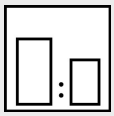
AK 555-20 Synthetic HS Mica Topcoat matt

Intended use

This oxidation-curing high-build black mica paint with high corrosion protection is suitable to apply thick coatings on steel constructions, cast parts, containers, machines, chassis, switchboards and so on which are made of steel, zinced steel and aluminium. Also suitable for wood substrates. For interior and exterior use. Low solvent content.

Processing instructions



Mixing ratio

hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
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Hardener

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Pot life

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Thinner

Mipa 2K-Verdünnung V 10, V 25, V 40

Processing viscosity

gravity spray gun	Airmix/Airless
20 - 30 s 4 mm DIN	50 - 60 s 4 mm DIN

Application mode

application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
gravity spray gun/ HVLP	--	2,0 - 2,5	1,8 - 2,0	2	20 - 25 %
Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,33 - 0,54	1	10 - 15 %
brush, roller	--	--	--	--	0 - 5 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	60 - 70 min	6 - 8 h	24 h	--	24 h
--	60 °C	--	--	60 min	--	--

Fully cured after 6 - 7 days (20 °C).

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Note

Characteristics:	binder base:	binder based on modified synthetic resins
	solids content (% by weight):	~ 80
	solids content (% by volume):	~ 63
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	~ 1,7
	gloss level ISO 2813 at 60° (GU):	Matt*

Properties:

highly UV- and weather-resistant
high corrosion protection due to barrier effect
resistant to fuels and diesel if exposed temporarily
heat resistance:
- short-term heat exposure: 160°C
- permanent heat exposure: 120°C

adhesion on steel, zinced substrates and aluminium

Theoretical spreading rate :

~ 40,5 m²/kg for 10 µm dry film thickness
~ 62,8 m²/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:

< 330 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 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 555-20 with 60 - 80 µm dry film thickness

2-coat system
steel:
priming coat: ***AK 100-20 / AK 105-20 with 50 - 60 µm dry film thickness
or for especially high corrosion protection Mipa Zinkalyd (50 - 60 µm)
finishing coat: AK 555-20 with 60 - 80 µm dry film thickness

zinced substrates:
priming coat: ***EP 100-20 with 50 - 70 µm dry film thickness
finishing coat: AK 555-20 with 60 - 80 µm dry film thickness

aluminium:
priming coat: ***EP 100-20 with 25 - 30 µm dry film thickness
finishing coat: AK 555-20 with 60 - 80 µm dry film thickness

Special notes:

*Due to the special surface, a measurement according to DIN EN ISO 2813 is inappropriate!

**This product contains the following maximum VOC-values:
- Applied by brush/ roller: < 500 g/l of VOC.

***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 before use.

In order to achieve optimum iron mica effects and to avoid strips, it is advisable to spray the finishing coat or to roll or paint in only one direction.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.

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