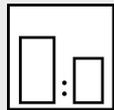


Intended use

Two-component zinc phosphate epoxy acrylic primer for coating steel, zinced substrates, aluminium, GRP and e-coatings. Its outstanding filling power and resistance to solvents and chemical agents make this product particularly suitable for high-quality coating of highly stressed installations and devices. Furthermore, this primer can be overcoated with Mipa 2K topcoats after a drying of only 20 minutes at room temperature.

Processing instructions



Mixing ratio

hardener

PU 914-XX

by weight (lacquer : hardener)

6 : 1

by volume (lacquer : hardener)

4 : 1



Hardener

Mipa PU 914-10, PU 914-25



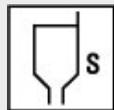
Pot life

with hardener-10 approx. 2,5 - 3 h at 20 °C



Thinner

Mipa 2K-Verdünnung V 10, V 25, V 40



Processing viscosity

gravity spray gun

30 - 40 s 4 mm DIN

Airmix/Airless

50 - 60 s 4 mm DIN



Application mode

application mode

gravity spray gun/
HVLP

hardener

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pressure (bar)

2,0 - 2,5

nozzle (mm)

1,5 - 1,8

spray passes

2 - 3

dilution

10 - 20 %

Airmix / Airless
compound pressure

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1,0 - 2,0
100 - 120

0,28 - 0,33

1 - 2

< 10 %



Drying time

hardener

-10

-10

-25

-25

object temperature

20 °C

60 °C

20 °C

60 °C

dust dry

20 - 30 min

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approx. 50 min

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set to touch

60 - 90 min

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approx. 2 h

--

ready for assembly

24 h

1 h

24 h

1 h

sandable

5 h

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12 h

--

recoatible

20 min

--

40 min

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Note

Characteristics:	binder base: epoxy acrylic resin solids content (% by weight): ~ 80 solids content (% by volume): ~ 60 delivery viscosity DIN 53211 4 mm (in s): thixotropic density DIN EN ISO 2811 (kg/l): ~ 1,8 gloss level ISO 2813 at 60° (GU): < 20 matt
Properties:	Early recoatability Excellent corrosion protection, contains zinc phosphate Outstanding filling properties Recoatible wet-on-wet Very good spray mist absorption Highly elastic film, good impact strength Excellent resistance to solvents and chemical agents Heat resistance: - Short-term heat exposure: 180 °C - Permanent heat exposure: 150 °C Adhesion on steel, zined substrates, aluminium, GRP, e-coatings
Theoretical spreading rate:	~ 37,6 m ² /kg, 6:1 by weight with PU 914-10, for 10 µm dry film thickness. ~ 55,5 m ² /l, 6:1 by weight with PU 914-10, for 10 µm dry film thickness.
Storage:	For at least 2 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:	< 375 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 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. Zined 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. GRP: - Clean (remove completely any mould release agents), if necessary, sand slightly and degrease with Mipa Silikonentferner. E-coating: - Clean, slightly sand and degrease with Mipa Silikonentferner.

Proposed coating structure: Steel, zincd substrates, aluminium, e-coating, GRP:
Priming coat: EA 100-20 with 70 - 110 µm dry film thickness or with 40 - 60 µm dry film thickness on aluminium.
Finishing coat: **PU 200-XX / PU 240-XX with 50 - 60 µm dry film thickness.

Special notes:

*This product has the following maximum VOC-values:
- Applied by spraying with 2K-PU-Härter PU 914-XX: < 480 g/l of VOC.

**Further Mipa topcoats 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.

Recoatable at the earliest after 20 min at 20 °C and at the latest after 4 weeks. After drying for more than 4 weeks, intermediate sanding is required.

Can be overcoated with putty after 60 minutes at 60 °C.

If required we also offer 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.