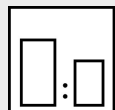


Intended use

Fast drying, semi-gloss 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)

—



Hardener

—



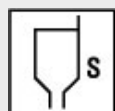
Pot life

—



Thinner

Mipa Verdünnung UN 21



Processing viscosity

gravity spray gun

18 - 20 s 4 mm DIN

Airmix/Airless

—



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):

~ 53

solids content (% by volume):

~ 37

delivery viscosity DIN 53211 4 mm (in s):

130 - 150

density DIN EN ISO 2811 (kg/l):

~ 1,2

gloss level ISO 2813 at 60° (GU):

50 - 60 semi-gloss

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:	~ 36,1 m ² /kg for 10 µm dry film thickness. ~ 37,3 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:	< 505 g/l.
Processing conditions:	From + 10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.
Substrate preparation:	<p>Remove oil, grease, rust, mill scale, rolling skins, as well as other substances impairing the function of the coating!</p> <p>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.</p> <p>Steel:</p> <ul style="list-style-type: none">- 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. <p>Zincd substrates:</p> <ul style="list-style-type: none">- Clean the surface with the ammonia solution Mipa Zinkreiniger.- Sweep blast. <p>Aluminium:</p> <ul style="list-style-type: none">- Degrease with Mipa 2K-Verdünnung, sand thoroughly with sandpaper P 360/400 and clean subsequently with Mipa Silikonentferner. <p>Unplasticised PVC:</p> <ul style="list-style-type: none">- Clean (remove completely any mould release agents), degrease with Mipa Kunststoffreiniger, sand slightly and degrease again with Mipa Kunststoffreiniger. <p>1K old paintworks:</p> <ul style="list-style-type: none">- Remove completely (sanding, paint remover).

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 210-50 with 30 - 40 µm dry film thickness.

Zincd substrates:

Priming coat:: *VB 100-20 with 50 - 60 µm dry film thickness.

Finishing coat: AY 210-50 with 30 - 40 µm dry film thickness.

Aluminium:

Priming coat:: *VB 100-20 with 25 - 30 µm dry film thickness.

Finishing coat: AY 210-50 with 30 - 40 µm dry film thickness.

Unplasticised PVC:

AY 210-50 with 40 - 50 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.

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.