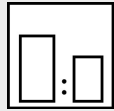


Intended use

2K acrylic topcoat in HS quality for coating trucks, commercial vehicles, truck bodies, facade components as well as highly stressed machines and constructions.

Processing instructions



Mixing ratio

hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
PU 914-XX	2 : 1	–
A 60	3 : 1	–



Hardener

Mipa PU 914-10, PU 914-25, PU 914-40
Mipa PUR Plus-Härter A 60



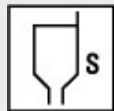
Pot life

with hardener -10 approx. 1,5 h at 20 °C
with hardener -40 approx. 3 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/ HVLP	–	2,0 - 2,5	1,2 - 1,3	1 - 2	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	recoatable
–	20 °C	25 - 30 min	3 - 4 h	8 - 10 h	–	–
–	60 °C	–	–	30 min	–	–

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

Note

Characteristics:

binder base:	Polyurethan-Acryl-System
solids content (% by weight):	- 75
solids content (% by volume):	~ 60
delivery viscosity DIN 53211 4 mm (in s):	120 - 140
density DIN EN ISO 2811 (kg/l):	~ 1,4
gloss level ISO 2813 at 60° (GU):	> 80 glossy

Version: en 11/0224

This technical data sheet is supplied for informational purposes only! According to our information, all data and recommendations correspond to the state of art and are based on years of experience in manufacturing our products. They do not exempt the user from his obligation to verify professionally, on his own responsibility, the suitability of our products to the intended purpose under prevailing conditions. Safety data sheets and warnings on packaging must be observed. We reserve the right to modify and to complete the information content at any time, without prior notice or obligation to update.

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Properties:	electrostatic application possible highly UV- and weather-resistant very good water resistance resistant to solvent scratch-resistant heat resistance: - short-term heat exposure: 180 °C - permanent heat exposure: 150 °C
Theoretical spreading rate:	~ 53,8 m ² /kg, 3:1 by weight with A 60, for 10 µm dry film thickness ~ 63,4 m ² /l, 3:1 by weight with A 60, for 10 µm dry film thickness ~ 47,5 m ² /kg, 2:1 by weight with PU 914-25, for 10 µm dry film thickness ~ 52,9 m ² /l, 2:1 by weight with PU 914-25, 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:	< 200 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:	steel, zincd substrates: priming coat: **EP 100-20 with 50 - 70 µm dry film thickness finishing coat: PU 260-90 with 50 - 60 µm dry film thickness aluminium: priming coat: **EP 100-20 with 25 - 30 µm dry film thickness finishing coat: PU 260-90 with 50 - 60 µm dry film thickness

Special notes:

- *This product has the following maximum VOC-values:
 - Applied by spraying with Härter A 60: < 420 g/l of VOC.
 - Applied by spraying with 2K-PU-Härter PU 914-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 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.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.