
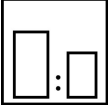








**Intended use**

High heat-resistant special coating based on silicon resin that is perfectly suitable to be applied on steel substrate like e.g. exhaust systems, ovens, barbecue grills, and so on. Heat resistance up to 800°C.

Spreading rate: 9,0 - 12,0 m<sup>2</sup>/l

**Processing instructions**

	<b>Colour</b> silver black						
	<b>Mixing ratio</b>	<b>Hardener</b>	<b>by weight (lacquer : hardener)</b>	<b>by volume (lacquer : hardener)</b>			
		--	--	--			
	<b>Hardener</b>	<b>for complete paintwork</b>		<b>for partial paintwork</b>			
		--		--			
	<b>Pot life</b>	--					
	<b>Thinner</b> ready to use						
	<b>Spray viscosity</b>	<b>gravity spray gun</b>		<b>Airmix/Airless</b>			
		--		--			
	<b>Application mode</b>	<b>Application mode</b>	<b>Hardener</b>	<b>pressure (bar)</b>	<b>nozzle (mm)</b>	<b>spray passes</b>	<b>dilution (%)</b>
		gravity spray gun (high pressure)	--	2 - 2,5	1,3 - 1,5	2	--
		HVLP (low pressure)	--	2 - 2,2	1,3 - 1,5	2	--
		HVLP / internal nozzle pressure	--	0,7	--	--	--
		Airmix / Airless	--	100 - 120	0,23 - 0,28	1 - 2	--
	<b>Flash-off time</b>	5 - 8 min between coats 10 - 15 min before oven drying					
	<b>Dry coat thickness</b>	15 - 20 µm					



**Drying time**

**object temperature**

20 °C

60 °C

**dust dry**

30 - 60 min

10 - 15 min

**set to touch**

5 h\*

40 - 60 min\*

**ready for assembly**

24 h

after cooling

**sandable**

--

--

**recoatable**

--

--

**Note**

**Storage:** at least 3 years in unopened original container

**VOC Regulation:** EU limit value for this product (category B/e): 840 g/l  
This product contains max. 750 g/l of VOC.

**Processing conditions:** From +10 °C and up to 80 % relative air humidity. Ensure an adequate air ventilation.

**Processing instructions:** Surface preparation:

The surface must be clean and dry.

Remove all oil, grease, rust, mill scale, scale, and other substances that could impair the function and the paint finish!

Steel substrates:

1. Pre-clean with Mipa Silikonentferner.
2. Then pre-sand with P 120 and final sand with P 220 - 320.
3. Then degrease with Mipa Silikonentferner.

Since Mipatherm is applied in a dry film thickness of 15 - 20 µm, the substrate must not be sanded too roughly. Blasting is not recommended as a pre-treatment method.

Reason for this: The resulting rough steel surface can no longer be covered to form a film, which can lead to premature corrosion.

General information:

\*Restricted touch resistance means: Light chalking is still possible. The coating is still sensitive to mechanical and chemical stress. Therefore, careful handling of the painted objects is necessary.

Conditional resistance: Conditional solvent resistance (temporary exposure) is achieved after approximately 1 - 2 hours at 200 °C. The coating is then also less sensitive to mechanical and chemical stress.

Optimal film properties and full chemical and mechanical resistance are achieved after the first heat exposure of approximately 1 hour at a minimum of 300 °C.

To avoid blistering due to excessively rapid heat exposure, appropriately long final flash-off times must be observed, or the temperature rise should be as slow as possible.

Brush and roller application are only possible to a limited extent.