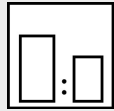


Intended use

2K polyurethane acrylic texture paint for industrial coating of machines, components, constructions, steel lockers and tools. For interior and exterior use.

Processing instructions



Mixing ratio

hardener

A 61, A 51

by weight (lacquer : hardener)

5 : 1

by volume (lacquer : hardener)

4 : 1



Hardener

Mipa 2K-Struktur-Härter A 61

Mipa 2K-Struktur-Härter A 51



Pot life

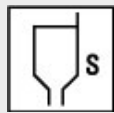
with hardener A 61 ca. 1 - 2 h at 20 °C

with hardener A 51 ca. 1 - 2 h at 20 °C



Thinner

Mipa 2K-Verdünnung V 10, V 25, V 40



Processing viscosity

Ready for use after adding hardener, if necessary thin with Mipa 2K-Verdünnung.

gravity spray gun

thixotropic

Airmix/Airless

thixotropic



Application mode

application mode

gravity spray gun/
HVLP

paint pressure gun
compound pressure

Airmix / Airless
compound pressure

hardener

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pressure (bar)

1,6 - 2,0

2,0 - 2,5
0,5 - 0,8

1,0 - 2,0
100 - 120

nozzle (mm)

1,8 - 3,0

1,8 - 3,0

0,41 - 0,54

spray passes

2

1 - 2

1

dilution

0 %

0 %

0 %



Drying time

hardener

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object temperature

20 °C

60 °C

dust dry

25 - 30 min

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set to touch

5 - 6 h

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ready for assembly

24 h

30 min

sandable

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recoatible

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

Note

Characteristics:	binder base: polyurethane acrylic system solids content (% by weight): ~ 71 solids content (% by volume): ~ 53 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): satin gloss *
Properties:	free from silicone electrostatic application possible highly UV- and weather-resistant very good resistance to water highly resistant to solvents, fuels and oils heat resistance: short-term heat exposure: 180 °C permanent heat exposure: 150 °C adhesion on steel adhesion on zincd substrates: Gt 0 - 1 adhesion on aluminium: Gt 2
Theoretical spreading rate:	~ 44,7 m ² /kg, 5:1 by weight with A 61, for 10 µm dry film thickness ~ 54,5 m ² /l, 5:1 by weight with A 61, for 10 µm dry film thickness ~ 44,7 m ² /kg, 5:1 by weight with A 51, for 10 µm dry film thickness ~ 50,9 m ² /l, 5:1 by weight with A 51, 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:	< 430 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:
PU 300-70 with 50 - 70 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 300-70 with 50 - 70 µm dry film thickness

aluminium:
priming coat: ***EP 100-20 with 25 - 30 µm dry film thickness
finishing coat: PU 300-70 with 50 - 70 µm dry film thickness

Special notes:

*Due to the special surface, a measurement according to DIN EN ISO 2813 is inappropriate!

**This product contains the following maximum VOC-values:
- Applied by spraying with hardener A 61, A 51: < 430 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.

For exterior use, we recommend using Mipa 2K-Struktur-Härter A 61.

Furthermore it's possible to mix it with neon colours which can be applied then as single-layer. Please see the technical data sheet "Mipa Neon-Farbtöne PMI single-layer paints"

Check colour before use.

Spray distance and pressure change the texture:

Low pressure = rough texture
Large distance = rough texture
High pressure = fine texture
Small distance = fine texture

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.