EP 170-20 2K-EP-Zinkstaubfarbe

Technical data sheet

Intended use

Mipa EP 170-20 2K-EP-Zinkstaubfarbe (BAN80-7050) is a high-quality zinc dust coating that ensures long-term cathodic corrosion protection. It can be applied only on bare, completely rust-free steel that has been blasted to cleaning degree Sa 2½.

Registered according to Bundeswehr (German army) TL 8010-0012, class A, type 4.

Colour: greyish-green.

Processing instructions

Mixing ratio

hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
EP 980-25	24 : 1	--

Hardener

Mipa EP 980-25 2K-EP-Härter (BAN93-0053)

Pot life

with Härter -25 max. 24 h at 20 °C

Thinner

Mipa EP Verdünnung 971 (BAN97-0001)

Processing viscosity

Ready for use after addition of hardener, if necessary thin with Mipa EP Verdünnung 971.

The processing viscosity is adjusted with the specified thinner according to the conditions of the device/ line.

gravity spray gun	Airmix/Airless
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Application mode

application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
gravity spray gun / HVLP	--	2,0 - 2,5	1,4 - 1,6	2	0 %
paint pressure tank compound pressure	--	2,0 - 2,5 0,5 - 0,8	1,4 - 1,6	1 - 2	0 %
Airmix / Airless compound pressure	--	1,0 - 2,0 80	0,28 - 0,41	1	0 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	5 min	6 h	16 h	--	30 min

recoatable at the earliest after 30 min. at 20°C and at the latest after 7 days.

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Note

Characteristics:

binder base:	modified epoxy resin
solids content (% by weight):	~ 91
solids content (% by volume):	~ 58
delivery viscosity DIN 53211 4 mm (in s):	thixotropic
density DIN EN ISO 2811 (kg/l):	~ 3,1
gloss level ISO 2813 at 60° (GU):	Matt

Properties:

very high active corrosion protection (cathodic)
electrostatic application possible
heat resistance:
- permanent heat exposure: up to max 400 °C
adehesion on blasted steel

Theoretical spreading rate:

~ 19,2 m²/kg, 24:1 by weight with EP 980-25, for 10 µm dry film thickness
~ 48,8 m²/l, 24:1 by weight with EP 980-25, 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:

< 400 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

Proposed coating structure:

steel:
priming coat: EP 170-20 with 20 - 45 µm dry film thickness above roughness depth
intermediate coat: *EP 175-20 with 40 - 60 µm dry film thickness
finishing coat: *PU 246-XX / PU 249-XX with 40 - 60 µm dry film thickness

Special notes:

*Further Mipa intermediate/ finishing coats are available. Please contact your technical adviser or our application technicians.

To get more information about recommended coating structures according to corrosivity categories as per DIN EN ISO 12944 please contact us or have a look at the brochure "Mipa Corrosion protection"!

For professional use only.

Due to the system, zinc dust paints tend to develop more spray mist. Therefore, remove possible overspray either by clean compressed air (free from oil or water) or by a tack rag before applying the subsequent coating.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.

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