

### Intended use

2K-PUR HS single-layer aluminium paint for high-quality coating of truck trailers, commercial vehicles, machines etc. Due to the very high proportion of solids (HS quality), durable, high-gloss coatings can be achieved. Furthermore, the special pigmentation guarantees a safe application without mottling. Very good weather resistance, high chemical and mechanical resistance.

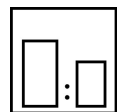
Spreading rate: 10,0 - 14,0 m<sup>2</sup>/l

### Processing instructions



#### Colour

approx. RAL 9006 white aluminium



#### Mixing ratio

##### Hardener

Mipa 2K-HS-Härter  
Mipa 2K-MS-Härter

##### by weight (lacquer : hardener)

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##### by volume (lacquer : hardener)

3 : 1  
2 : 1



#### Hardener

##### for complete paintwork

Mipa 2K-HS-Härter HS 25 / 35  
Mipa 2K-MS-Härter MS 25 / 40

##### for partial paintwork

Mipa 2K-HS-Härter HS 10  
Mipa 2K-Härter MS 10



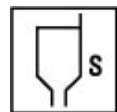
#### Pot life

1 h with Mipa 2K-Härter HS 10, MS 10 at 20 °C  
2 h with Mipa 2K-Härter HS 25, MS 25 at 20 °C  
4 h with Mipa 2K-Härter HS 35, MS 40 at 20 °C



#### Thinner

Mipa 2K-Verdünnung kurz V 10  
Mipa 2K-Verdünnung V 25  
Mipa 2K-Verdünnung lang V 40



#### Spray viscosity

Only thin when using HS hardeners. There is no need to thin when using MS hardeners.

##### gravity spray gun

20 - 25 s 4 mm DIN

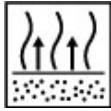
##### Airmix/Airless

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#### Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
gravity spray gun (high pressure)	--	2 - 2,5	1,3 - 1,4	1 - 2	5 - 10
HVLP (low pressure)	--	2 - 2,2	1,3 - 1,4	1 - 2	5 - 10
HVLP / internal nozzle pressure	--	0,7	--	--	--



### Flash-off time

5 - 8 min between coats  
10 - 15 min prior to oven drying

### Dry coat thickness

50 - 60 µm



### Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	45 - 55 min	5 - 6 h	12 - 24 h	--	--
60 °C	10 - 15 min	25 - 30 min	after cooling	--	--

### Note

**Storage:** at least 3 years in unopened original containers

**VOC Regulation :** EU limit value for this product (category B/e): 840 g/l  
This product contains max. 534 g/l of VOC.

**Processing conditions:** from +10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.

**Processing instructions:** To increase the application reliability, especially on large surfaces, the following paint structure is recommended:

1. Pre-painting:

Apply 1 flowing coat of Mipa PUR HS RAL 7001. This pre-painting creates a uniformly covering pre-paint similar in colour to the top coat RAL 9006. This reduces the risk of mottling during the application of Mipa PUR HS-Einschicht-Aluminium and ensures homogeneous hiding power.

2. final coating:

Overcoat the pre-paint wet-on-wet with 1 coat of Mipa PUR HS-Einschicht-Aluminium.