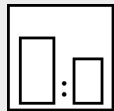


Intended use

2K epoxy resin micaceous iron coating according to TL 918 300, sheet 87, can be used as intermediate coat within the anti-corrosion coating system for steel, zinc-coated substrates and aluminium. Designed as intermediate coating for bridges, railings, docks, piping and structures in aggressive atmosphere as well as for areas exposed to sewage and seawater. Durable corrosion protection and decorative effect.

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



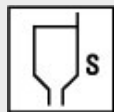
Pot life

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



Thinner

Mipa EP-Verdünnung, Mipa EP-Verdünnung lang



Processing viscosity gravity spray gun

–

Airmix/Airless

–



Application mode

application mode

hardener

pressure (bar)

nozzle (mm)

spray passes

dilution

gravity spray gun/
HVL P

–

2,0 - 2,5

1,8 - 2,0

2

10 - 15 %

Airmix / Airless
compound pressure

–

1,0 - 2,0
100 - 120

0,33 - 0,54

1

10 - 15 %

paint brush, roller

–

–

–

–

5 - 10 %



Drying time

hardener

object temperature

dust dry

set to touch

ready for assembly

sandable

recoat able

–

20 °C

45 - 55 min

4 - 5 h

10 - 12 h

–

1 h

–

60 °C

–

–

45 min

–

–

Note

Characteristics:	binder base:	epoxy resin
	solids content (% by weight):	~ 76
	solids content (% by volume):	~ 48
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	~ 1,9
	gloss level ISO 2813 at 60° (GU):	Matt*
Properties:	highly resistant to water	
	electrostatic application possible	
	excellent resistance to chemical and mechanical strains	
	highest corrosion protection, resistant to abrasion, viscoplastic	
	heat resistance:	
	- short-term heat exposure: 180°C	
	- permanent heat exposure: 150°C	
	adhesion to steel, zined substrates and aluminium	
Theoretical spreading rate :	~ 31,5 m ² /kg, 5:1 by weight with EP 950-25, for 10 µm dry film thickness	
	~ 51,8 m ² /l, 5:1 by weight with EP 950-25, 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:	< 450 g/l. **	
Processing conditions:	From + 10 °C and up to 80 % relative humidity. Ensure adequate air ventilation. Recommendation: At temperatures between + 10 and + 15 °C use the EP 950-10 hardener, at temperatures above + 15 °C use the EP 950-25 hardener.	
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	

Proposed coating structure: 2-coat system
zincd substrates, aluminium:
priming coat: EP 500-20 with 60 - 80 µm dry film thickness
finishing coat: ***PU 500-20 with 50 - 60 µm dry film thickness

3-coat system
steel
priming coat: *** EP 100-20 or in case of constant water exposure 2K zinc dust paint with 60 - 80 µm dry film thickness
intermediate coat: EP 500-20 (60 - 80 µm), for maximum corrosion protection (140 - 160 µm)
finishing coat: ***PU 500-20 with 50 - 60 µm dry film thickness

Special notes:

*Due to the special surface, a measurement according to DIN EN ISO 2813 is inappropriate!

**This product contains the following maximum values:

- Applied by spraying with 2K-EP-Härter EP 950-25: < 500 g/l of VOC.

***Further Mipa primers/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 DB 701. For other colour shades, these may deviate.

In case of application by means of an Airmix/Airless device, it is recommended testing beforehand the equipment for its suitability.

Check colour prior to application.

In order to achieve optimum iron mica effects and to avoid strips, it is advisable to spray the finishing coat or to roll or paint in only one direction.

When used as an intermediate layer in anti-corrosion coating, the addition of PMI colour concentrate can be dispensed with.

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.