content (% by volume): ~ 62 delivery viscosity DIN 53211 4 mm (in s): thixotropic density DIN EN ISO 2811 (kg/l): ~ 1,5 gloss level ISO 2813 at 60° (GU): < 20 matt
Properties:	active protection against corrosion (zinc phosphate) electrostatic application possible excellent resistance to chemical and mechanical strains suitable to insulate thermoplastic substrates heat resistance: - short-term heat exposure: 180 °C - permanent heat exposure: 150 °C adhesion to steel, zincd substrates, aluminium and GRP
Theoretical spreading rate:	~ 48,9 m ² /kg, 4:1 by weight with EP 968-25, for 10 µm dry film thickness ~ 67,9 m ² /l, 4:1 by weight with EP 968-25, 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:	< 340 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 zincd substrates: - clean the surface with the ammonia solution Mipa Zinkreiniger - sweep blast aluminium: - degrease with Mipa 2K-Verdünnung, sand thoroughly with sandpaper P 360/400 and clean subsequently with Mipa Silikonentferner GRP: - clean (remove completely any mould release agents), sand slightly if necessary and degrease again with Mipa Silikonentferner
Proposed coating structure:	2-coat system steel, zincd substrates, aluminium, GRP priming coat: EP 168-20 with 80 - 100 µm dry film thickness finishing coat: *PU 260-90 / PU 262-90 with 50 - 60 µm dry film thickness

Version: en 1/0124

This technical data sheet is supplied for informational purposes only! According to our information, all data and recommendations correspond to the state of art and are based on years of experience in manufacturing our products. They do not exempt the user from his obligation to verify professionally, on his own responsibility, the suitability of our products to the intended purpose under prevailing conditions. Safety data sheets and warnings on packaging must be observed. We reserve the right to modify and to complete the information content at any time, without prior notice or obligation to update.

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Special notes:

*Further Mipa topcoats are available. Please contact your technical adviser or our application technicians.

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The details of the paragraphs - Proposed coating structure, Characteristics, Theoretical spreading rate, VOC - refer to the colour shade grey. For other colour shades, these may deviate.

Recoatable at the earliest after 60 min at 20 °C and at the latest after 7 days. After drying for more than 7 days, intermediate sanding is required.

If required we also offer cleaning agents that are suitable for 2-component mixing and dosing units. Please contact your technical adviser or our application technicians.

Cleaning of tools:

Clean tools immediately after use with Mipa EP-Verdünnung.