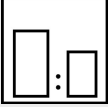








### Intended use

Mipa Metallgrund ist eine hochwertige 1K-Rostschutzgrundierung für den industriellen Einsatz (Maschinen-, Anlagen- und Geräteteile, Mipa Metallgrund is a high-quality 1K anticorrosion primer for industrial use (parts of machines, plants and equipment, metal constructions, etc. made of steel). The high proportion of zinc phosphate ensures excellent corrosion protection.

Colours: Red-brown, grey. Further colour shades on request.

### Processing instructions

	<b>Mixing ratio</b> hardener	<b>by weight (lacquer : hardener)</b>		<b>by volume (lacquer : hardener)</b>				
	–	–		–				
	<b>Hardener</b>	–						
	<b>Pot life</b>	2 days with Härterverdünnung						
	<b>Thinner</b>	Mipa UN-Verdünnung Mipa Verdünnung UN 21 Mipa Härterverdünnung						
	<b>Processing viscosity</b> gravity spray gun	20 - 25 s 4 mm DIN		<b>Airmix/Airless</b> 50 - 60 s 4 mm DIN				
	<b>Application mode</b>	<b>application mode</b>	<b>hardener</b>	<b>pressure (bar)</b>	<b>nozzle (mm)</b>	<b>spray passes</b>	<b>dilution</b>	
	gravity spray gun/ HVLP	–	–	2,0 - 2,5	1,3 - 1,8	2 - 3	15 - 20 %	
	Airmix / Airless compound pressure	–	–	1,0 - 2,0 100 - 120	0,28 - 0,33	1 - 2	5 - 10 %	
	brush, roller	–	–	–	–	–	0 - 5 %	
	<b>Drying time</b>	<b>hardener</b>	<b>object temperature</b>	<b>dust dry</b>	<b>set to touch</b>	<b>ready for assembly</b>	<b>sandable</b>	<b>recoatable</b>
	–	–	20 °C	15 - 30 min	45 - 60 min	5 - 6 h	–	1 - 2 h (1 h for 1K paints, 2 h for 2K paints)
	–	–	60 °C	–	–	30 min	–	–

Fully cured after 3 - 4 days (at 20 °C).

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**Note**

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**Characteristics:**

binder base:	alkyd resin
solids content (% by weight):	~ 64
solids content (% by volume):	~ 43
delivery viscosity DIN 53211 4 mm (in s):	80 - 100
density DIN EN ISO 2811 (kg/l):	~ 15
gloss level ISO 2813 at 60° (GU):	< 20 matt

**Properties:**

good flow, fast drying  
active corrosion protection (zinc phosphate)  
electrostatic application is possible when adding approx. 10 % of thinner Verdünnung UN  
very good weather resistance  
adhesive, shock and scratch-resistant  
resistant to cleaning agents and in case of temporary exposure also to oils, greases, fuels, acids and alkali in low concentration  
resistance to heat: - short-term heat exposure: 150 °C  
- permanent heat exposure: 120 °C  
adhesion to steel

**Theoretical spreading rate :** ~ 33,1 m<sup>2</sup>/kg for 10 µm dry film thickness  
~ 44,9 m<sup>2</sup>/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:** < 520 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

**Proposed coating structure:** steel:  
priming coat: Metallgrund with 30 - 40 µm dry film thickness  
finishing coat: \*AK 200 / AK 240 / AK 250 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.

Do not overcoat with high-solid Mipa 2K topcoats.

Without top coating, the primed objects can be stored outside for approx. 5 days.

**Cleaning of tools:**

Clean tools immediately after use with Mipa Nitroverdünnung.