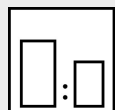


### Intended use

Thixotropic, high-build monolayer paint to coat constructions (halls, pipes, doors, wall and ceiling panels, roofs, recipients, container, vehicle constructions) made of steel, zinc steel and aluminium. Suitable for brush, roller and spray application. For interior and exterior use.

### 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

20 - 25 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

1,3 - 1,5

2 - 3

10 - 15 %

Airmix / Airless  
compound pressure

--

1,0 - 2,0  
100 - 120

0,28 - 0,33

1

0 - 10 %

paint brush, roller

--

--

--

--

0 - 10 %



#### Drying time

hardener

object  
temperature

dust dry

set to  
touch

ready for  
assembly

sandable

recoat able

--

20 °C

20 min

2 h

24 h

--

--

--

60 °C

--

--

1 h

--

--

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

**Note**

<b>Characteristics:</b>	binder base:	acrylic resin
	solids content (% by weight):	~ 68
	solids content (% by volume):	~ 48
	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):	20 - 40 satin matt
<b>Properties:</b>	good edge coverage	
	electrostatic application possible	
	non-blocking	
	heat resistance:	
	- short-term heat exposure: 150 °C	
	- permanent heat exposure: 120 °C	
	adhesion on steel, zincd substrates	
	adhesion on aluminium Gt 0-1	
<b>Theoretical spreading rate :</b>	~ 37,5 m²/kg for 10 µm dry film thickness	
	~ 48,9 m²/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>	< 430 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	
	zincd 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	

Version: en 5/0723

This technical data sheet is supplied for informational purposes only! According to our information, all data and recommendations correspond to the state of art and are based on years of experience in manufacturing our products. They do not exempt the user from his obligation to verify professionally, on his own responsibility, the suitability of our products to the intended purpose under prevailing conditions. Safety data sheets and warnings on packaging must be observed. We reserve the right to modify and to complete the information content at any time, without prior notice or obligation to update.

MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49 8703 92 20 · Fax: +49 8703 92 21 00 · mipa@mipa-paints.com · www.mipa-paints.com

**Proposed coating structure:** single coat system  
steel, zinc coated substrates, aluminium:  
AY 250-30 with 70 - 90 µm dry film thickness

2-coat system  
steel, zinc coated substrates:  
priming coat: \*VB 100-20 / EP 100-20 with 50 - 60 µm dry film thickness  
finishing coat: AY 250-30 with 50 - 70 µm dry film thickness

aluminium:  
priming coat: \*VB 100-20 / EP 100-20 with 25 - 30 µm dry film thickness  
finishing coat: AY 250-30 with 50 - 70 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.

Check colour prior to application.

**Cleaning of tools:** Clean tools immediately after use with Mipa Nitroverdünnung.