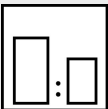



### Intended use


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, zinc 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


	<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>	2 days with Härterverdünnung
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	<b>Thinner</b>	Mipa UN-Verdünnung Mipa Verdünnung UN 21 Mipa Härterverdünnung
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	<b>Processing viscosity</b>	
	<b>gravity spray gun</b>	<b>Airmix/Airless</b>
	thixotropic	thixotropic

	<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	1,7 - 2,5	2 - 3	10 - 15 %
	Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,36 - 0,54	1	0 - 10 %
	paint brush, roller	--	--	--	--	0 - 10 %

	<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	30 - 40 min	ca. 5 h	12 h	--	--
	--	60 °C	--	--	1 h	--	--

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

### Note

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<b>Characteristics:</b>	binder base:	modified alkyd resins
	solids content (% by weight):	~ 75
	solids content (% by volume):	~ 56
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	~ 1,5
	gloss level ISO 2813 at 60° (GU):	60 - 70 satin gloss
<b>Properties:</b>	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, zined substrates and aluminium	
<b>Theoretical spreading rate :</b>	~ 38,8 m <sup>2</sup> /kg for 10 µm dry film thickness	
	~ 56,5 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:</b>	< 380 g/l.	
<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	
	zined 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 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

zincd 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.