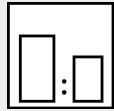


Intended use

Mipa PUR-Lack is a 2K PUR acrylic vehicle paint that has been developed especially for complete and partial coatings of commercial vehicles, tank lorries, bus and for high quality coatings of machines.

Processing instructions



Mixing ratio

hardener

PU 900-25, PU 933-10,
H, MS

A 60

by weight (lacquer : hardener)

–

5 : 1

by volume (lacquer : hardener)

2 : 1

–



Hardener

Mipa PU 900-25, PU 933-10, H 10, H 25, MS 25, MS 40

Mipa PUR Plus-Härter A 60



Pot life

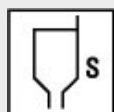
with hardener-10 approx. 1 h at 20 °C

with hardener-40 approx. 8 h at 20 °C



Thinner

Mipa 2K-Verdünnung V 10, V 25, V 40



Processing viscosity

gravity spray gun

20 - 25 s 4 mm DIN

Airmix/Airless

20 - 25 s 4 mm DIN



Application mode

application mode

gravity spray gun/
HVLP

Airmix / Airless
compound pressure

brush, roller*

hardener

–

–

A 60

pressure (bar)

2,0 - 2,5

1,0 - 2,0
100 - 120

–

nozzle (mm)

1,2 - 1,3

0,23 - 0,28

–

spray passes

2 - 4

1

–

dilution

10 - 15 %

10 - 15 %

0 - 5 %



Drying time

hardener

–

–

object temperature

20 °C

60 °C

dust dry

15 - 20 min

–

set to touch

6 h

–

ready for assembly

16 - 24 h

30 min

sandable

–

–

recoatable

–

–

Fully cured after 5 - 6 days (at 20 °C).

Note

Characteristics:	binder base: polyurethane acrylic system solids content (% by weight): ~ 60 solids content (% by volume): ~ 47 delivery viscosity DIN 53211 4 mm (in s): 170 - 190 density DIN EN ISO 2811 (kg/l): ~ 1,3 gloss level ISO 2813 at 60° (GU): > 80 glossy
Properties:	electrostatic application possible highly resistant to water highly UV- and weather-resistant highly resistant to chemicals highly resistant to solvents scratch-resistant excellent resistance to chemical and mechanical strains heat resistance: - short-term heat exposure: 180 °C - permanent heat exposure: 150 °C
Theoretical spreading rate:	~ 49,9 m²/kg, 5:1 by weight with A 60, for 10 µm dry film thickness ~ 55,6 m²/l, 5:1 by weight with A 60, for 10 µm dry film thickness ~ 38,1 m²/kg, 3:1 by weight with MS 25, for 10 µm dry film thickness ~ 40,9 m²/l, 3:1 by weight with MS 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:	< 410 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

Proposed coating structure: steel, zincd substrates:
priming coat: **EP 100-20 with 50 - 70 µm dry film thickness
finishing coat: PUR-Lack with 50 - 60 µm dry film thickness

aluminium:
priming coat: **EP 100-20 with 25 - 30 µm dry film thickness
finishing coat: PUR-Lack with 50 - 60 µm dry film thickness

Special notes: *Suitable: e.g. mohair, Supren, velour, Glattfilt, Rolloschaum. We recommend MP Heizkörperwalze Aurora and MP Farbwalze UniPlan.

**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.

Check colour shade prior to application.

In case of application by means of an Airmix/Airless device, it is recommended testing beforehand the equipment for its suitability. If micro foam or bubbling emerge during the application with an Airmix/Airless device, it is recommended adding more thinner or using the additives 2K-Systemzusatz PUA and PUS. Furthermore, the film thickness should be kept as low as possible.

If required we also offer hardeners and cleaning agents that are suitable for 2-component mixing and dosing units. Please contact your technical adviser or our application technicians.

To optimise the flow properties and to reduce blistering when applying by roller, we recommend the addition of 5 % of Mipa 2K-Systemzusatz PUS. Mipa 2K-Systemzusatz PUS must be stirred well in the paint otherwise cratering may result. For roller application, please consider generally the following hints:

- Before use, roll a new roller over the sticky side of a tape to remove fluff, hairs and so on.
- Soak new roller completely with paint before starting the application and roll out to remove entrapped air.
- Do not apply at direct sunlight or on heated substrates. Object and processing temperature should be between + 10 °C and max. + 25 °C.
- Apply only under dry weather conditions: no rain, dew or fog
- Move roller uniformly and not too fast, get rid of stubborn bubbles by slow rolling with low contact pressure.
- avoid to apply too thick layers in one pass.
- due to the system, this product is not suitable for application on large surfaces.

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