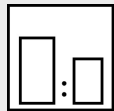


Intended use

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 2K EP Hardener



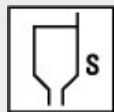
Pot life

with hardener -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

hardener

pressure (bar)

nozzle (mm)

spray passes

dilution

gravity spray gun/
HVL

—

2,0 - 2,5

1,2 - 1,5

1 - 2

10 - 25 %

Airmix / Airless
compound pressure

—

1,0 - 2,0
100 - 120

0,28 - 0,33

1 - 2

5 - 10 %

brush, roller

—

—

—

—

5 - 10 %



Drying time

hardener

object temperature

dust dry

set to touch

ready for assembly

sandable

recoatable

—

20 °C

10 - 15 min

3 - 4 h

10 - 12 h

—

30 - 45 min

—

60 °C

—

—

30 min

—

—

Note

Characteristics:	binder base: solids content (% by weight): solids content (% by volume): delivery viscosity DIN 53211 4 mm (in s): density DIN EN ISO 2811 (kg/l): gloss level ISO 2813 at 60° (GU):	Epoxy polyamide combination ~ 70 ~ 51 thixotropic ~ 1,5 < 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, zincd 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 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), 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.