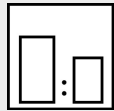


### Intended use

High-quality 2K polyurethane acrylic primer with active protection against corrosion and excellent adhesion to steel, zinc substrates and aluminium. Recoatable with 1K and 2K paints. This product can be used as adhesion promoter, primer and filler and can also be applied wet on wet.

### Processing instructions



#### Mixing ratio

##### hardener

PU 900-25, PU 912-XX

by weight (lacquer : hardener)

10 : 1

by volume (lacquer : hardener)

7 : 1



#### Hardener

Mipa PU 900-25, PU 912-10, PU 912-25



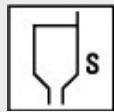
#### Pot life

with hardener -25 approx. 8-9 h at 20 °C



#### Thinner

Mipa 2K-Verdünnung V 10, V 25, V 40



#### Processing viscosity

In order to apply thicker layers (used as filler with a coat thickness of more than 60 µm), reduce the mentioned data referring to the addition of thinner by 5 % and use a larger nozzle (up to 2 mm). When using it as adhesion promoter (coat thickness 20 - 25 µm), increase the mentioned data referring to thinner addition by 10% and use a smaller nozzle (1,3 - 1,5 mm).

##### gravity spray gun

20 - 30 s 4 mm DIN

##### Airmix/Airless

50 - 60 s 4 mm DIN



#### Application mode

##### application mode

gravity spray gun/  
HVLP

Airmix / Airless  
compound pressure

##### hardener

–

–

##### pressure (bar)

2,0 - 2,5

1,0 - 2,0  
100 - 120

##### nozzle (mm)

1,5 - 1,8

0,28 - 0,33

##### spray passes

2 - 3

1 - 2

##### dilution

15 %

5 %



#### Drying time

##### hardener

–

–

##### object temperature

20 °C

60 °C

##### dust dry

25 - 30 min

–

##### set to touch

50 - 60 min

–

##### ready for assembly

5 - 6 h

30 min

##### sandable

–

–

##### recoatable

50 - 60 min

30 min

Coat thickness of more than 60 µm extent the drying time.

### Note

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|                         |                                           |                             |
|-------------------------|-------------------------------------------|-----------------------------|
| <b>Characteristics:</b> | binder base:                              | polyurethane acrylic system |
|                         | solids content (% by weight):             | ~ 66                        |
|                         | solids content (% by volume):             | ~ 47                        |
|                         | delivery viscosity DIN 53211 4 mm (in s): | 170 - 190                   |
|                         | density DIN EN ISO 2811 (kg/l):           | ~ 1,4                       |
|                         | gloss level ISO 2813 at 60° (GU):         | 10 - 20 matt                |

|                    |                                                   |
|--------------------|---------------------------------------------------|
| <b>Properties:</b> | short drying time                                 |
|                    | excellent filling properties                      |
|                    | electrostatic application possible                |
|                    | active corrosion protection (zinc-phosphate)      |
|                    | heat resistance:                                  |
|                    | - short-term heat exposure: 180 °C                |
|                    | - permanent heat exposure: 150 °C                 |
|                    | adhesion to steel, zined substrates and aluminium |

|                                     |                                                                                        |
|-------------------------------------|----------------------------------------------------------------------------------------|
| <b>Theoretical spreading rate :</b> | ~ 36,0 m <sup>2</sup> /kg, 10:1 by weight with PU 900-25, for 10 µm dry film thickness |
|                                     | ~ 44,3 m <sup>2</sup> /l, 10:1 by weight with PU 900-25, for 10 µm dry film thickness  |

|                 |                                                                                                                                                                                                                     |
|-----------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Storage:</b> | 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. |
|-----------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

|             |             |
|-------------|-------------|
| <b>VOC:</b> | < 450 g/l.* |
|-------------|-------------|

|                               |                                                                                 |
|-------------------------------|---------------------------------------------------------------------------------|
| <b>Processing conditions:</b> | From + 10 °C and up to 80 % relative humidity. Ensure adequate air ventilation. |
|-------------------------------|---------------------------------------------------------------------------------|

|                               |                                                                                                                                                                                                                           |
|-------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Substrate preparation:</b> | 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

#### zined 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

**Proposed coating structure:** steel, zincd substrates:  
priming coat: PU 100-20 with 40 - 50 µm dry film thickness  
finishing coat: \*\*PU 200-XX / PU 240-XX with 50 - 60 µm dry film thickness

steel, zincd substrates (to comply with a higher corrosivity categorie):  
priming coat: PU 100-20 with 80 - 100 µm dry film thickness  
finishing coat: \*\*PU 200-XX / PU 240-XX with 50 - 60 µm dry film thickness

aluminium:  
priming coat: PU 100-20 with 20 - 25 µm dry film thickness  
finishing coat: \*\*PU 200-XX / PU 240-XX with 50 - 60 µm dry film thickness

### Special notes:

\*This product contains the following maximum values:  
- Applied by spraying with 2K-Härter PU 900-25 / PU 912-XX: < 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.

When using this product as adhesion promoter on hard aluminium, observe dry film thickness of 20 - 25 µm.

Recoatable at the earliest after 30 min at 60 °C or 50 min at 20 °C and at the latest after 4 weeks. After drying for more than 4 weeks, intermediate sanding is required.

If required we also offer hardeners and 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 Nitroverdünnung.