

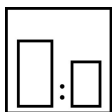
Intended use

2K-PUR HS single-layer aluminium paint for high-quality coating of truck trailers, commercial vehicles, machines etc. Due to the very high proportion of solids (HS quality), durable, high-gloss coatings can be achieved. Furthermore, the special pigmentation guarantees a safe application without mottling. Very good weather resistance, high chemical and mechanical resistance.

Spreading rate: 10,0 - 14,0 m²/l

Processing instructions**Colour**

approx. RAL 9006 white aluminium

**Mixing ratio****Hardener****by weight (lacquer : hardener)****by volume (lacquer : hardener)**

Mipa 2K-HS-Härter

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3 : 1

Mipa 2K-MS-Härter

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2 : 1

**Hardener****for complete paintwork**

Mipa 2K-HS-Härter HS 25 / 35

Mipa 2K-MS-Härter MS 25 / 40

for partial paintwork

Mipa 2K-HS-Härter HS 10

Mipa 2K-Härter MS 10

**Pot life**

1 h with Mipa 2K-Härter HS 10, MS 10 at 20 °C

2 h with Mipa 2K-Härter HS 25, MS 25 at 20 °C

4 h with Mipa 2K-Härter HS 35, MS 40 at 20 °C

**Thinner**

Mipa 2K-Verdünnung kurz V 10

Mipa 2K-Verdünnung normal V 25

Mipa 2K-Verdünnung lang V 40

**Spray viscosity**

Only thin when using HS hardeners. There is no need to thin when using MS hardeners.

gravity spray gun

20 - 25 s 4 mm DIN

Airmix/Airless

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**Application mode****Application mode****Hardener****pressure
(bar)****nozzle
(mm)****spray
passes****dilution
(%)**

gravity spray gun (high pressure)

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2 - 2,5

1,3 - 1,4

1 - 2

5 - 10

HVLP (low pressure)

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2 - 2,2

1,3 - 1,4

1 - 2

5 - 10

HVLP / internal nozzle pressure

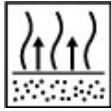
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0,7

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**Flash-off time**

5 - 8 min between coats

10 - 15 min prior to oven drying

Dry coat thickness

50 - 60 µm

**Drying time**

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	45 - 55 min	5 - 6 h	12 - 24 h	—	—
60 °C	10 - 15 min	25 - 30 min	after cooling	—	—

Note

Storage: At least 3 years in unopened original containers.

VOC Regulation: EU limit value for this product (category B/e): 840 g/l.
This product contains max. 534 g/l of VOC.

Processing conditions: From +10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.

Processing instructions: To increase the application reliability, especially on large surfaces, the following paint structure is recommended:

1. Pre-painting:

Apply 1 flowing coat of Mipa PUR HS RAL 7001. This pre-painting creates a uniformly covering pre-paint similar in colour to the top coat RAL 9006. This reduces the risk of mottling during the application of Mipa PUR HS-Einschicht-Aluminium and ensures homogeneous hiding power.

2. final coating:

Overcoat the pre-paint wet-on-wet with 1 coat of Mipa PUR HS-Einschicht-Aluminium.