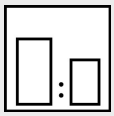
Intended use

This 2K polyurethane wet-in-wet filler can be overcoated already after approx. 15 minutes without loss of gloss. Especially developed for commercial vehicle construction. Can be used on truck box bodies, side panels, tank lorries, and so on.

Processing instructions



Mixing ratio

hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
PU 912-XX, PU 933-10, H	5 : 1	4 : 1

Hardener

Mipa PU 912-10, PU 912-25, PU 912-40, PU 933-10, H 5

Pot life

with hardener -10 approx. 2 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	Airmix/Airless
18 - 22 s 4 mm DIN	30 - 40 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	20 - 25 %
Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,23 - 0,28	1	10 - 15 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
H 5	20 °C	3 - 5 min	50 - 60 min	--	--	15 - 20 min
--	60 °C	--	20 min	--	--	5 min
-10	20 °C	5 - 10 min	1,5 - 2 h	--	--	20 - 30 min
--	60 °C	--	25 - 30 min	--	--	5 - 10 min
-25	20 °C	10 - 15 min	3 - 4 h	--	--	30 - 40 min
--	60 °C	--	30 min	--	--	10 - 15 min
PU 933-10	20 °C	15 - 20 min	4 - 4,5 h	--	--	40 - 50 min
--	60 °C	10 - 15 min	45 min	--	--	15 - 20 min

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Note

Characteristics:

binder base:	polyurethane acrylic system
solids content (% by weight):	~ 77
solids content (% by volume):	~ 60
delivery viscosity DIN 53211 4 mm (in s):	thixotropic
density DIN EN ISO 2811 (kg/l):	~ 1,6
gloss level ISO 2813 at 60° (GU):	< 30 satin matt

Properties:

Electrostatic application possible
Can quickly be overcoated
Very good flow
Excellent spray mist absorption
Very good edge coverage and vertical stability
Excellent gloss retention
Heat resistance:
- Short-term heat exposure: 180 °C
- Permanent heat exposure: 150 °C

Adhesion to steel and GRP

Theoretical spreading rate:

~ 37,4 m²/kg, 5:1 by weight with PU 912-25, for 10 µm dry film thickness.
~ 50,3 m²/l, , 5:1 by weight with PU 912-25, 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:

< 350 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.

GRP:
- Clean (remove completely any mould release agents), if necessary, sand slightly and degrease with Mipa Silikonentferner.

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Proposed coating structure:

2-coat system
Steel, GRP:
Wet-in-wet filler: PU 150-30 with 20 - 30 µm dry film thickness.
Finishing coat: **OC / PUR HS / PU 260 / PU 262 with 50 - 60 µm dry film thickness.

3-coat system
Steel, GRP:
Wet-in-wet filler: PU 150-30 with 20 - 30 µm dry film thickness.
Finishing coat: **WBC / BC*** with 15 - 20 µm dry film thickness.
Clear coat: **2K-HS-Klarlack CC 8 with 50 - 60 µm dry film thickness.

Zinced substrates, aluminium:
Adhesion promoter: Aktivprimer with 10 - 15 µm dry film thickness.
Wet-in-wet filler: PU 150-30 with 20 - 30 µm dry film thickness.
Finishing coat: **OC / PUR HS / PU 260 / PU 262 with 50 - 60 µm dry film thickness.

4-coat system
Zinced substrates, aluminium:
Adhesion promoter: Aktivprimer with 10 - 15 µm dry film thickness.
Wet-in-wet filler: PU 150-30 with 20 - 30 µm dry film thickness.
Finishing coat: **WBC / BC*** with 15 - 20 µm dry film thickness.
Clear coat: **2K-HS-Klarlack CC 8 with 50 - 60 µm dry film thickness.

Special notes:

*This product has the following maximum VOC-values:
- Applied by spraying with 2K-Härter PU 933-10 / PU 912-XX / H: < 540 g/l of VOC.

**Further Mipa topcoats are available. Please contact your technical adviser or our application technicians.

***When using Mipa BC as topcoat, allow PU 150-30 to dry at least 30 - 45 minutes at 60 - 80 °C. After cooling, it's possible to apply the basecoat.

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.

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.

Cleaning of tools:

Clean tools immediately after work with Mipa Nitroverdünnung.

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