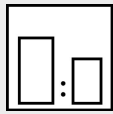



Intended use

Fast-drying, highly weather-resistant and heavy-duty synthetic paint to coat commercial vehicles, machines and constructions. For interior and exterior use.


Processing instructions


	Mixing ratio		
	hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
	--	--	--


	Hardener
	--

	Pot life
	2 days with Mipa Härterverdünnung

	Thinner
	Mipa UN-Verdünnung
	Mipa Verdünnung UN 21
	Mipa Härterverdünnung

	Spray viscosity	
	gravity spray gun	Airmix/Airless
	20 - 25 s 4 mm DIN	40 - 50 s 4 mm DIN

	Application mode					
	application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
	gravity spray gun / HVLP	--	2,0 - 2,5	1,2 - 1,3	2 - 3	10 - 20 %
	Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,23 - 0,28	1,5 - 2	5 - 10 %

	Drying time						
	hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
	--	20 °C	40 - 45 min	6 - 8 h	24 h	--	--
	--	60 °C	--	--	1 h	--	--

Fully cured after 6 - 7 days (at 20 °C).

Note

Characteristics:	binder base:	modified alkyd resin
	solids content (% by weight):	50 - 56
	solids content (% by volume):	39 - 41
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	1,0 - 1,2
	gloss level ISO 2813 at 60° (GU):	> 80 glossy

Properties:	short drying time highly resistant to UV and weathering high vertical stability excellent flow, high final hardness, retains the gloss over time resistant to petrol and diesel if exposed temporarily short-term heat exposure 150 °C permanent heat exposure 130 °C
Theoretical spreading rate :	33,2 - 40,5 m ² /kg for 10 µm dry film thickness 39,5 - 41,4 m ² /l 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 Regulation :	This product contains the following maximum VOC-values: undiluted: < 520 g/l of VOC
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
Proposed coating structure:	steel: priming coat: *AK 100-20 / AK 105-20 with 50 - 60 µm dry film thickness finishing coat: AK 240-90 with 50 - 60 µm dry film thickness
Special notes:	*Further Mipa primers are available. Please contact your technical adviser or our application technicians. For professional use only. Applying too thick layers may extend considerably the drying time. Depending on the colour, the delivery viscosity may vary. Adjust the viscosity by adding thinner. Check colour shade prior to application.
Cleaning of tools:	Clean tools immediately after use with Mipa Nitroverdünnung.