

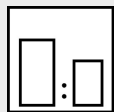
### Intended use

2K zinc phosphate epoxy primer for steel, zinc substrates, aluminium, GRP and mineral substrates. Suitable as priming coat even for both underwater and chemical protective coatings and as intermediate coating for EP zinc dust primers.

This product complies in combination with PU 250-XX with the requirements for fire behaviour of materials and components according to EN 45545-2:2013 + A1:2015.

In combination with Mipa PU 240-XX it can be used harmlessly to coat surfaces that are in direct contact with both dry and abrasive food (e.g. grain). (ISEGA certificate: 43517 U 16).

### Processing instructions



#### Mixing ratio

##### hardener

EP 950-XX

##### by weight (lacquer : hardener)

5 : 1

##### by volume (lacquer : hardener)

3 : 1



#### Hardener

Mipa EP 950-10, EP 950-25



#### Pot life

with hardener -10 ca. 7 - 8 h at 20 °C

with hardener -25 ca. 7 - 9 h at 20 °C



#### Thinner

Mipa EP-Verdünnung, Mipa EP-Verdünnung lang



#### Processing viscosity

##### gravity spray gun

20 - 30 s 4 mm DIN

##### Airmix/Airless

30 - 40 s 4 mm DIN



#### Application mode

##### application mode

gravity spray gun/  
HVLP

Airmix / Airless  
compound pressure

brush, roller

##### hardener

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##### pressure (bar)

2,0 - 2,5

1,0 - 2,0  
100 - 120

–

##### nozzle (mm)

1,5 - 1,8

0,28 - 0,33

–

##### spray passes

2 - 3

1 - 2

–

##### dilution

20 - 25 %

10 - 15 %

5 - 10 %



#### Drying time

##### hardener

–

–

##### object temperature

20 °C

60 °C

##### dust dry

45 - 55 min

–

##### set to touch

4 - 5 h

–

##### ready for assembly

10 - 12 h

45 min

##### sandable

–

–

##### recoatible

1 h

–

**Note**

<b>Characteristics:</b>	binder base: epoxy resin solids content (% by weight): ~ 68 solids content (% by volume): ~ 45 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 matt
<b>Properties:</b>	active protection against corrosion (zinc phosphate) electrostatic application possible excellent resistance to chemical and mechanical strains suitable to insulate thermoplastic substrates heat resistance: - short-term heat exposure: 180 °C - permanent heat exposure: 150 °C adhesion on steel, zincd substrates, aluminium and GRP
<b>Theoretical spreading rate :</b>	~ 36,8 m <sup>2</sup> /kg, 5:1 by weight with EP 950-25, for 10 µm dry film thickness ~ 48,0 m <sup>2</sup> /l, 5:1 by weight with EP 950-25, 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>	< 450 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  GRP: - clean (remove completely any mould release agents), sand slightly if necessary and degrease again with Mipa Silikonentferner

**Proposed coating structure:** steel, zincd substrates, GRP:  
priming coat: EP 100-20 with 50 - 70 µm dry film thickness  
finishing coat: \*\*PU 200-XX / PU 240-XX with 50 - 60 µm dry film thickness

aluminium:  
priming coat: EP 100-20 with 25 - 30 µm dry film thickness  
finishing coat: \*\*PU 200-XX / PU 240-XX with 50 - 60 µm dry film thickness

**Special notes:**

\*This product contains the following maximum VOC-values:  
- Applied by brush/ roller with 2K-EP-Härter EP 950-25: < 500 g/l of VOC.  
- Applied by spraying with 2K-EP-Härter EP 950-25: < 540 g/l of VOC.

\*\*Further Mipa topcoats 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.

Recoatable at the earliest after 60 min at 20 °C and at the latest after 14 days. After drying for more than 14 days, intermediate sanding is required.

If required we also offer cleaning agents that are suitable for 2-component mixing and dosing units. Please contact your technical adviser or our application technicians.

**Cleaning of tools:**

Clean tools immediately after use with Mipa EP-Verdünnung.