PU 330-20 2K-PU-Strukturbeschichtung

Technical data sheet

Intended use

Highly stressable 2K polyurethane acrylic paint to give a scratch-resistant and robust coating to transport and floor surfaces and to highly stressed surfaces of commercial vehicles, construction machinery, agricultural vehicles and equipment etc.

Possible fields of application:

- driver's cab and bodies of commercial vehicles
- floor and storage surfaces of commercial vehicles and working platforms
- rims, underbody and chassis areas
- impact protection, roof rack, spare wheel covers etc.
- wheelhouse area
- drive-on ramps, transport surfaces of towing vehicles and trailers
- boat decks and superstructures

Mipa PU 330-20 provides extremely high wear resistance as well as excellent mechanical and chemical resistance. The very high vertical stability allows extremely high-build applications.

Processing instructions

Mixing ratio

hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
PU 912-XX	4 : 1	3 : 1

Hardener

Mipa PU 912-10, PU 912-25

Pot life

with hardener -10 approx. 1 - 1,5 h at 20°C

Thinner

Mipa 2K-Verdünnung V 10, V 25, V 40

Processing viscosity

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

gravity spray gun	Airmix/Airless
thixotropic	--

Application mode

application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
gravity spray gun/ HVLP	--	2,0 - 3,0	2,5 - 3,0	2 - 3	0 %
paint pressure gun compound pressure	--	2,0 - 2,5 0,5 - 0,8	2,5 - 3,0	2 - 3	0 %
UBS gun	--	3 - 4	--	2 - 3	0 %

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Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	15 - 20 min	3 - 4 h	24 h	--	--
--	60 °C	--	30 min	1 - 2 h	--	--

Fully cured after 5 - 6 days (at 20 °C).

Note

Characteristics:

binder base:	polyurethane acrylic system
solids content (% by weight):	~ 59
solids content (% by volume):	~ 43
delivery viscosity DIN 53211 4 mm (in s):	thixotropic
density DIN EN ISO 2811 (kg/l):	~ 1,3
gloss level ISO 2813 at 60° (GU):	Matt*

Properties:

highly UV- and weather-resistant
excellent shock and scratch resistance
highly reisistant to fuels and oils
very googd water resistance
heat resistance:
- short-term heat exposure: 180 °C
- permanent heat exposure: 150 °C

Theoretical spreading rate:

~ 34,6 m²/kg, 4:1 by weight with PU 912-25, for 10 µm dry film thickness
~ 38,5 m²/l, 4:1 by weight with PU 912-25, 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:

< 500 g/l.

Processing conditions:

From + 10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.

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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

zinced 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

wooden substrates:
- clean, sand slightly and free from dust

GRP:
- clean, sand slightly and degrease with Mipa Silikonentferner

faultless, old 2K-resistant paintworks:
- clean, sand slightly and degrease with Mipa Silikonentferner

Proposed coating structure:

single coat system
GRP, faultless, old 2K-resistant paintworks:
PU 330-20 with 100 - 380 µm dry film thickness

2-coat system
steel, zinced substrated, GRP, faultless, old 2K-resistant paintworks:
priming coat: **EP 100-20 with 50 - 70 µm dry film thickness
finishing coat: PU 330-20 with 100 - 380 µm dry film thickness

aluminium:
priming coat: **EP 100-20 with 25 - 30 µm dry film thickness
finishing coat: PU 330-20 with 100 - 380 µm dry film thickness

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Special notes:

*Due to the special surface, a measurement according to DIN EN ISO 2813 is inappropriate!

**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.

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.

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