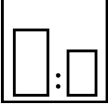







Intended use

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).

Processing instructions

	Mixing ratio						
	hardener		by weight (lacquer : hardener)	by volume (lacquer : hardener)			
	--		--	--			
	Hardener						
	--						
	Pot life						
	--						
	Thinner						
	apply undiluted						
	Processing viscosity						
	gravity spray gun		Airmix/Airless				
	--		--				
	Application mode						
	application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution	
	paint brush, roller	--	--	--	--	0 %	
	Drying time						
	hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
	--	20 °C	25 - 30 min	50 - 60 min	6 h	--	12 h
	--	60 °C	--	--	45 min	--	--

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

Note

Characteristics:	binder base:	epoxy resin esters
	solids content (% by weight):	79 - 81
	solids content (% by volume):	41 - 43
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	2,5 - 2,6
	gloss level ISO 2813 at 60° (GU):	10 - 20 matt

Properties:	metal content in the dry film is higher than 91 % high cathodic corrosion protection heat resistance: - permanent heat exposure: up to 400 °C adhesion to steel
Theoretical spreading rate :	16,9 - 17,8 m ² /kg for 10 µm dry film thickness 42,9 - 44,0 m ² /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 lead to undesirable properties of the material.
VOC:	EU limit value according to Directive 2004/42/EC for this product (category A/i): 500 g/l. This product has the following maximum VOC-values: Applied by paint brush/ roller: < 490 g/l of VOC.
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
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. 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.
Cleaning of tools:	Clean tools immediately after use with Mipa Nitroverdünnung.