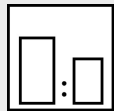


Intended use

Mipa EP 175-20 2K-EP-Primer (BAN83-1211) is a 2K epoxy resin primer containing zinc phosphate for coating steel, zinc substrates, aluminium and GRP. Suitable as an intermediate coat for a zinc dust and EP based priming coat.

Colours: Various colour shades.

Processing instructions



Mixing ratio

hardener

EP 940-25

by weight (lacquer : hardener)

4 : 1

by volume (lacquer : hardener)

3 : 1



Hardener

Mipa EP 940-25 2K-EP-Härter (BAN93-0009)



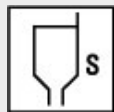
Pot life

with Härter -25 max. 24 h at 20 °C



Thinner

Mipa EP Verdünnung 971 (BAN97-0001)



Processing viscosity

After adding the hardener, allow approx. 15 min. pre-reaction time, then adjust viscosity.

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

gravity spray gun

20 - 30 s 4 mm DIN

Airmix/Airless

30 - 40 s 4 mm DIN



Application mode

application mode

gravity spray gun / HVLP

paint pressure tank compound pressure

Airmix / Airless compound pressure

brush, roller

hardener

–

–

–

–

pressure (bar)

2,0 - 2,5

2,0 - 2,5
0,5 - 0,8

1,0 - 2,0

70 - 100

–

nozzle (mm)

1,4 - 1,6

1,3 - 1,5

0,33 - 0,38

–

spray passes

2 - 3

2 - 3

1 - 2

–

dilution

15 - 20 %

bis 15 %

0 - 5 %

0 - 10 %



Drying time

hardener

–

–

object temperature

20 °C

60 °C

dust dry

10 - 15 min

–

set to touch

3 - 4 h

–

ready for assembly

2 days

45 min

sandable

–

–

recoatable

4 h

45 min

Note

Characteristics:	binder base: epoxy resin solids content (% by weight): ~ 73 solids content (% by volume): ~ 52 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 corrosion protection (zinc phosphate) electrostatic application possible excellent resistance to chemical and mechanical stresses can be used to insulate thermoplastic substrates heat resistance: - short-term heat exposure: 180 °C - permanent heat exposure: 150 °C adhesion on steel, zincd substrates, aluminium and GRP
Theoretical spreading rate:	~ 37,6 m ² /kg, 4:1 by weight with EP 940-25, for 10 µm dry film thickness ~ 48,6 m ² /l, 4:1 by weight with EP 940-25, 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:	< 450 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), if necessary, sand slightly and degrease with Mipa Silikonentferner

Proposed coating structure: steel, zincd substrates, aluminium, GRP:
priming 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
or
steel, zincd substrates, aluminium, GRP:
priming coat: EP 175-20 with 2 x 40 - 60 µm dry film thickness
finishing coat: **PU 246-XX / PU 249-XX with 40 - 60 µm dry film thickness

Special notes:

*This product has the following maximum VOC values:
- applied by spraying with 2K-EP-Härter EP 940-25: < 540 g/l of VOC.

**Further Mipa topcoats 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.

Flash-off time: 10 - 15 Min. prior to oven drying.

Recoatable at the earliest after 45 min at 60 °C or 4 h at 20 °C and at the latest after 14 days. After drying for more than 14 days, intermediate sanding is required.

Can be overcoated with putty after 60 minutes at 60 °C.

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 971.