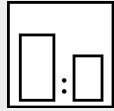


Intended use

High-quality 2K polyurethane acrylic primer with active corrosion protection, high vertical stability and excellent adhesion on steel, zinc substrates, aluminium and GRP. Recoatable with 1K and 2K paints. Can be used as adhesion promoter, primer and primer filler. Wet-on-wet application is possible.

Processing instructions



Mixing ratio

hardener

PU 900-25, PU 912-XX

by weight (lacquer : hardener)

10 : 1

by volume (lacquer : hardener)

7 : 1



Hardener

Mipa PU 900-25, PU 912-10, PU 912-25



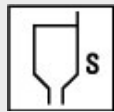
Pot life

with hardener -25 approx. 8 - 9 h at 20 °C



Thinner

Mipa 2K-Verdünnung V 10, V 25, V 40



Processing viscosity

To achieve higher coating thicknesses (use as primer filler with a coating thickness of more than 100 µm), reduce the specified quantity of thinner by 5 % and use a larger nozzle (up to 2 mm). For use as an adhesion promoter (coating thickness 20 - 25 µm), increase the specified quantity of thinner by 10 % and use a smaller nozzle (1.3 - 1.5 mm).

gravity spray gun

—

Airmix/Airless

—



Application mode

application mode

hardener

pressure (bar)

nozzle (mm)

spray passes

dilution

gravity spray gun/
HVL

—

2,0 - 2,5

1,5 - 1,8

2 - 3

15 %

Airmix / Airless
compound pressure

—

1,0 - 2,0
100 - 120

0,28 - 0,33

1 - 2

5 %



Drying time

hardener

object temperature

dust dry

set to touch

ready for assembly

sandable

recoatable

—

20 °C

25 - 30 min

50 - 60 min

5 - 6 h

—

50 - 60 min

—

60 °C

—

—

30 min

—

30 min

In case of coat thicknesses of more than 60 µm, the drying time is extended.

Note

Characteristics:	binder base: polyurethane acrylic system solids content (% by weight): ~ 66 solids content (% by volume): ~ 48 delivery viscosity DIN 53211 4 mm (in s): 170 - 190 density DIN EN ISO 2811 (kg/l): ~ 1,4 gloss level ISO 2813 at 60° (GU): 10 - 20 matt
Properties:	Short drying time High vertical stability and filling power Electrostatic application possible Active corrosion protection (zinc phosphate) Heat resistance: - Short-term heat exposure: 180 °C - Permanent heat exposure: 150 °C Adhesion on steel, zincd substrates, aluminium and GRP
Theoretical spreading rate:	~ 36,5 m²/kg, 10:1 by weight with PU 900-25, for 10 µm dry film thickness. ~ 45,1 m²/l, 10:1 by weight with PU 900-25, 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:	< 450 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. 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. GRP: - Clean (remove completely any mould release agents), if necessary, sand slightly and degrease with Mipa Silikonentferner.

Proposed coating structure: Steel, zincd substrates, aluminium, GRP:
Priming coat: PU 164-20 with 40 - 50 µm dry film thickness or with 20 - 25 µm dry film thickness on aluminium.
Finishing coat: **PU 200-XX / PU 240-XX with 50 - 60 µm dry film thickness.

Steel, zincd substrates (to comply with a higher corrosivity categorie):
Priming coat: PU 164-20 with 80 - 100 µm dry film thickness.
Finishing coat: **PU 200-XX / PU 240-XX with 50 - 60 µm dry film thickness.

Special notes:

*This product has the following maximum VOC-values:
- Applied by spraying with 2K-Härter PU 900-25 / PU 912-XX: < 540 g/l of VOC.

**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 RAL 7035. For other colour shades, these may deviate.

When using this product as adhesion promoter on hard aluminium, observe dry film thickness of 20 - 25 µm.

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 use with Mipa Nitroverdünnung.