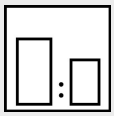
VC 300-50 Single-layer Texture Coat semi gloss

Intended use

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

Processing instructions



Mixing ratio

hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
1K = --	--	--
2K = A 61	10 : 1	--

Hardener

1K = --

2K = Mipa 2K Structure Hardener 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	Airmix/Airless
thixotropic	thixotropic

Application mode

application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
gravity spray gun/ HVLP	--	2 - 2,5	1,6 - 2,0	2 - 4	0 %
paint pressure gun compound pressure	--	2,0 - 2,5 0,5 - 0,8	2,5 - 3,0	1 - 2	0 %
Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,23 - 0,33	1	0 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	10 - 15 min	20 - 30 min	2 - 3 h	--	--
--	60 °C	--	30 min	30 min	--	--

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

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Note

Characteristics:	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*

Properties:

Very good resistance to water
Electrostatic application possible
Heat resistance:
- Short-term heat exposure: 90 °C
- Permanent heat exposure: 70 °C

Adhesion to steel, zinced substrates and aluminium

Theoretical spreading rate:

~ 35,2 m²/kg for 10 µm dry film thickness.
~ 40,1 m²/l 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:

< 500 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 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:

Single coat system
Steel, zinced substrates, aluminium:
VC 300-50 with 50 - 70 µm dry film thickness.

2-coat system
Steel, zinced 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.

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