

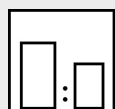
### Intended use

This high-quality zinc dust coating ensures long-term cathodic corrosion protection and can be applied only on bare, completely rust-free steel that has been blasted to cleaning degree Sa 2½.

Recoatable with Mipa 2K EP and 2K PU paint systems complying with coating structures for corrosion protection as described in DIN EN ISO 12944.

Registered according to Bundeswehr (German army) TL 8010-0012, class B, type 3

### Processing instructions



#### Mixing ratio

##### hardener

H

H

##### by weight (lacquer : hardener)

19 : 1

10:1 (for better spray mist absorption when applying on larger surfaces and/or by means of electrostatics)

##### by volume (lacquer : hardener)

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#### Hardener

Mipa H 10, H 25



#### Pot life

10 - 12 h



#### Thinner

Mipa 2K-Verdünnung



#### Spray viscosity

##### gravity spray gun

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##### Airmix/Airless

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#### Application mode

##### application mode

gravity spray gun/  
HVLP

Airmix / Airless

##### hardener

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##### pressure (bar)

2,0 - 2,5

100 - 120

##### nozzle (mm)

1,3 - 1,5

0,28 - 0,33

##### spray passes

2

1 - 2

##### dilution

5 - 10 %

0 - 5 %



#### Drying time

##### hardener

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##### object temperature

20 °C

##### dust dry

20 - 30 min

##### set to touch

2,0 - 2,5 h

##### ready for assembly

12 h

##### sandable

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##### recoatable

4 h\*

### Note

<b>Characteristics:</b>	binder base: modified epoxy resin solids content (% by weight): 82 - 85 solids content (% by volume): 50 - 54 delivery viscosity DIN 53211 4 mm (in s): 90 - 110 density DIN EN ISO 2811 (kg/l): 2,5 - 2,7 gloss level ISO 2813 at 60° (GU): matt
<b>Properties:</b>	very high active corrosion protection (cathodic) electrostatic application possible resistant to permanent heat exposure up to max. 400 °C adhesion on blasted steel
<b>Theoretical spreading rate :</b>	17,2 - 21,5 m <sup>2</sup> /kg, 19:1 by weight with H 25, for 10 µm dry film thickness 39,6 - 46,0 m <sup>2</sup> /l, 19:1 by weight with H 25, for 10 µm dry film thickness recommended dry film thickness: 30 - 60 µm
<b>Storage:</b>	at least 2 years in unopened original container.
<b>VOC Regulation :</b>	This product contains the following maximum values: undiluted with 2K-Härter H: < 480 g/l of VOC
<b>Processing conditions:</b>	from+ 10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.
<b>Substrate preparation:</b>	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
<b>Proposed coating structure:</b>	steel (for example: environment category C4 High as per DIN EN ISO 12944) priming coat: 2K-Zinkstaubfarbe with 60 µm dry film thickness above roughness depth intermediate coat: EP 100-20 / EP 164-20 with 160 µm dry film thickness finishing coat: PU 240-XX / PU 250-XX with 60 µm dry film thickness
<b>Special notes:</b>	To get more information about recommended coating structures according to corrosivity categories as per DIN EN ISO 12944 please contact us or have a look at the brochure "Mipa Corrosion protection"!  For professional use only.  Due to the system, zinc dust paints tend to develop more spray mist. Therefore, remove possible overspray either by clean compressed air (free from oil or water) or by a before applying the subsequent coating.  * When applying an epoxy intermediate coat, the solvent retention may retard the drying process which results in a soft intermediate coating surface. To avoid this effect, use an epoxy intermediate coating that has a very slow solvent content (e.g. EP 164-20) or solve the problem by extending the drying time or by forced drying (e.g.. 2 h at 60°C object temperature).
<b>Cleaning of tools:</b>	Clean tools immediately after use with Mipa Nitroverdünnung.