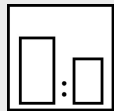


Intended use

This is a 2-component epoxy resin primer filler for steel, zinc substrates, aluminium and GRP. Its very good spray mist absorption, fast drying and the very good flow guarantee a fast overcoatability with perfect gloss retention. It can also be used as primer before filling work and as wet-on-wet filler. This makes the product particularly suitable for use in high-quality industrial and commercial vehicle construction.

Processing instructions



Mixing ratio

hardener

EP 905-05

by weight (lacquer : hardener)

3 : 1

by volume (lacquer : hardener)

2 : 1



Hardener

Mipa EP 905-05



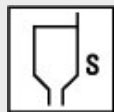
Pot life

with Härter -05 approx. 5 h at 20 °C



Thinner

Mipa 2K-Verdünnung V 10, V 25, V 40



Processing viscosity

gravity spray gun

20 - 25 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

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nozzle (mm)

1,2 - 1,5

0,28 - 0,33

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spray
passes

1 - 2

1 - 2

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dilution

10 - 25 %

5 - 10 %

5 - 10 %



Drying time

hardener

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object
temperature

20 °C

60 °C

dust dry

10 - 15 min

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set to
touch

3 - 4 h

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ready for
assembly

10 - 12 h

30 min

sandable

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recoatable

30 - 45 min

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Note

Characteristics:	binder base: Epoxy polyamide combination solids content (% by weight): ~ 70 solids content (% by volume): ~ 51 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 - 30 matt
Properties:	active corrosion protection (zinc phosphate) electrostatic application possible very good flow and very good spray mist absorption 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 to steel, zined substrates, aluminium and GRP.
Theoretical spreading rate :	~ 36,4 m ² /kg, 3:1 by weight with EP 905-05, for 10 µm dry film thickness ~ 42,2 m ² /l, 3:1 by weight with EP 905-05, 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:	< 430 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 zined 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), if necessary, sand slightly and degrease with Mipa Silikonentferner

Proposed coating structure: Steel, zincd substrates, GRP:
priming coat: EP 140-30 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 140-30 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 has the following maximum VOC-values:
- Applied by spraying with 2K-EP-Härter EP 905-05: < 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 30 min at 20 °C and at the latest after 14 days. After drying for more than 14 days, intermediate sanding is required.

Can be overcoated with putty after 30 Min. at 60 °C or after 12 hours drying at room temperature. When recoating with a putty do not exceed the coat thickness of max. 25 µm (1 thin spray coat).

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 Nitroverdünnung.