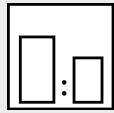


### Intended use

Mipa VC 300-50 Einschicht-Struktur-Spritzlack halbgläzend "Mipaflex-Strukturlack".  
Fast drying, thixotropic textured paint for industrial coatings on machines, devices, components and constructions made of steel, zinc steel and aluminium. For interior and exterior use. Applicable as 1K or 2K textured paint.

### Processing instructions



#### Mixing ratio

##### hardener

1K = --

2K = A 61

##### by weight (lacquer : hardener)

--

10 : 1

##### by volume (lacquer : hardener)

--

--



#### Hardener

1K = --

2K = Mipa 2K-Struktur-Härter A 61



#### Pot life

1K = --

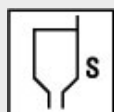
2K = with hardener A 61 approx. 48 h at 20 °C



#### Thinner

Mipa UN-Verdünnung

Mipa Verdünnung UN 21



#### Processing viscosity

Ready for use, if necessary thin with ipa UN-Verdünnung or Verdünnung UN 21.

##### 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

--

--

--

##### pressure (bar)

2 - 2,5

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

1,0 - 2,0  
100 - 120

##### nozzle (mm)

1,6 - 2,0

2,5 - 3,0

0,23 - 0,33

##### spray passes

2 - 4

1 - 2

1

##### dilution

0 %

0 %

0 %



#### Drying time

##### hardener

--

--

##### object temperature

20 °C

60 °C

##### dust dry

10 - 15 min

--

##### set to touch

20 - 30 min

30 min

##### ready for assembly

2 - 3 h

30 min

##### sandable

--

--

##### recoatible

--

--

Fully cured after 4 - 5 days (at 20 °C).

### Note

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<b>Characteristics:</b>	binder base:	vinyl copolymer
	solids content (% by weight):	~ 58
	solids content (% by volume):	~ 40
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	~ 1,3
	gloss level ISO 2813 at 60° (GU):	semi-gloss*
<b>Properties:</b>	very good resistance to water	
	electrostatic application possible	
	heat resistance:	
	- short-term heat exposure: 90 °C	
	- permanent heat exposure: 70 °C	
	adhesion to steel, zined substrates and aluminium	
<b>Theoretical spreading rate:</b>	~ 35,2 m <sup>2</sup> /kg for 10 µm dry film thickness	
	~ 40,1 m <sup>2</sup> /l for 10 µm dry film thickness	
<b>Storage:</b>	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.	
<b>VOC:</b>	< 500 g/l.	
<b>Processing conditions:</b>	From + 10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.	
<b>Substrate preparation:</b>	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	
	zined 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:  
VC 300-50 with 50 - 70 µm dry film thickness

2-coat system  
steel, zincd substrates:  
priming coat: \*\*VB 100-20 min 20 - 30 µm or EP 100-20 with 50 - 70 µm dry film thickness  
finishing coat: VC 300-50 with 50 - 60 µm dry film thickness

aluminium:  
priming coat: \*\*VB 100-20 min 20 - 30 µm or EP 100-20 with 25 - 30 µm dry film thickness  
finishing coat: VC 300-50 with 50 - 60 µm dry film thickness

**Special notes:**

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

\*\*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.

Due to the system, strong exposure to UV and weathering may cause chalking. In addition, the thermoplastic behaviour of the coating must be observed at higher temperatures.

Check colour shade prior to application.

Spraying distance and pressure affect the texture:

Low pressure = coarse texture

Long distance = coarse texture

High pressure = fine texture

Short 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.