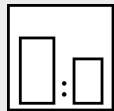


Intended use

2K polyurethane micaceous iron coating according to TL 918 300, sheet 87, can be used as topcoat within the anti-corrosion coating system for steel, zinc-coated substrates and aluminium. Designed as top coating for bridges, railings, docks, piping and structures in aggressive atmosphere as well as for areas exposed to sewage and seawater. Durable corrosion protection and decorative effect.

Processing instructions



Mixing ratio

hardener

H, MS

by weight (lacquer : hardener)

5 : 1

by volume (lacquer : hardener)

3 : 1



Hardener

Mipa H 10, H 25, MS 25, MS 40



Pot life

with hardener -10 approx. 1.5 h at 20 °C

with hardener -40 approx. 8 h at 20 °C



Thinner

Mipa 2K-Verdünnung



Spray viscosity

gravity spray gun

20 - 30 s 4 mm DIN

Airmix/Airless

30 - 40 s 4 mm DIN



Application mode

application mode

hardener

pressure (bar)

nozzle (mm)

spray passes

dilution

gravity spray gun/
HVLP

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2,0 - 2,5

1,8 - 2,0

2

20 - 25 %

Airmix / Airless

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100 - 120

0,33 - 0,53

1

10 - 15 %

paint brush, roller

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5 - 10 %



Drying time

hardener

object temperature

dust dry

set to touch

ready for assembly

sandable

recoatable

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20 °C

25 - 30 min

50 - 60 min

10 - 12 h

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60 °C

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30 min

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

Note

Characteristics:	binder base:	polyurethane acrylic system
	solids content (% by weight):	78 - 80
	solids content (% by volume):	52 - 55
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	1,8 - 1,9
	gloss level ISO 2813 at 60° (GU):	matt*
Properties:	highest corrosion protection, abrasion-resistant, viscoelastic highly UV- and weather-resistant excellent resistance to chemical and mechanical strains heat resistance: - short-term heat exposure: 180°C - permanent heat exposure: 150°C	
Theoretical spreading rate :	23,7 - 23,8 m ² /kg, 5:1 by weight with MS 25, for 10 µm dry film thickness 38,8 - 40,2 m ² /l, 5:1 by weight with MS 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 the product categories A/j = 500 g/l and B/e 840 g/l. This product has the following maximum VOC-values: applied by brush/roller with hardener H, MS: < 500 g/l of VOC applied by spraying with hardner H, MS: < 550 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 zincd 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: 2-coat system
steel, zincd substrates:
priming coat: **EP 100-20 with 50 - 70 µm dry film thickness
finishing coat: PU 500-20 with 50 - 60 µm dry film thickness

aluminium:
priming coat: **EP 100-20 with 25 - 30 µm dry film thickness
finishing coat: PU 500-20 with 50 - 60 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 500-20 with 60 - 80 µm dry film thickness (maximum corrosion protection with 140 - 160 µm DFT)
finishing coat: PU 500-20 with 50 - 60 µm dry film thickness
in case of permanent exposure to water
steel
priming coat: **2K-Zinkstaubfarbe with 60 - 80 µm dry film thickness
intermediate coat: EP 500-20 with 60 - 80 µm dry film thickness (maximum corrosion protection with 140 - 160 µm DFT)
finishing coat: PU 500-20 with 50 - 60 µm dry film thickness

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

Special notes:

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

For professional use only.

In order to achieve optimum iron mica effects and to avoid strips, it is advisable to spray the finishing coat or to roll or paint in only one direction.

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 bubbling 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.