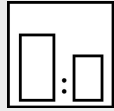


Intended use

2K polyurethane acrylic monolayer with active protection against corrosion, high gloss and fast drying in HS quality. Particularly suitable for high-quality single-layer coating of machines, chassis, components, constructions in interior and exterior areas. Direct adhesion on steel, zinc-coated substrates and aluminium.

Processing instructions



Mixing ratio

hardener

PU 900-25, PU 912-XX,
PU 933-XX

PU 914-XX

PU 916-XX, A 60

by weight (lacquer : hardener)

5 : 1

8 : 1

10 : 1

by volume (lacquer : hardener)

4 : 1

6 : 1

8 : 1



Hardener

Mipa PU 900-25, PU 912-10, PU 912-25, PU 912-40, PU 933-05, PU 933-10

Mipa PU 914-10, PU 914-25, PU 914-40

Mipa PU 916-10, PU 916-25

Mipa PUR Plus-Härter A 60



Pot life

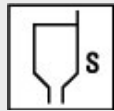
with Härter -10 approx. 1,5 h at 20 °C

with Härter A 60 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

40 - 50 s 4 mm DIN



Application mode

application mode

gravity spray gun/
HVLP

gravity spray gun/
HVLP

Airmix / Airless
compound pressure

Airmix / Airless
compound pressure

paintbrush, roller*

hardener

PU 900 / 912 /
933

PU 914 / 916

PU 900 / 912 /
933

PU 914 / 916

A 60

pressure (bar)

2,0 - 2,5

2,0 - 2,2

1,0 - 2,0
100 - 120

1,0 - 2,0
100 - 120

–

nozzle (mm)

1,2 - 1,3

1,5 - 2,0

0,23 - 0,28

0,23 - 0,28

–

spray passes

2 - 4

1 - 3

1

1

–

dilution


15 - 20 %

5 - 10 %

0 - 10 %

0 - 5 %

0 - 5 %

	Drying time						
	hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
	-10	20 °C	10 - 15 min	2 - 3 h	12 h	--	--
	-10	60 °C	--	20 min	30 - 40 min	--	--
	-25	20 °C	20 min	5 - 6 h	16 h	--	--
	-25	60 °C	--	30 min	45 min	--	--
	-40 / A 60	20 °C	1,5 - 2 h	8 - 10 h	24 h	--	--
	-40 / A 60	60 °C	--	--	1 h	--	--
	PU 933-05	20 °C	30 - 45 min	1 - 2 h	12 h	--	--
	PU 933-10	20 °C	1,5 - 2 h	2 - 3 h	12 h	--	--

Fully cured after 7 - 8 days (at 20 °C).

Note

Characteristics:

binder base: polyurethane acrylic system
 solids content (% by weight): ~ 68
 solids content (% by volume): ~ 50
 delivery viscosity DIN 53211 4 mm (in s): thixotropic
 density DIN EN ISO 2811 (kg/l): ~ 1,4
 gloss level ISO 2813 at 60° (GU): 80 - 90 glossy

Properties:

capable of high-build application
 active corrosion protection (zinc phosphate)
 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, zincd substrates and aluminium

Theoretical spreading rate:

~ 43,3 m²/kg, 10:1 by weight with A 60, for 10 µm dry film thickness
 ~ 53,2 m²/l, 10:1 by weight with A 60, for 10 µm dry film thickness
 ~ 38,5 m²/kg, 5:1 by weight with PU 900-25, for 10 µm dry film thickness
 ~ 44,6 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:

< 420 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: single coat system
steel, zincd substrates, aluminium:
PU 215-80 with 60 - 100 µm dry film thickness

2-coat system

steel, zincd substrates:

- priming coat: ***EP 100-20 with 50 - 70 µm dry film thickness
- finishing coat: PU 215-80 with 50 - 60 µm dry film thickness

aluminium:

- priming coat: ***EP 100-20 with 25 - 30 µm dry film thickness
- finishing coat: PU 215-80 with 50 - 60 µm dry film thickness

Special notes:

*Suitable: e.g. mohair, nap, velour, Glattfilt, Rolloplan, foam paint roller.

**This product has the following maximum VOC-values:

- Applied by brush/ roller with hardener A 60: < 420 g/l of VOC.
- Applied by spraying with hardener PU 916-XX: < 420 g/l of VOC.
- Applied by spraying with hardener PU 900-25, PU 912-XX: < 500 g/l of VOC.

***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.

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

Check colour 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 adding 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.

Depending on the hardener in use and on the processing condition, the gloss level may prove to be higher or lower. The mentioned data refer to the hardener of series: „PU 914-XX“.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.