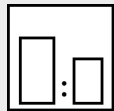


Intended use

Two-component zinc phosphate epoxy acrylic primer for coating steel, zincated substrates, aluminium, GRP and e-coatings. Its outstanding filling power and resistance to solvents and chemical agents make this product particularly suitable for high-quality coating of highly stressed installations and devices. Furthermore, this primer can be overcoated with Mipa 2K topcoats after a drying of only 20 minutes at room temperature.

Processing instructions



Mixing ratio

hardener

PU 914-XX

by weight (lacquer : hardener)

6 : 1

by volume (lacquer : hardener)

4 : 1



Hardener

Mipa PU 914-10, PU 914-25



Pot life

with Härter-10 approx. 2,5 - 3 h at 20°C



Thinner

Mipa 2K-Verdünnung



Spray viscosity

gravity spray gun

30 - 40 s 4 mm DIN

Airmix/Airless

50 - 60 s 4 mm DIN



Application mode

application mode

gravity spray gun/
HVL P

Airmix / Airless

hardener

–

pressure (bar)

2,0 - 2,5

100 - 120

nozzle (mm)

1,5 - 1,8

0,28 - 0,33

spray passes

2 - 3

1 - 2

dilution

10 - 20 %

< 10 %



Drying time

hardener

-10

-10

object temperature

20 °C

60 °C

dust dry

20 - 30 min

–

set to touch

60 - 90 min

–

ready for assembly

24 h

1 h

sandable

5 h

–

recoat able

20 min

–

Note

Characteristics:

binder base:

solids content (% by weight):

solids content (% by volume):

delivery viscosity DIN 53211 4 mm (in s):

density DIN EN ISO 2811 (kg/l):

gloss level ISO 2813 at 60° (GU):

epoxy acrylic resin

74 - 76

53 - 55

thixotropic

1,5 - 1,6

10 - 20 matt

Properties:	early recoatability excellent corrosion protection, contains zinc phosphate outstanding filling properties recoatable wet-on-wet very good spray mist absorption highly elastic film, good impact strength excellent resistance to solvents and chemical agents heat resistance: - short-term heat exposure: 180 °C - permanent heat exposure: 150 °C adhesion on steel, zincd substrates, aluminium, GRP, e-coatings
Theoretical spreading rate :	35,0 - 37,4 m ² /kg, 6:1 by weight with PU 914-10, for 10 µm dry film thickness 51,1 - 53,4 m ² /l, 6:1 by weight with PU 914-10, 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 Regulation :	EU limit value according to Directive 2004/42/EC for this product (category B/c): 540 g/l. This product has the following maximum VOC-values: applied by spraying with 2K-PU-Härter PU 914-XX: < 490 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 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 GRP: - clean (remove completely any mould release agents), if necessary, sand slightly and degrease with Mipa Silikonentferner e-coating: - clean, slightly sand and degrease with Mipa Silikonentferner

Proposed coating structure: steel, zincd substrates, e-coating, GRP:
priming coat: EA 100-20 with 70 - 110 µm dry film thickness
finishing coat: *PU 200-XX / PU 240-XX with 50 - 60 µm dry film thickness

aluminium:
priming coat: EA 100-20 with 40 - 60 µm dry film thickness
finishing coat: *PU 200-XX / PU 240-XX with 50 - 60 µm dry film thickness

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

Special notes: For professional use only.

Recoatable at the earliest after 20 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 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.