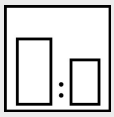
Intended use

High-solids 2K epoxy aluminium high-build paint which can be used as priming coat with high corrosion protection for steel, zinced substrates and aluminium. Very suitable for coating bridges, railings, docks, piping and structures in aggressive atmosphere as well as for areas exposed to sewage and seawater. Durable corrosion protection. Due to its very high solids content, this paint can be easily applied in thick layers and is also suitable for monolayer use.

Colour: Aluminium silver.

Processing instructions



Mixing ratio

hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
EP 964-10	1 : 1	1 : 1

Hardener

Mipa EP 964-10

Pot life

with hardener -10 approx.1 h at 20 °C

Thinner

Mipa EP-Verdünnung, Mipa EP-Verdünnung lang

Processing viscosity

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	1,8 - 2,0	2 - 3	5 - 10 %
Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,33 - 0,54	1	0 - 10 %
paint brush, roller	--	--	--	--	0 - 10 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	20 - 30 min	3 - 4 h	10 - 12 h	--	1 - 2 h
--	60 °C	--	--	60 min	--	--

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Note

Characteristics:	binder base:	epoxy resin
	solids content (% by weight):	~ 83
	solids content (% by volume):	~ 71
	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):	matt*

Properties:

applicable in thick layers
electrostatic application possible
excellent resistance to chemical and mechanical strains
highest corrosion protection, resistant to abrasion, viscoplastic
high resistance to water
heat resistance:
- short-term heat exposure: 200°C
- permanent heat exposure: 160°C

adhesion to steel, zinced substrates and aluminium

Theoretical spreading rate : ~ 47,8 m²/kg, 1:1 by weight with EP 964-10, for 10 µm dry film thickness
~ 67,1 m²/l, 1:1 by weight with EP 964-10, 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: < 260 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

zinced 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

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Proposed coating structure:

single coat system
steel, zinced substrates, aluminium:
EP 564-20 with 100 - 200 µm dry film thickness

3-coat system
steel:
priming coat: EP 564-20 with 100 - 200 µm dry film thickness
intermediate coat: EP 500-20 with 140 - 160 µm dry film thickness
finishing coat: **PU 240-XX / EP 200-XX with 50 - 60 µm dry film thickness

Special notes:

*Due to the special surface, a measurement according to DIN EN ISO 2813 is inappropriate!

**This product contains the following maximum values:
- Applied by spraying with 2K-EP-Dickschichthärter EP 964-10: < 370 g/l of VOC.

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

For professional use only.

Check colour prior to application.

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.

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