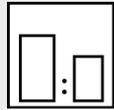


### Intended use

Fast drying 2K polyurethane acrylic paint for industrial coating of machines, components, constructions, agricultural machinery and construction vehicles.

### Processing instructions



#### Mixing ratio

##### hardener

-25

##### by weight (lacquer : hardener)

5 : 1

##### by volume (lacquer : hardener)

5 : 1



#### Hardener

Mipa PU 900-25, PU 950-25



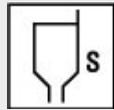
#### Pot life

with Härter -25 approx. 6 - 8 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

25 - 35 s 4 mm DIN



#### Application mode

##### application mode

##### hardener

##### pressure (bar)

##### nozzle (mm)

##### spray passes

##### dilution

gravity spray gun/  
HVL P

–

2,0 - 2,5

1,2 - 1,3

2 - 4

10 - 15 %

Airmix / Airless  
compound pressure

–

1,0 - 2,0  
100 - 120

0,23 - 0,28

1

0 - 10 %



#### Drying time

##### hardener

##### object temperature

##### dust dry

##### set to touch

##### ready for assembly

##### sandable

##### recoat able

–

20 °C

20 - 25 min

2 - 3 h

6 - 8 h

–

–

–

60 °C

–

–

30 min

–

–

Fully cured after 5 - 6 days (20 °C)

### Note

#### Characteristics:

binder base:

polyurethane acrylic system

solids content (% by weight):

~ 64

solids content (% by volume):

~ 45

delivery viscosity DIN 53211 4 mm (in s):

150 - 160

density DIN EN ISO 2811 (kg/l):

~ 1,4

gloss level ISO 2813 at 60° (GU):

50 - 60 semi-gloss

- Properties:** short drying time  
electrostatic application possible  
highly water-resistant  
highly UV- and weather-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 :** ~ 36,6 m<sup>2</sup>/kg, 5:1 by weight with PU 900-25, bei 10 µm Trockenschichtdicke  
~ 42,8 m<sup>2</sup>/l, 5:1 by weight with PU 900-25, bei 10 µm Trockenschichtdicke
- 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:** < 450 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
- glass:  
- Before coating, it is indispensable to determine definitely the recoatable glass surface (e.g. by means of an appropriate measure device to determine the tin side of float glass) because it is generally impossible to coat the side which came in contact with the tin bath.  
- degrease with Mipa WBS Reiniger or Mipa Silikonentferner

**Proposed coating structure:** single coat system  
steel, zincd substrates, aluminium:  
PU 200-50 with 50 - 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 200-50 with 50 - 60 µm dry film thickness

aluminium:  
priming coat: \*EP 100-20 with 25 - 30 µm dry film thickness  
finishing coat: PU 200-50 with 50 - 60 µm dry film thickness

glass:  
pretreatment: 1K-Glasprimer  
finishing coat: PU 200-50 incl. PU 950-25 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.

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

Check colour 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 blistering 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.

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.