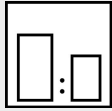


Intended use

2K polyurethane acrylic paint with long open time. Monolayer paint with good vertical stability, very good surface hardness and scratch resistance. Suitable for coating commercial vehicles as well as highly stressed machines and constructions.

Processing instructions**Mixing ratio****hardener**
PU 900-25, PU 912-XX,
PU 933-10

A 60

by weight (lacquer : hardener)

2 : 1

4 : 1

by volume (lacquer : hardener)

1 : 1

3 : 1

**Hardener**

Mipa PU 900-25, PU 912-10, PU 912-25, PU 912-40, PU 933-10

Mipa PUR Plus-Härter A 60

**Pot life**

with hardener -10 approx. 2 h at 20 °C

with hardener A 60 approx. 6 h at 20 °C

**Thinner**

Mipa 2K-Verdünnung V 10, V 25, V 40

**Processing viscosity****gravity spray gun**

20 - 25 s 4 mm DIN

Airmix/Airless

20 - 25 s 4 mm DIN

**Application mode****application mode**gravity spray gun/
HVLPAirmix / Airless
compound pressure

paint brush, roller*

hardener

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A 60

**pressure
(bar)**

2,0 - 2,5

1,0 - 2,0
100 - 120

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**nozzle
(mm)**

1,2 - 1,3

0,23 - 0,28

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**spray
passes**

2 - 4

1

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dilution

0 - 5 %

0 - 5 %

5 - 10 %

**Drying time****hardener**

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**object
temperature**

20 °C

60 °C

dust dry

30 - 45 min

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**set to
touch**

3 - 4 h

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**ready for
assembly**

16 h

40 min

sandable

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recoatable

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Fully cured after 7 - 8 Tagen (20 °C).

Note

Characteristics:	binder base:	polyurethane acrylic system
	solids content (% by weight):	~ 72
	solids content (% by volume):	~ 57
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	~ 1,4
	gloss level ISO 2813 at 60° (GU):	> 80 glossy
Properties:	electrostatic application possible	
	highly UV- and weather-resistant	
	very good water resistance	
	solvent-resistant	
	heat resistance:	
	- short-term heat exposure: 180 °C	
	- permanent heat exposure: 150 °C	
	adhesion to steel and zinc-coated substrates	
	adhesion to aluminium: Gt 1	
Theoretical spreading rate:	~ 51,5 m²/kg, 4:1 by weight with A 60, for 10 µm dry film thickness	
	~ 61,2 m²/l, 4:1 by weight with A 60, for 10 µm dry film thickness	
	~ 39,0 m²/kg, 2:1 by weight with PU 900-25, for 10 µm dry film thickness	
	~ 41,9 m²/l, 2:1 by weight with PU 900-25, 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:	< 360 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	

Proposed coating structure: single coat system
steel, zincd substrates, aluminium:
PU 255-90 with 60 - 70 µm dry film thickness

2-coat system
steel, zincd substrates:
priming coat: ***EP 100-20 with 50 - 70 µm dry film thickness
finishing coat: PU 255-90 with 50 - 60 µm dry film thickness

aluminium:
priming coat: ***EP 100-20 with 25 - 30 µm dry film thickness
finishing coat: PU 255-90 with 50 - 60 µm dry film thickness

Special notes:

*Suitable: E.g. mohair, nap, velour, Glattfilt, Rolloplan, foam paint roller, roller for radiators UniPlan.

**This product has the following maximum VOC-values:

- Applied by spraying/ rolling with Härter A 60: < 420 g/l of VOC.
- Applied by spraying with hardener PU 900-25, PU 912-XX, PU 933-10: < 530 g/l of VOC.

***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.

Especially UV-resistant pigmentations (e.g. pastel shades for facades) are available on request.

Check colour shade prior to application.

In case of application by means of an Airmix/Airless device, it is recommended testing beforehand the equipment for its suitability. If micro foam or bubbling emerge during the application with an Airmix/Airless device, it is recommended adding more thinner or using the additives 2K-Systemzusatz PUA and PUS. Furthermore, the film thickness should be kept as low as possible.

To optimise the flow properties and to reduce blistering when applying by roller, we recommend adding 5 % of Mipa 2K-Systemzusatz PUS before the crosslinking.

If required we also offer hardeners and cleaning agents that are suitable for 2-component mixing and dosing units. Please contact your technical adviser or our application technicians.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.