## AK 233-60 Synthetic Single-layer Topcoat HS satin gloss Technical data sheet Page 1 / 3



## Intended use

This low-solvent, oxidation-curing high-build one-layer paint with active protection against corrosion is suitable for coatings on steel constructions, cast parts, containers, machines, chassis, switchboards and so on which are made of steel, zinced steel and aluminium. Due to its special formulation, the product can already be exposed to moisture after drying for approx. 30 minutes at 20 °C.

## Processing instructions

	Mixing ratio hardener 		by weight (lacquer : hardener) 				dener) b 	by volume (lacquer : hardener) 			
A	Hardener 										
	Pot life 2 days with Härterverdünnung										
	<b>Thinner</b> Mipa UN-Verc Mipa Verdünn Mipa Härterve	iung UN 2									
∏s	Processing viscosity gravity spray gun thixotropic				<b>Airmix/Airless</b> thixotropic						
	Application I application n		harden	er	pre (ba	ssure r)	no	zzle (mm)	spray passes		dilution
	gravity spray ( HVLP	gun/			2,0	- 2,5	1,7	7 - 2,5	2 - 3		10 - 15 %
	Airmix / Airless compound pressure				1,0 - 2,0 100 - 120		0,3	86 - 0,54	1		0 - 10 %
	paint brush, ro	oller									0 - 10 %
$\bigcirc$	Drying time hardener	object tempera		st dry		set to touch		eady for ssembly	sand	able	recoatable
		20 °C	30	- 40 min		ca. 5 h		2 h			
		60 °C					1	h			

Fully cured after 8 - 10 days (20 °C).

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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):	modified alkyd resins ~ 75 ~ 56 thixotropic ~ 1,5 60 - 70 satin gloss					
Properties:	highly UV- and weather-resistant after only 30 min/20 °C resistant to moisture heat resistance: - short-term heat exposure: 150 °C - permanent heat exposure: 130 °C adhesion to steel, zinced substrates and aluminium						
Theoretical spreading rate :	<ul> <li>~ 38,8 m<sup>2</sup>/kg for 10 μm dry film thickness</li> <li>~ 56,5 m<sup>2</sup>/l for 10 μm dry film thickness</li> </ul>						
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:	< 380 g/l.						
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 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						

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Proposed coating structure:	single coat system steel, zinced substrates, aluminium AK 233-60 with 60 - 80 µm dry film thickness					
	2-coat system steel: priming coat: *AK 105-20 with 50 - 60 μm dry film thickness finishing coat: AK 233-60 with 60 - 80 μm dry film thickness					
	zinced substrates: priming coat:: *EP 100-20 with 50 - 60 μm dry film thickness finishing coat: AK 233-60 with 60 - 80 μm dry film thickness					
	aluminium: priming coat:: *EP 100-20 with 25 - 30 μm dry film thickness finishing coat: AK 233-60 with 60 - 80 μm dry film thickness					
Special notes:	*Further Mipa primers are available. Please contact your technical adviser or our application technicians.					
	For professional use only.					
	The details of the paragraphs - Proposed coating structure, Characteristics, Theoretical spreading rate, VOC - refer to the colour shade RAL 7035. For other colour shades, these may deviate.					
	Applying too thick layers may extend considerably the drying time.					
	Check colour shade prior to application.					
Cleaning of tools:	Clean tools immediately after use with Mipa Nitroverdünnung.					

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