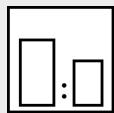


Intended use

Fast-drying, highly weather-resistant and heavy-duty synthetic paint to coat commercial vehicles, machines and constructions. For interior and exterior use.

Processing instructions



Mixing ratio

hardener

by weight (lacquer : hardener)

by volume (lacquer : hardener)

—

—

—



Hardener

—



Pot life

2 days with Mipa Härterverdünnung



Thinner

Mipa UN-Verdünnung

Mipa Verdünnung UN 21

Mipa Härterverdünnung



Processing viscosity

gravity spray gun

Airmix/Airless

20 - 25 s 4 mm DIN

40 - 50 s 4 mm DIN



Application mode

application mode

hardener

pressure
(bar)

nozzle
(mm)

spray
passes

dilution

gravity spray gun /
HVL

—

2,0 - 2,5

1,2 - 1,3

2 - 3

10 - 20 %

Airmix / Airless
compound pressure

—

1,0 - 2,0
100 - 120

0,23 - 0,28

1,5 - 2

5 - 10 %



Drying time

hardener

object
temperature

dust dry

set to
touch

ready for
assembly

sandable

recoatable

—

20 °C

40 - 45 min

6 - 8 h

24 h

—

—

—

60 °C

—

—

1 h

—

—

Fully cured after 6 - 7 days (at 20 °C).

Note

Characteristics:

binder base:

modified alkyd resin

solids content (% by weight):

~ 56

solids content (% by volume):

~ 41

delivery viscosity DIN 53211 4 mm (in s):

thixotropic

density DIN EN ISO 2811 (kg/l):

~ 1,2

gloss level ISO 2813 at 60° (GU):

> 80 glossy

Properties:	Short drying time Highly resistant to UV and weathering High vertical stability Excellent flow, high final hardness, retains the gloss over time Resistant to petrol and diesel if exposed temporarily Short-term heat exposure 150 °C Permanent heat exposure 130 °C
Theoretical spreading rate:	~ 40,5 m ² /kg for 10 µm dry film thickness. ~ 41,4 m ² /l 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:	< 470 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 of metals, alloys, metallic and conversion coatings and so on. The adhesion must therefore be tested on the original 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.
Proposed coating structure:	Steel: Priming coat: *AK 100-20 / AK 105-20 with 50 - 60 µm dry film thickness. Finishing coat: AK 240-90 with 50 - 60 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. When alkyd resin (based) products are stored, a skin can form on the surface of the paint due to the system. This generally has no negative effects on the quality (material testing is recommended!). If a skin has formed, it must be carefully removed before stirring (before tinting for bases) and the product must be sieved as required before application. Applying too thick layers may extend considerably the drying time. Depending on the colour, the delivery viscosity may vary. Adjust the viscosity by adding thinner. Check colour shade prior to application.
Cleaning of tools:	Clean tools immediately after use with Mipa Nitroverdünnung.