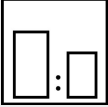








Intended use

Fast drying, glossy, highly weather-resistant and hard-wearing synthetic resin paint for coating commercial vehicles, machines and structures indoors and outdoors.

Processing instructions

	Mixing ratio hardener		by weight (lacquer : hardener)	by volume (lacquer : hardener)				
	–		–	–				
	Hardener							
	–							
	Pot life	2 days with Härterverdünnung						
	Thinner	Mipa UN-Verdünnung Mipa Verdünnung UN 21 Mipa Härterverdünnung						
	Processing viscosity gravity spray gun			Airmix/Airless				
	18 - 22 s 4 mm DIN			40 - 50 s 4 mm DIN				
	Application mode	application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution	
	gravity spray gun / HVLP	–	–	2,0 - 2,5	1,2 - 1,5	2 - 3	10 - 20 %	
	Airmix / Airless compound pressure	–	–	1,0 - 2,0 120 - 250	0,23 - 0,33	1 - 2	5 - 10 %	
	brush, roller	–	–	–	–	–	0 - 5 %	
	Drying time	hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
	–	–	20 °C	40 - 45min	6 - 8 h	24 h	–	–
	–	–	60 °C	–	–	60min	–	–

Allow to flash off for 10-15 min. at elevated temperature before drying.

Note

Characteristics:	binder base:	modified alkyd resin
	solids content (% by weight):	~ 58
	solids content (% by volume):	~ 48
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	~ 1,2
	gloss level ISO 2813 at 60° (GU):	> 80 glossy
Properties:	fast drying	
	good hiding power	
	highly UV- and weather-resistant	
	high vertical stability	
	excellent flow, high final hardness, gloss stable	
	resistant to fuels and diesel if exposed temporarily	
	heat resistance:	
	- short-term heat exposure: 150°C	
	- permanent heat exposure: 130 °C	
Theoretical spreading rate :	~ 46,6 m ² /kg for 10 µm dry film thickness	
	~ 47,8 m ² /l 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:	< 480 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	
	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	
	wood (wood moisture max. 15 %):	
	- pre-sand with grit P 180 –P 280 and remove dust thoroughly	

Proposed coating structure: steel:
priming coat: *AK 100-20 / AK 105-20 with 50 - 60 µm dry film thickness
finishing coat: KH-Lack with 50 - 60 µm dry film thickness

zincd substrates, aluminium:
priming coat: *VB 100-20 with 15 - 30 µm dry film thickness
finishing coat: KH-Lack with 50 - 60 µm dry film thickness

wood for exterior use:
impregnation: Mipaxyl spezial
priming coat: Mipa Malervorlack HS with 50 - 60 µm dry film thickness
finishing coat: KH-Lack with 50 - 60 µm dry film thickness

wood for interior use:
priming coat: Mipa Malervorlack HS with 50 - 60 µm dry film thickness
finishing coat: KH-Lack with 50 - 60 µm dry film thickness

Special notes: *Further Mipa primers are available. Please contact your technical adviser or our application technicians.

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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.

Applying too thick layers may extend considerably the drying time.

Depending on the colour, the delivery viscosity may vary. Adjust the viscosity by adding thinner.

Check colour before applying.

Cleaning of tools: Clean tools immediately after use with Mipa Nitroverdünnung.