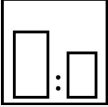








### Intended use

Fast drying nitro combination lacquer to coat metal (machines, tools, constructions) for interior and exterior use and wood (furniture, wooden parts) for interior use.

### Processing instructions

	<b>Mixing ratio</b>						
	<b>hardener</b>		<b>by weight (lacquer : hardener)</b>	<b>by volume (lacquer : hardener)</b>			
	--		--	--			
	<b>Hardener</b>						
	--						
	<b>Pot life</b>						
	--						
	<b>Thinner</b>						
	Mipa UN-Verdünnung						
	Mipa Verdünnung UN 21						
	<b>Processing viscosity</b>						
	<b>gravity spray gun</b>		<b>Airmix/Airless</b>				
	20 - 25 s 4 mm DIN		30 - 40 s 4 mm DIN				
	<b>Application mode</b>						
	<b>application mode</b>	<b>hardener</b>	<b>pressure (bar)</b>	<b>nozzle (mm)</b>	<b>spray passes</b>	<b>dilution</b>	
	gravity spray gun / HVLP	--	2,0 - 2,5	1,2 - 1,3	2 - 3	40 - 50 %	
	Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,23 - 0,28	1	15 - 20 %	
	<b>Drying time</b>						
	<b>hardener</b>	<b>object temperature</b>	<b>dust dry</b>	<b>set to touch</b>	<b>ready for assembly</b>	<b>sandable</b>	<b>recoatable</b>
	--	20 °C	5 - 10 min	15 - 20 min	1 h	--	--
	--	60 °C	--	--	15 min	--	--

Fully cured after 2 - 3 days (at 20 °C).

### Note

<b>Characteristics:</b>	binder base:	nitro acrylic combination
	solids content (% by weight):	~ 36
	solids content (% by volume):	~ 23
	delivery viscosity DIN 53211 4 mm (in s):	80 - 100
	density DIN EN ISO 2811 (kg/l):	~ 1,1
	gloss level ISO 2813 at 60° (GU):	> 80 gloss

- Properties:** very fast drying  
highly UV- and weather-resistant  
high hardness, sandable and polishable after a short time  
heat resistance:  
- short-term heat exposure: 150 °C  
- permanent heat exposure: 120 °C
- Theoretical spreading rate :** ~ 23,5 m<sup>2</sup>/kg for 10 µm dry film thickness  
~ 23,5 m<sup>2</sup>/l for 10 µm dry film thickness
- Storage:** For at least 1 year 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:** < 640 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
- wood (wood moisture: max. 15 %):  
- pre-sand with grit P 180 - P 280 and remove dust thoroughly
- Proposed coating structure:** steel:  
priming coat: \*AK 100-20 / AK 105-20 with 50 - 60 µm dry film thickness  
finishing coat: CN 200-90 with 20 - 30 µm dry film thickness
- wood for interior use:  
priming coat: CN 200-90 with 10 - 15 µm dry film thickness  
finishing coat: CN 200-90 with 20 - 30 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.
- Applying too thick layers may extend considerably the drying time.
- Check colour before use.
- Cleaning of tools:** Clean tools immediately after use with Mipa Nitroverdünnung.