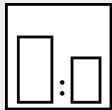


Intended use

Mipa PU 850-05 2K-PU-Klarlack dull matt colourless is a two-component matt varnish with light stabilizers according to TL 8010-0002 class II Type 7. It is suitable as topcoat for military equipment that has been coated in flecktarn camouflage.

WIWeB certificate: 440.05.02.L27A4.1, incl. resistance to chemical agents and decontaminants in accordance to STANAG 4360.

Processing instructions



Mixing ratio

hardener

PU 955-25

by weight (lacquer : hardener)

4 : 1

by volume (lacquer : hardener)

4 : 1



Hardener

Mipa PU 955-25 2K PU Hardener



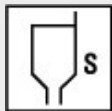
Pot life

with hardener -25, approx. 3 h at 20 °C



Thinner

Mipa 2K-Verdünnung 971



Processing viscosity

Ready for use after addition of hardener, if necessary thin with Mipa 2K-Verdünnung.

gravity spray gun

—

Airmix/Airless

—



Application mode

application mode

gravity spray gun /
HVLP

hardener

—

pressure (bar)

2,0 - 2,5

nozzle (mm)

1,5

spray passes

2 - 3

dilution

0 %



Drying time

hardener

—

object temperature

20 °C

dust dry

5 - 10 min

set to touch

60 min

ready for assembly

16 h

sandable

—

recoatible

—

Fully cured after 10 days (20 °C).

Note

Characteristics:

binder base:

polyurethane acrylic system

solids content (% by weight):

~ 45

solids content (% by volume):

~ 35

delivery viscosity DIN 53211 4 mm (in s):

thixotropic

density DIN EN ISO 2811 (kg/l):

~ 1,1

gloss level ISO 2813 at 60° (GU):

< 2 GU or < 8 GU in a 85°-angle

Version: en 10/0924

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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| | |
|------------------------------------|--|
| Properties: | Electrostatic application is possible Particularly good flow of the wet film during the drying process Highly UV-, weather and water-resistant High chemical resistance Highly resistant to solvents Scratch resistant Excellent chemical and mechanical resistance Heat resistance: - Short-term heat exposure: 180 °C - Permanent heat exposure: 150 °C |
| Theoretical spreading rate: | ~ 40,9 m²/kg, 4:1 by weight with PU 955-25 hardener, for 10 µm dry film thickness. ~ 42,4 m²/l, 4:1 by weight with PU 955-25 hardener, for 10 µm dry film thickness. |
| Storage: | For at least 1 year 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: | < 560 g/l. |
| Processing conditions: | From + 10 °C and up to 80 % relative humidity. Ensure adequate air ventilation. |
| Substrate preparation: | <p>Please consider:</p> <p>The following Mipa coating recommendations refer to general product properties of Mipa EP 175-20 and Mipa EA 184-20 and may differ from Bundeswehr or other military coating instructions.</p> <p>Generally, when painting devices of Bundeswehr or others, corresponding paint prescriptions and required coating structures must always be adhered to.</p> <p>We therefore strongly recommend consulting your technical advisor or our application technology department before carrying out any painting work on military equipment.</p> <p>Remove oil, grease, rust, mill scale, rolling skins, as well as other substances impairing the function of the coating!</p> <p>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.</p> <p>Steel:</p> <ul style="list-style-type: none">- 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. <p>Zinc substrates:</p> <ul style="list-style-type: none">- Clean the surface with the ammonia solution Mipa Zinkreiniger.- Sweep blast. <p>Aluminium:</p> <ul style="list-style-type: none">- Degrease with Mipa 2K-Verdünnung, sand thoroughly with sandpaper P 360/400 and clean subsequently with Mipa Silikonentferner. |

Proposed coating structure: 3-coat-system

Steel, zinc substrates, aluminium:

Priming coat: EP 175-20 accord. to TL 8010-0001 class II, type 4 with 40 - 60 µm dry film thickness or EA 184-20 accord. to TL 8010-0001 class II, type 3 with 40 - 60 µm dry film thickness.

Finishing coat: camouflage coating PU 246-XX, PU 247-XX.

Clear coat: PU 850-05 with 40 - 60 µm dry film thickness.

Special notes:

For professional use only.

The gloss level may be higher or lower depending on the thickness of the coat, drying and color of the base coat.

Stir well before use.

When exposed to heat during storage, the product may dry in the headspace of the container. These whitish layers cannot be dissolved completely by stirring. We therefore recommend using a pre-filter with mesh size < 55 µm.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.