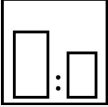








Intended use

High-quality 2-component clearcoat based on acrylic resin, with an excellent surface finish and excellent matt effect for high-quality industrial painting and automotive series painting.

Processing instructions

	Mixing ratio hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)					
	PU 985-25	3 : 1	3 : 1					
	Hardener	Mipa PU 985-25 2K-PU-Härter						
	Pot life	with -25, approx. 3 h at 20 °C						
	Thinner	Mipa 2K-Verdünnung V 10, V 25, V 40						
	Processing viscosity	Ready for use after addition of hardener, if necessary thin with Mipa 2K-Verdünnung.						
	gravity spray gun	Airmix/Airless						
	–	–						
	Application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution		
	gravity spray gun / HVLP	–	2,0 - 2,5	1,5	2 - 3	0 %		
	Drying time	hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
	–	80 °C	–	–	48 min	–	–	
	–	Infrared drying shortwave at 80 °C	–	30 min	–	–	–	

Fully cured after 10 days (20 °C).

Note

Characteristics:	binder base:	polyurethane acrylic system
	solids content (% by weight):	~ 40
	solids content (% by volume):	~ 38
	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):	5 - 10 matt

Version: en 1/0124

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 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:	~ 50,1 m ² /kg, 3:1 by weight with PU 985-25 hardener, for 10 µm dry film thickness ~ 53,1 m ² /l, 3:1 by weight with PU 985-25 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:	< 569 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 metal substrate. steel: - 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 zincd substrates: - clean the surface with the ammonia solution Mipa Zinkreiniger - sweep blast aluminium: - 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, zincd substrates: priming coat: *EP 100-20 with 50 - 70 µm dry film thickness finishing coat: *BC 200-30 / WBC 2000-30 with 15 - 20 µm dry film thickness clear coat: PU 850-10 with 40 - 50 µm dry film thickness aluminium: priming coat: *EP 100-20 with 25 - 30 µm dry film thickness finishing coat: *BC 200-30 / WBC 2000-30 with 15 - 20 µm dry film thickness clear coat: PU 850-10 with 40 - 50 µm dry film thickness

Special notes:

*Further Mipa coats are available. Please contact your technical adviser or our application technicians.

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.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.