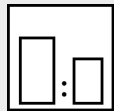


Intended use

Fast drying 2K HS zinc phosphate epoxy primer for steel, zinc substrates, aluminium and GRP. Suitable as priming coat for the top quality coating of commercial vehicles and highly stressed machines and constructions.

Colour: Grey. Further colour shades on request.

Processing instructions**Mixing ratio****hardener**

EP 968-25

by weight (lacquer : hardener)

4 : 1

by volume (lacquer : hardener)

4 : 1

**Hardener**

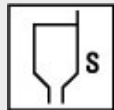
Mipa EP 968-25 2K EP Hardener

**Pot life**

with hardener -25 approx. 6 h at 20 °C

**Thinner**

Mipa EP-Verdünnung, Mipa EP-Verdünnung lang

**Processing viscosity**
gravity spray gun

—

Airmix/Airless

50 - 60 s 4 mm DIN

**Application mode****application mode****hardener****pressure
(bar)****nozzle
(mm)****spray
passes****dilution**gravity spray gun/
HVL

—

2,0 - 2,5

1,5 - 2,5

2 - 3

5 %

Airmix / Airless
compound pressure

—

1,0 - 2,0
100 - 120

0,28 - 0,33

1 - 2

0 - 5 %

brush, roller

—

—

—

—

5 %

**Drying time****hardener****object
temperature****dust dry****set to
touch****ready for
assembly****sandable****recoatable**

—

20 °C

40 min

4 h

10 h

—

1 h

—

60 °C

—

—

60 min

—

—

A flash-off phase of 15 min/20 °C is necessary before forced drying.

Note

Characteristics:	binder base: epoxy resin solids content (% by weight): ~ 77 solids content (% by volume): ~ 62 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
Properties:	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 to steel, zincd substrates, aluminium and GRP
Theoretical spreading rate:	~ 48,9 m²/kg, 4:1 by weight with EP 968-25, for 10 µm dry film thickness. ~ 67,9 m²/l, 4:1 by weight with EP 968-25, 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:	< 340 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), sand slightly if necessary and degrease again with Mipa Silikonentferner.
Proposed coating structure:	2-coat system Steel, zincd substrates, aluminium, GRP: Priming coat: EP 168-20 with 80 - 100 µm dry film thickness. Finishing coat: *PU 260-90 / PU 262-90 with 50 - 60 µm dry film thickness.

Special notes:

*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 grey. For other colour shades, these may deviate.

Recoat at the earliest after 60 min at 20 °C and at the latest after 7 days. After drying for more than 7 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.