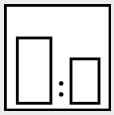
PU 265-50 2K PU HS Industry Chassis Paint semi-gloss

Intended use

2K PU HS chassis paint with active corrosion protection ideal for high-quality coating of chassis of commercial vehicles and trucks.

Processing instructions



Mixing ratio

hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
PU 900-25, PU 912-XX, PU 933-10	5 : 1	4 : 1
PU 914-XX	8 : 1	6 : 1
PU 916-XX, A 60	10 : 1	8 : 1

Hardener

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

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

Mipa PU 916-10, PU 916-25

Mipa PUR Plus Hardener A 60

Pot life

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

with hardener A 60 approx. 8 h at 20 °C

Thinner

Mipa 2K-Verdünnung V 10, V 25, V 40

Processing viscosity

gravity spray gun	Airmix/Airless
20 - 25 s 4 mm DIN	40 - 50 s 4 mm DIN

Application mode

application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
gravity spray gun/ HVLP	PU 900 / 912 / 933	2,0 - 2,5	1,2 - 1,3	2 - 4	15 - 20 %
gravity spray gun/ HVLP	PU 914 / 916	2,0 - 2,2	1,5 - 2,0	1 - 3	0 - 5 %
Airmix / Airless compound pressure	PU 900 / 912 / 933	1,0 - 2,0 100 - 120	0,23 - 0,28	1	0 - 10 %
Airmix / Airless compound pressure	PU 914 / 916	1,0 - 2,0 100 - 120	0,23 - 0,28	1	0 - 5 %
brush, roller*	A 60	--	--	--	0 - 5 %

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Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
-10	20 °C	15 - 30 min	2 - 3 h	12 h	--	--
-10	60 °C	--	20 min	30 - 40 min	--	--
-25	20 °C	30 - 45 min	3 - 4 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 933-10	20 °C	1,5 - 2 h	2 - 3 h	12 h	--	--

Fully cured after 7 - 8 days (20 °C).

Note

Characteristics:

binder base:	polyurethane acrylic system
solids content (% by weight):	~ 77
solids content (% by volume):	~ 59
delivery viscosity DIN 53211 4 mm (in s):	thixotropic
density DIN EN ISO 2811 (kg/l):	~ 1,6
gloss level ISO 2813 at 60° (GU):	50 - 60 semi-gloss

Properties:

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 on steel, zinced substrates and aluminium

Theoretical spreading rate:

~ 42,6 m²/kg, 10:1 by weight with A 60, for 10 µm dry film thickness.
~ 60,8 m²/l, 10:1 by weight with A 60, for 10 µm dry film thickness.
~ 37,2 m²/kg, 5:1 by weight with PU 900-25, for 10 µm dry film thickness.
~ 49,9 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:

< 400 g/l.**

Processing conditions:

From + 10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.

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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 withMipa 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.

Proposed coating structure:

Single coat system
Steel, zinced substrates, aluminium:
PU 265-50 with 60 - 100 µm dry film thickness.

2-coat system
Steel, zinced 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 265-50 with 50 - 60 µm dry film thickness.

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Special notes:

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

**This product contains the following maximum VOC-values:
- Applied by brush/ roller with hardener A 60: < 400 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, PU 933-10: < 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 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 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.

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