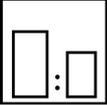


Intended use

Fast drying single-layer spray paint to coat constructions (halls, pipes, doors, wall and ceiling panels, recipients, vehicle constructions) made of steel, zinc steel and aluminium. For interior and exterior use.

Processing instructions

| | | | |
|---|---------------------|---------------------------------------|---------------------------------------|
|  | Mixing ratio | | |
| | hardener | by weight (lacquer : hardener) | by volume (lacquer : hardener) |
| | -- | -- | -- |

| | | |
|---|-----------------|----|
|  | Hardener | -- |
|---|-----------------|----|

| | | |
|---|-----------------|------------------------------|
|  | Pot life | 2 days with Härterverdünnung |
|---|-----------------|------------------------------|

| | | |
|---|----------------|--|
|  | Thinner | Mipa UN Verdünnung Mipa Verdünnung UN 21 Mipa Härterverdünnung |
|---|----------------|--|

| | | |
|---|-----------------------------|-----------------------|
|  | Processing viscosity | |
| | gravity spray gun | Airmix/Airless |
| | -- | -- |

| | | | | | | |
|---|---------------------------------------|-----------------|------------------------|--------------------|---------------------|-----------------|
|  | Application mode | | | | | |
| | application mode | hardener | pressure (bar) | nozzle (mm) | spray passes | dilution |
| | gravity spray gun/ HVLP | -- | 2,0 - 2,5 | 1,3 - 1,5 | 2 - 4 | 10 - 15 % |
| | Airmix / Airless compound pressure | -- | 1,0 - 2,0 100 - 120 | 0,28 - 0,33 | 1 | 0 - 5 % |

| | | | | | | | |
|---|--------------------|---------------------------|-----------------|---------------------|---------------------------|-----------------|-------------------|
|  | Drying time | | | | | | |
| | hardener | object temperature | dust dry | set to touch | ready for assembly | sandable | recoatable |
| | -- | 20 °C | 10 - 15 min | 20 - 30 min | 2 - 3 h | -- | 10 min |
| | -- | 60 °C | -- | 30 min | 30 min | -- | 5 min |

Fully cured after 4 - 5 days (at 20 °C).

Note

| | | |
|-------------------------|---|--------------------|
| Characteristics: | binder base: | vinyllic copolymer |
| | solids content (% by weight): | ~ 56 |
| | solids content (% by volume): | ~ 37 |
| | delivery viscosity DIN 53211 4 mm (in s): | 70 - 90 |
| | density DIN EN ISO 2811 (kg/l): | ~ 1,3 |
| | gloss level ISO 2813 at 60° (GU): | 35 - 45 semi-gloss |

| | |
|------------------------------------|--|
| Properties: | electrostatic application possible highly water-resistant short drying time heat resistance: - short-term heat exposure: 90 °C - permanent heat exposure: 70 °C adhesion to steel, zinc-coated steel, aluminium and concrete |
| Theoretical spreading rate: | ~ 32,9 m ² /kg for 10 µm dry film thickness ~ 37,5 m ² /l for 10 µm dry film thickness |
| Storage: | For at least 3 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: | < 570 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 zinc-coated 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 mineral substrates (concrete, plaster): - mineral substrates (set, dimensionally stable, rough and solid) must be free from friable parts and other substances that may affect the adhesion (e.g. rubber marks, greases, oils, rust, dust and similar) |

Proposed coating structure: single coat system
steel, zincd substrates, aluminium:
VC 200- 50 with 50 - 70 µm dry film thickness

2-coat system
steel, zincd substrates:
priming coat: *VB 100-20 min 20 - 30 µm or EP 100-20 with 50 - 70 µm dry film thickness
finishing coat: VC 200-50 with 50 - 60 µm dry film thickness

aluminium:
priming coat: *VB 100-20 min 20 - 30 µm or EP 100-20 with 25 - 30 µm dry film thickness
finishing coat: VC 200-50 with 50 - 60 µm dry film thickness

concrete/ mineral substrates
priming coat: VC 200-50 with 10 - 20 µm dry film thickness
finishing coat: VC 200-50 with 50 - 60 µm dry film thickness

Special notes: *Further Mipa primers are available. Please contact your technical adviser or our application technicians.

For professional use only.

The details of the paragraphs - Proposed coating structure, Characteristics, Theoretical spreading rate, VOC - refer to the colour shade RAL 7035. For other colour shades, these may deviate.

Due to the system there might be signs of chalking in the event of exposure to high UV and weathering stress. Furthermore, thermoplastic behaviour of the coating is observed at higher temperatures.

Check colour shade prior to application.

Cleaning of tools: Clean tools immediately after use with Mipa Nitroverdünnung.