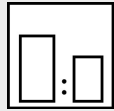


Intended use

High-solid 2K polyurethane-acrylic high-build paint in HS-quality for industrial coatings with high film build for machines, construction components, constructions and constructions machines. For interior and exterior use.

Processing instructions



Mixing ratio

hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
PU 914-XX	6 : 1	4 : 1
PU 916-XX	8 : 1	6 : 1



Hardener

Mipa PU 914-10, PU 914-25, PU 914-40
Mipa PU 916-10, PU 916-25



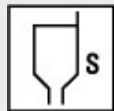
Pot life

with hardener -10 approx. 1 h at 20 °C
with hardener -40 approx. 5 h at 20 °C



Thinner

ready for use after addition of hardener, if necessary thin with Mipa 2K-Verdünnung



Spray viscosity gravity spray gun

thixotropic

Airmix/Airless

thixotropic



Application mode

application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
gravity spray gun/ HVLV	–	2,0 - 2,2	1,5 - 2,5	2	0 %
Airmix / Airless	–	100 - 120	0,23 - 0,33	1	0 %



Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
–	20 °C	20 - 25 min	1 - 2 h	24 h	–	–
–	60 °C	–	–	30 min	–	–

Fully cured after 5 - 6 days (20 °C).

Note

Characteristics:

binder base:	polyurethane acrylic system
solids content (% by weight):	68 - 74
solids content (% by volume):	50 - 54
delivery viscosity DIN 53211 4 mm (in s):	thixotropic
density DIN EN ISO 2811 (kg/l):	1,3 - 1,5
gloss level ISO 2813 at 60° (GU):	40 - 50 semi-gloss

- Properties:**
- electrostatic application possible
 - highly UV- and weather-resistant
 - very good water resistance, solvent resistant
 - highly resistant to fuels and oils
 - high vertical stability (up to approx. 250 µm dry film thickness)
 - heat resistance:
 - short-term heat exposure: 180°C
 - permanent heat exposure: 150°C
 - adheres on steel
 - adhesion on zinced substrates: Gt 0-1
- Theoretical spreading rate :** 37,8 - 39,8 m²/kg, 8:1 by weight with PU 916-25, for 10 µm dry film thickness
52,2 - 55,0 m²/l, 8:1 by weight with PU 916-25, for 10 µm dry film thickness
36,1 - 38,2 m²/kg, 6:1 by weight with PU 914-25, for 10 µm dry film thickness
49,2 - 51,3 m²/l, 6:1 by weight with PU 914-25, for 10 µm dry film thickness
- Storage:** at least 3 years in unopened original container.
- VOC Regulation :** EU limit value according to Directive 2004/42/EC for this product (category A/j): 500 g/l.
This product contains the following maximum VOC-values:
applied by spraying with hardener PU 916-XX: < 440 g/l of VOC
applied by spraying with hardener PU 914-XX: < 460 g/l of VOC
- 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
- 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

Proposed coating structure: single coat system
steel, zincd substrates:
PU 264-50 with 80 - 150 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 264-50 mit 80 - 150 µm dry film thickness

aluminium:
priming coat: *EP 100-20 with 25 - 30 µm dry film thickness
finishing coat: PU 264-50 with 80 - 150 µm dry film thickness

3-coat system
steel, zincd substrates:
priming coat: *EP 100-20 with 50 - 70 µm dry film thickness
intermediate coat: EP 564-20 with 80 - 150 µm dry film thickness
finishing coat: PU 264-50 with 80 - 150 µm dry film thickness

*Further Mipa primers are available. Please contact your technical adviser or our application technicians.

Special notes:

For professional use only.

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

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 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.

Depending on the hardener in use and on the processing condition, the gloss level may prove to be higher or lower. The mentioned data refer to the hardener of series: PU 914-XX.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.