

## Intended use

Mipa Zink-Alu-Spray is a high-quality zinc dust coating with high corrosion protection for use on steel and ferrous metals and is perfectly suited for refinishing hot-dip galvanized steel parts in compliance with DIN EN ISO 1461. Since the colour shade is matched to that of the hot-dip galvanized surface, it is easier to visually adapt the repaired areas. Due to the corrosion protection properties of Mipa Zink-Alu-Spray, the coating is highly resistant to moisture and has a corrosion resistance of > 450 hours in salt spray tests according to DIN EN ISO 9227. Mipa Zink-Alu-Spray is also resistant to high temperatures of up to 300 °C, can be spot-welded and if required, can be overcoated with Mipa 1K paints. For indoor and outdoor use.

## Processing instructions



### Substrates

Iron and steel.

### Pre-treatment / cleansing

Pre-clean with Mipa Silikonentferner.

Please refer to the section "Substrate preparation" for detailed information.

### Characteristics

Especially suitable for spot welding  
High zinc content, therefore high corrosion protection  
Resistant to chemical agents and physical stress  
Heat-resistant up to at least 300 °C  
Allows refinishes conforming to standards as per DIN EN ISO 1461  
Fast drying

## Colour / gloss level

silver-aluminium, visually similar to hot-dip galvanising



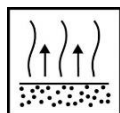
### Preparation

Before use, shake can vigorously for 1 - 2 minutes!



### Application

Spray to test - spray distance approx. 15 - 20 cm  
2 - 3 coats, dry film thickness: 30 - 40 µm



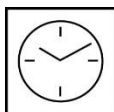
### Flash-off time

2 - 3 min between coats



### After use

After use, turn can upside down and spray until the valve is clean, this prevents the valve from clogging up.



## Drying times at 20 °C

Dust dry after approx.	15 min
Set to touch after approx.	1 h
Overcoatable after approx.	4 - 6 h

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

**Storage** Can be stored for 2 years in cool and dry places.

**VOC-regulation** EU limit value for the product (cat. B/e): 840 g/l  
This product contains max. 650 g/l of VOC.

**Safety information** See safety data sheet

## Substrate preparation:

The substrate must be clean and dry. Remove oil, grease, rust, corrosion as well as any other substances impairing the function of the coating!

### Steel substrates:

Blast to cleaning degree Sa 2½, remove blast residues and overcoat promptly.

Alternatively:

1. Pre-clean with Mipa Silikonentferner.
2. Then de-rust with hand and power tools to degree of cleanliness St 3.
3. Afterwards, degrease with Mipa Silikonentferner.

### Refinishing galvanised substrates (batch galvanising / discontinuous hot-dip galvanising / strip galvanising / continuous hot-dip galvanising and electrogalvanising):

1. Pre-clean the repaired area with Mipa Silikonentferner.
2. Then dry sand with P 220.
3. Afterwards, degrease with Mipa Silikonentferner.

Note: When repairing damaged galvanised areas, the dry film thickness of Mipa Zink-Alu-Spray must be approx. 30 µm higher than the existing zinc layer.