Mipa 2K-Acryl-Epoxygrund

Technical data sheet

Intended use

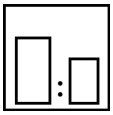
Mipa 2K-Acryl-Epoxygrund is a fast drying priming coat with good filling properties and active corrosion protection for coating steel, galvanised steel, aluminium, GRP and e-coatings. The excellent filling properties and the outstanding applicability on large surfaces render the Mipa 2K-Acryl-Epoxygrund perfect for applications in the commercial vehicle sector. Furthermore, it is fast overcoatable wet on wet with all common Mipa 1K or 2K topcoats after only 20 minutes drying at room temperature.

Spreading rate: 7,0 - 8,0 m²/l (for 70 µm DFT)

Processing instructions

Colour

approx. RAL 7035



Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
Mipa 2K-HS-Härter HS 10	6 : 1	4 : 1

Hardener

for complete paintwork	for partial paintwork
--	--

Pot life

1,5 h with Mipa 2K-HS-Härter HS 10 at 20 °C

Thinner

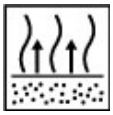
Mipa 2K-Verdünnung V 25

Spray viscosity

gravity spray gun	Airmix/Airless
18 - 22 s 4 mm DIN	40 - 50 s 4 mm DIN

Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
gravity spray gun (high pressure)	--	2,0 - 2,5	1,5 - 1,8	2 - 3	10 - 20 %
HVLP (low pressure)	--	2,0 - 2,5	1,5 - 1,8	2 - 3	10 - 20 %
HVLP / internal nozzle pressure	--	0,7	--	--	--
Airmix / Airless	--	100 - 120	0,28 - 0,33	1 - 2	< 10 %



Flash-off time

5 - 8 min between coats

10 - 15 min prior to oven drying

MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49(0)8703/922-0 · Fax: +49(0)8703/922-100 · mipa@mipa-paints.com · www.mipa-paints.com

Dry coat thickness
40 - 110 µm, depending on application

Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	20 - 30 min	60 - 90 min	24 h	5 h	20 min
60 °C	--	--	1 h	--	--

Note

Storage: at least 3 years in unopened original container

VOC Regulation : EU limit value for this product (category B/c): 540 g/l
This product contains max. 470 g/l of VOC.

Processing conditions: From +10 °C and up to 80 % relative air humidity. Ensure an adequate air ventilation.

MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49(0)8703/922-0 · Fax: +49(0)8703/922-100 · mipa@mipa-paints.com · www.mipa-paints.com

Processing instructions:

Substrate pre-treatment:

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

zinced 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, sand slightly and degrease with Mipa Silikonentferner

Coating structure (recommendation):

steel, zinced substrates, e-coating, GRP:

priming coat: Mipa 2K-Acryl-Epoxygrund with 70 - 110 µm dry film thickness
finishing coat: Mipa PUR HS with 50 - 60 µm dry film thickness

Aluminium:

priming coat: Mipa 2K-Acryl-Epoxygrund with 40 - 60 µm dry film thickness
finishing coat: Mipa PUR HS with 50 - 60 µm dry film thickness

Special notes:

Recoatable wet on wet at the earliest after 20 minutes and at latest after 24 hours. After a drying of more than 24 hours, intermediate sanding is necessary.

For professional use only.

If required we also offer hardeners and cleaning agents that are suitable for 2-component mixing and dosing units.

MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49(0)8703/922-0 · Fax: +49(0)8703/922-100 · mipa@mipa-paints.com · www.mipa-paints.com