Intended use

High heat-resistant special coating based on silicon resin that is perfectly suitable to be applied on steel substrate like e.g. exhaust systems, ovens, barbecue grills, and so on. Heat resistance up to 800°C.

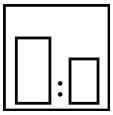
Spreading rate: 9,0 - 12,0 m²/l

Processing instructions

Colour

silver

black



Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
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Hardener

for complete paintwork	for partial paintwork
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Pot life

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Thinner

ready to use

Spray viscosity

gravity spray gun	Airmix/Airless
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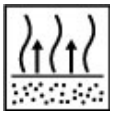
Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	dilution (%)
gravity spray gun (high pressure)	--	2 - 2,5	1,3 - 1,5	2	--
HVLP (low pressure)	--	2 - 2,2	1,3 - 1,5	2	--
HVLP / internal nozzle pressure	--	0,7	--	--	--
Airmix / Airless	--	100 - 120	0,23 - 0,28	1 - 2	--



Flash-off time

5 - 8 min between coats

10 - 15 min before oven drying

Dry coat thickness

15 - 20 µm

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Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	30 - 60 min	5 h*	24 h	--	--
60 °C	10 - 15 min	40 - 60 min*	after cooling	--	--

Note

Storage: at least 2 years in unopened original container

VOC Regulation: EU limit value for this product (category B/e): 840 g/l
This product contains max. 750 g/l of VOC.

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

Processing instructions: Surface preparation:

The surface must be clean and dry.

Remove all oil, grease, rust, mill scale, scale, and other substances that could impair the function and the paint finish!

Steel substrates:
1. Pre-clean with Mipa Silikonentferner.
2. Then pre-sand with P 120 and final sand with P 220 - 320.
3. Then degrease with Mipa Silikonentferner.

Since Mipatherm is applied in a dry film thickness of 15 - 20 µm, the substrate must not be sanded too roughly. Blasting is not recommended as a pre-treatment method.

Reason for this: The resulting rough steel surface can no longer be covered to form a film, which can lead to premature corrosion.

General information:

*Restricted touch resistance means: Light chalking is still possible. The coating is still sensitive to mechanical and chemical stress. Therefore, careful handling of the painted objects is necessary.

Conditional resistance: Conditional solvent resistance (temporary exposure) is achieved after approximately 1 - 2 hours at 200 °C. The coating is then also less sensitive to mechanical and chemical stress.

Optimal film properties and full chemical and mechanical resistance are achieved after the first heat exposure of approximately 1 hour at a minimum of 300 °C.

To avoid blistering due to excessively rapid heat exposure, appropriately long final flash-off times must be observed, or the temperature rise should be as slow as possible.

Brush and roller application are only possible to a limited extent.

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