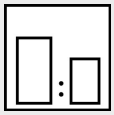
AY 210-10 1K Acrylic Topcoat matt

Intended use

Fast drying, matt 1K acrylic paint for complete and partial coatings on vehicles and machines. Perfectly suitable to be filled into aerosol spray cans.

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 Verdünnung UN 21

Processing viscosity

gravity spray gun	Airmix/Airless
18 - 20 s 4 mm DIN	--

Application mode

application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
gravity spray gun/ HVLP	--	2,0 - 2,5	1,2 - 1,3	2 - 4	25 - 30 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	10 - 15 min	20 - 25 min	1 - 2 h	--	15 min
--	60 °C	--	--	30 min	--	--

Fully cured after 2 days (20 °C) .

Note

Characteristics:

binder base:	acrylic copolymer
solids content (% by weight):	~ 54
solids content (% by volume):	~ 38
delivery viscosity DIN 53211 4 mm (in s):	125 - 135
density DIN EN ISO 2811 (kg/l):	~ 1,2
gloss level ISO 2813 at 60° (GU):	10 - 20 matt

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Properties:

Electrostatic application is possible
Short drying time
Highly UV- and weather-resistant
Heat resistance:
- Short-term heat exposure: 130 °C
- Permanent heat exposure: 70 °C

Adhesion on unplasticised PVC

Theoretical spreading rate:

~ 37,2 m²/kg for 10 µm dry film thickness.
~ 38,7 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:

< 490 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.

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.

Unplasticised PVC:
- Clean (remove completely any mould release agents), degrease with Mipa Kunststoffreiniger, sand slightly and degrease again with Mipa Kunststoffreiniger.

1K old paintworks:
- Remove completely (sanding, paint remover).

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Proposed coating structure:

Steel:
Priming coat: *AK 105-20 / AK 100-20 / VB 100-20 with 50 - 60 µm dry film thickness.
Finishing coat: AY 210-10 with 30 - 40 µm dry film thickness.

Zinced substrates:
Priming coat: *VB 100-20 with 50 - 60 µm dry film thickness.
Finishing coat: AY 210-10 with 30 - 40 µm dry film thickness.

Aluminium:
Priming coat: *VB 100-20 with 25 - 30 µm dry film thickness.
Finishing coat: AY 210-10 with 30 - 40 µm dry film thickness.

Unplasticised PVC:
AY 210-10 with 40 - 50 µm dry film thickness.

Special notes:

*Further Mipa primers are available. Please contact your technical adviser or our application technicians.

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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.

Especially UV-resistant pigmentations are available on demand.

Furthermore it's possible to mix it with neon colours which can be applied then as single-layer. Please see the technical data sheet "Mipa Neon-Farbtöne PMI singlelayer paints".

In case of ambient temperatures higher than 25 °C it's necessary to add 70 % of Mipa Verdünnung UN 21 (to avoid cobwebbing).

Check colour before use.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.

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