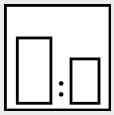
Mipa KH-Lack Kunstharz-Decklack

Technical data sheet

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)
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Hardener

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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.

MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49 8703 92 20 · Fax: +49 8703 92 21 00 · mipa@mipa-paints.com · www.mipa-paints.com

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 m²/kg for 10 µm dry film thickness.
~ 47,8 m²/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 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.

Zinced 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.

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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.

Zinced 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.

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.

When alkyd resin (based) products are stored, a skin can form on the surface of the paint due to the system. This generally has no negative effects on the quality (material testing is recommended!).
If a skin has formed, it must be carefully removed before stirring (before tinting for bases) and the product must be sieved as required before application.

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.

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