

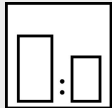
Intended use

Fast drying special paint based on plastic reinforced synthetic resins that is particularly resistant to saltwater and humidity.

Colours:

DB 7350 novagrau SG, RAL 9005 black GL, RAL 9011 MAN graphite-black SG

Processing instructions



Mixing ratio

hardener

by weight (lacquer : hardener)

by volume (lacquer : hardener)

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Hardener

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Pot life

2 days with Härterverdünnung



Thinner

Mipa UN-Verdünnung

Mipa Verdünnung UN 21

Mipa Härterverdünnung



Spray viscosity gravity spray gun

18 - 22 s 4 mm DIN

Airmix/Airless

40 - 60 s 4 mm DIN



Application mode

application mode

hardener

pressure
(bar)

nozzle (mm)

spray
passes

dilution

gravity spray gun/
HVLP

—

2,0 - 2,5

1,2 - 1,5

2 - 3

15 - 20 %

Airmix / Airless

—

100 - 120

0,23 - 0,28

2

10 %



Drying time

hardener

object
temperature

dust dry

set to
touch

ready for
assembly

sandable

recoatable

—

20 °C

30 - 60 min

5 - 6 h

16 h

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60 °C

10 - 15 min

40 - 60 min after cooling

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before drying at higher temperature, allow flash-off of 10 - 15 minutes

Note**Characteristics:**

binder base:	modified alkyd resins
solids content (% by weight):	52 - 55
solids content (% by volume):	43 - 47
delivery viscosity DIN 53211 4 mm (in s):	100 - 120
density DIN EN ISO 2811 (kg/l):	1,0 - 1,2
gloss level ISO 2813 at 60° (GU):	depends on the colour

Properties:

short drying time
good hiding power
highly UV- and weather-resistant
excellent vertical stability
excellent flow, high final hardness, stable gloss
resistant to fuels and diesel if exposed temporarily
particularly resistant to saltwater and humidity
heat resistance:
- short-term heat exposure: 150 °C
- permanent heat exposure: 130 °C

Theoretical spreading rate : 43,0 - 45,2 m²/kg for 10 µm dry film thickness
44,1 - 46,4 m²/l for 10 µm dry film thickness

Storage:

at least 3 years in unopened original container.

VOC Regulation :

This product has the following maximum VOC-values:
undiluted: < 500 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

Proposed coating structure: steel:

priming coat: *AK 100-20 / AK 105-20 with 50 - 60 µm dry film thickness
finishing coat: Mipalin FG-Spezial-Chassislack with 50 - 60 µm dry film thickness

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

Special notes:

For professional use only.

Applying too thick layers may extend considerably the drying time.

Depending on the colour, the delivery viscosity may vary. Adjust the viscosity by adding thinner.

Check colour before use.

Cleaning of tools: Clean tools immediately after use with Mipa Nitroverdünnung.