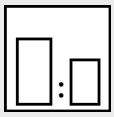
Intended use

High-quality 2K polyurethane acrylic paint with vertical stability ideal for the coating of commercial vehicles, façade elements and highly stressed machines and constructions with excellent hiding power and optimal settings for Airmix application.

Applied on the chipboards, Mipa PU 248-30 is classified B1 according to the test to determine the fire behaviour as per DIN 4102-1.

Processing instructions



Mixing ratio

hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
PU 900-25, PU 912-XX, PU 933-XX, PU 950-25	3 : 1	2 : 1
PU 914-XX	4 : 1	3 : 1
PU 916-XX, A 60	5 : 1	4 : 1

Hardener

Mipa PU 900-25, PU 912-10, PU 912-25, PU 912-40, PU 933-05, PU 933-10, PU 950-25

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 hardener -10 approx. 1 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
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Application mode

application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
gravity spray gun/ HVLP	--	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	10 - 15 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	25 - 30 min	2 - 3 h	6 - 8 h	--	--
--	60 °C	--	--	30 min	--	--

Fully cured after 5 - 6 days (20 °C) .

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Note

Characteristics:	binder base:	polyurethane acrylic system
	solids content (% by weight):	~ 68
	solids content (% by volume):	~ 45
	delivery viscosity DIN 53211 4 mm (in s):	140 - 160
	density DIN EN ISO 2811 (kg/l):	~ 1,5
	gloss level ISO 2813 at 60° (GU):	20 - 30 satin matt

Properties:

electrostatic application possible
very high opacity
high vertical stability
highly UV- and weather-resistant
highly resistant to chemicals and water
excellent resistance to chemical and mechanical strains
highly resistant to solvents
scratch resistant
heat resistance: short-term exposure: 180 °C
permanent exposure: 150 °C

Theoretical spreading rate:

~ 37,8 m²/kg, 5:1 by weight with PU 916-XX, for 10 µm dry film thickness
~ 48,4 m²/l, 5:1 by weight with PU 916-XX, for 10 µm dry film thickness
~ 31,4 m²/kg, 3:1 by weight with PU 912-25, for 10 µm dry film thickness
~ 36,7 m²/l, 3:1 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:

< 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 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

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

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Proposed coating structure:

steel, zinced substrates:
priming coat: **EP 100-20 with 50 - 70 µm dry film thickness
finishing coat: PU 248-30 with 50 - 60 µm dry film thickness

aluminium:
priming coat:: **EP 100-20 with 25 - 30 µm dry film thickness
finishing coat: PU 248-30 with 50 - 60 µm dry film thickness

Special notes:

*This product has the following maximum VOC-values:
- Undiluted with 2K-PU-Härter PU 916-XX: < 480 g/l of VOC.
- Undiluted with 2K-PU-Härter PU 912-XX: < 550 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 demand.

Check colour shade 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 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.

Depending on the hardener in use and on the processing conditions, the gloss level may prove to be higher or lower. The mentioned data refer to the hardener of series: PU 900-25, PU 912-25, PU 933-XX, PU 950-25..

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.

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