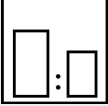








Intended use

Inorganic ethyl silicate zinc-rich coating according to DIN EN ISO 12944. Thanks to its extreme resistance to salt spray and to condensation water, the product can be used either as anti-corrosion coating without subsequent topcoat or as anti-corrosion primer with suitable top coating. The product can be used as welding primer provided that the dry film thickness is less than 20 µm.

Processing instructions

	Mixing ratio hardener	by weight (lacquer : hardener)		by volume (lacquer : hardener)				
	--	--		--				
	Hardener	--						
	Pot life	--						
	Thinner Mipa Verdünnung ESI							
	Processing viscosity gravity spray gun	18 - 22 s 4 mm DIN		Airmix/Airless 20 - 25 s 4 mm DIN				
	Application mode	application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution	
	gravity spray gun / HVLP	--	--	2,0 - 3,0	1,5	--	3 - 10 %	
	Airmix / Airless compound pressure	--	--	1,0 - 2,0 120 - 250	0,33 - 0,58	--	0 - 5 %	
	by brush, roller (only recommended for small areas)	--	--	--	--	--	0 %	
	Drying time	hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
	--	--	20°C (rel. humidity)	5 - 15 min	--	--	--	with itself after 2 - 3 h, otherwise after 24 h
	--	--	60 °C	--	--	--	--	with itself after 30 min

Recoatable after 24 hours. Rain-resistant after 30 minutes at 20 °C. Fully cured after 3 - 4 days.

Note

Characteristics:	binder base: ethyl silicate solids content (% by weight): ~ 88 solids content (% by volume): ~ 59 delivery viscosity DIN 53211 4 mm (in s): 20 - 25 density DIN EN ISO 2811 (kg/l): ~ 2,9 gloss level ISO 2813 at 60° (GU): < 10 matt
Properties:	short drying time high filling power salt spray test, 70 µm coating thickness: more than 1000 hours condensation water test, 70 µm coating thickness: more than 1000 hours easy to apply sliding friction coefficient μ according to DIN 51131 (friction coefficient) = 0,5 heat-resistant up to 450 °C adhesion on blasted steel
Theoretical spreading rate:	~ 24,7 m ² /kg for 10 µm dry film thickness ~ 60,2 m ² /l for 10 µm dry film thickness
Storage:	For at least 1 year 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:	< 360 g/l.
Processing conditions:	1K-ESI-Zinkstaubprimer requires humidity for curing. Perfect processing conditions are between 50 - 98 % relative humidity. At a humidity of less than 50 % the curing slows down considerably. In these cases provide air humidification or spray water on the surface only when the surface is dust dry. Application temperature - 5 up to + 50 °C. During the application, the surface temperature of the parts to be coated must be kept at least 3 °C above the dew point of air (DIN EN ISO 12944-7).
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 as per DIN EN ISO 12944-4, roughness degree: medium (G) as per DIN EN ISO 8503-1
Proposed coating structure:	3-coat-system (example: corrosivity category C4 High according to DIN EN ISO 12944); steel: priming coat: 1K-ESI-Zinkstaubprimer with 60 µm dry film thickness intermediate coat: EP 100-20 with 80 µm dry film thickness finishing coat: PU 240-XX with 60 µm dry film thickness

Special notes:

To get more information about recommended coating structures according to corrosivity categories as per DIN EN ISO 12944 please contact us or have a look at the brochure "Mipa Corrosion protection"!

For professional use only.

Attention: Before applying any further top coating ensure that the applied product is completely cured otherwise it is largely cut off from the humidity that is essential for curing.

Avoid coat thicknesses of more than 80 µm per layer since otherwise there is a risk of cracking.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.