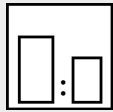



### Intended use


This oxidation-curing high-build black mica paint with high corrosion protection is suitable to apply thick coatings on steel constructions, cast parts, containers, machines, chassis, switchboards and so on which are made of steel, zinc steel and aluminium. Also suitable for wood substrates. For interior and exterior use. Low solvent content.


### Processing instructions


	<b>Mixing ratio</b>		
	<b>hardener</b>	<b>by weight (lacquer : hardener)</b>	<b>by volume (lacquer : hardener)</b>
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	<b>Hardener</b>	--
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	<b>Pot life</b>	--
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	<b>Thinner</b>	Mipa 2K-Verdünnung
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	<b>Spray viscosity</b>	
	<b>gravity spray gun</b>	<b>Airmix/Airless</b>
	20 - 30 s 4 mm DIN	50 - 60 s 4 mm DIN

	<b>Application mode</b>					
	<b>application mode</b>	<b>hardener</b>	<b>pressure (bar)</b>	<b>nozzle (mm)</b>	<b>spray passes</b>	<b>dilution</b>
	gravity spray gun/ HVLP	--	2,0 - 2,5	1,8 - 2,0	2	20 - 25 %
	Airmix / Airless	--	100 - 120	0,33 - 0,54	1	10 - 15 %
	brush, roller	--	--	--	--	0 - 5 %

	<b>Drying time</b>						
	<b>hardener</b>	<b>object temperature</b>	<b>dust dry</b>	<b>set to touch</b>	<b>ready for assembly</b>	<b>sandable</b>	<b>recoatable</b>
	--	20 °C	60 - 70 min	6 - 8 h	24 h	--	24 h
	--	60 °C	--	--	60 min	--	--

Fully cured after 6 - 7 days (20 °C).

### Note

<b>Characteristics:</b>	binder base:	binder based on modified synthetic resins
	solids content (% by weight):	78 - 80
	solids content (% by volume):	60 - 63
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	1,6 - 1,7
	gloss level ISO 2813 at 60° (GU):	Matt*

Version: en 2/0421

This technical data sheet is supplied for informational purposes only! According to our information, all data and recommendations correspond to the state of art and are based on years of experience in manufacturing our products. They do not exempt the user from his obligation to verify professionally, on his own responsibility, the suitability of our products to the intended purpose under prevailing conditions. Safety data sheets and warnings on packaging must be observed. We reserve the right to modify and to complete the information content at any time, without prior notice or obligation to update.

<b>Properties:</b>	highly UV- and weather-resistant high corrosion protection due to barrier effect resistant to fuels and diesel if exposed temporarily heat resistance: - short-term heat exposure: 160°C - permanent heat exposure: 120°C adhesion on steel, zincd substrates and aluminium
<b>Theoretical spreading rate :</b>	38,2 - 40,5 m <sup>2</sup> /kg for 10 µm dry film thickness 60,2 - 62,8 m <sup>2</sup> /l 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 Regulation :</b>	EU limit value according to Directive 2004/42/EC for this product (category A/i): 500 g/l This product contains the following maximum VOC-values: applied by brush/ roller: < 500 g/l of VOC
<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  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

**Proposed coating structure:** single coat system  
steel, zincd substrates, aluminium:  
AK 555-20 with 60 - 80 µm dry film thickness

2-coat system  
steel:  
priming coat: \*\*AK 100-20 / AK 105-20 with 50 - 60 µm dry film thickness  
or for especially high corrosion protection Mipa Zinkalyd (50 - 60 µm)  
finishing coat: AK 555-20 with 60 - 80 µm dry film thickness

zincd substrates:  
priming coat: \*\*EP 100-20 with 50 - 70 µm dry film thickness  
finishing coat: AK 555-20 with 60 - 80 µm dry film thickness

aluminium:  
priming coat: \*\*EP 100-20 with 25 - 30 µm dry film thickness  
finishing coat: AK 555-20 with 60 - 80 µm dry film thickness

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

**Special notes:** \* due to the special surface, a measurement according to DIN EN ISO 2813 is inappropriate!

For professional use only.

Applying too thick layers may extend considerably the drying time.

Check colour before use.

In order to achieve optimum iron mica effects and to avoid strips, it is advisable to spray the finishing coat or to roll or paint in only one direction.

**Cleaning of tools:** Clean tools immediately after use with Mipa Nitroverdünnung.