

Intended use .

Fast drying one-component zinc dust primer for corrosion protection systems with high protective properties for steel substrates. Moreover, it can be used to repair damages on spray-galvanized parts, weld seams and so on. Recoatable with Mipa 1K-paints (based on synthetic resin, PMI AK, PMI VC).

Colour: Grey.

Processing instructions _

	Mixing ratio hardener 		by wei 	ght (lacquer :	hardener)	by volume (lacquer : hardener) 	
A	Hardener 						
	Pot life 						
	Thinner 						
∏ s	Processing vis Apply undiluted gravity spray g		Airm –	nix/Airless			
	Application m application mo	ode ha	ardener	pressure (bar) 	nozzle (mm) 	spray passes 	dilution 0 %
\bigcirc	Drying time hardener	object temperatur	dust dry re	set to touch	ready for assembly	sandable	recoatable
		20 °C 60 °C	25 - 30 min 	50 - 60 Mir 	45 min	-	

Fully cured after 3 - 4 days (at 20 °C).

Characteristics:	binder base:	epoxy resin esters	
	solids content (% by weight):	~ 81	
	solids content (% by volume):	~ 43	
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic	
	density DIN EN ISO 2811 (kg/l):	~ 2,6	
	gloss level ISO 2813 at 60° (GU):	10 - 20 matt	

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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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Zinkalyd - Brush Application Technical data sheet



Properties:	Metal contant in the dyr film is higher than 91 %. High cathodic corrosion protection. Heat resistance: - Permanent heat exposure: Up to 400 °C. Adhesion to steel.	
Theoretical spreading rate:	\sim 17,8 m²/kg for 10 μm dry film thickness. \sim 44,0 m²/l for 10 μm dry film thickness.	
Storage:	For at least 2 years in the unopened original container. Optimum storage conditions between $+5$ °C and $+25$ °C, avoid direct sunlight. Other storage conditions may leas 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.	
Proposed coating structure:	2-coat system Steel: Priming coat: Zinkalyd with 50 - 60 μm dry film thickness. Finishing coat: *AK 200 / AK 240 / AK 250 with 60 - 80 μm dry film thickness.	
	3-coat system Steel: Priming coat: Zinkalyd with 50 - 60 μm dry film thickness. Intermediate coat: AK 555-20 / VC 555-20 with 60 - 80 μm dry film thickness. Finishing coat: *AK 200 / AK 240 / AK 250 with 60 - 80 μm dry film thickness.	
Special notes:	*Further Mipa topcoats are available. Please contact your technical adviser or our application technicians.	
	For professional use only.	
	Keep already opened containers tightly closed and protect from humidity.	
	When alkyd resin (based) products are stored, a skin can form on the surface of the paint due to the system. This generally has no negative effects on the quality (material testing is recommended!). If a skin has formed, it must be carefully removed before stirring (before tinting for bases) and the product must be sieved as required before application.	
	Do not exceed the dry film thickness of 120 μm per application (otherwise you risk fissuring and retarding in drying).	
	Do not overcoat with 2-component paints.	
	Special colours available on request.	

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Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.

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