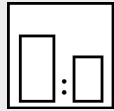


Intended use

Fast drying 2K polyurethane acrylic paint for industrial coating of machines, components, constructions, agricultural machinery and construction vehicles.

Processing instructions



Mixing ratio

hardener

-25

by weight (lacquer : hardener)

5 : 1

by volume (lacquer : hardener)

5 : 1



Hardener

Mipa PU 900-25 2K PU Hardener, Mipa PU 950-25 2K PU Glass Hardener



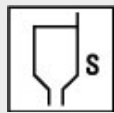
Pot life

with hardener -25 approx. 6 - 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

25 - 30 s 4 mm DIN



Application mode

application mode

hardener

pressure (bar)

nozzle (mm)

spray passes

dilution

gravity spray gun/
HVL P

—

2,0 - 2,5

1,2 - 1,3

2 - 4

10 - 15 %

Airmix / Airless
compound pressure

—

1,0 - 2,0
100 - 120

0,23 - 0,28

1

0 - 10 %



Drying time

hardener

object temperature

dust dry

set to touch

ready for assembly

sandable

recoat able

—

20 °C

20 - 25 min

2 - 3 h

6 - 8 h

—

—

—

60 °C

—

—

30 min

—

—

Fully cured after 5 - 6 days (20 °C)

Note

Characteristics:

binder base:

polyurethane acrylic system

solids content (% by weight):

~ 58

solids content (% by volume):

~ 42

delivery viscosity DIN 53211 4 mm (in s):

150 - 160

density DIN EN ISO 2811 (kg/l):

~ 1,2

gloss level ISO 2813 at 60° (GU):

> 80 glossy

Properties:	Short drying time Electrostatic application possible Highly water-resistant Highly UV- and weather-resistant Heat resistance: - Short-term heat exposure: 180 °C - Permanent heat exposure: 150 °C Adhesion to steel and zinc substrates Adhesion to aluminium: Gt 1
Theoretical spreading rate:	~ 38,8 m²/kg, 5:1 by weight with PU 900-25, for 10 µm dry film thickness. ~ 40,6 m²/l, 5:1 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:	< 460 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. Zinc 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. Glass: 1. Before coating, it is indispensable to determine definitely the recoatable glass surface (e.g. by means of an appropriate measure device to determine the tin side of float glass) because it is generally impossible to coat the side which came in contact with the tin bath. 2. Degrease with Mipa WBS Reiniger or Mipa Silikonentferner.

Proposed coating structure: Single coat system
Steel, zincd substrates, aluminium:
PU 200-90 with 50 - 70 µm dry film thickness.

2-coat system
Steel, zincd substrates, aluminium:
Priming coat: *EP 100-20 with 50 - 70 µm dry film thickness or 25 - 30 µm dry film thickness on aluminum.
Finishing coat: PU 200-90 with 50 - 60 µm dry film thickness.

Glass:
Pretreatment: 1K-Glasprimer.
Finishing coat: PU 200-90 incl. PU 950-25 with 50 - 60 µm dry film thickness.

Special notes:

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

For professional use only.

Especially UV-resistant pigmentations (e.g. pastel shades for facades) are available on demand.

Check colour prior to application.

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.

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 blistering 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.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.