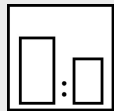


Intended use

Two-component zinc phosphate epoxy acrylic primer for coating steel, zinced substrates, aluminium, GRP and e-coatings. Its outstanding filling power and resistance to solvents and chemical agents make this product particularly suitable for high-quality coating of highly stressed installations and devices. Furthermore, this primer can be overcoated with Mipa 2K topcoats after a drying of only 20 minutes at room temperature.

Processing instructions



Mixing ratio

hardener

PU 914-10

by weight (lacquer : hardener)

6 : 1

by volume (lacquer : hardener)

4 : 1



Hardener

Mipa PU 914-10



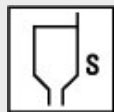
Pot life

with Härter-10 approx. 2,5 - 3 h at 20°C



Thinner

Mipa 2K-Verdünnung



Spray viscosity

gravity spray gun

30 - 40 s 4 mm DIN

Airmix/Airless

50 - 60 s 4 mm DIN



Application mode

application mode

gravity spray gun/
HVLP

Airmix / Airless

hardener

–

–

pressure (bar)

2,0 - 2,5

100 - 120

nozzle (mm)

1,5 - 1,8

0,28 - 0,33

spray passes

2 - 3

1 - 2

dilution

10 - 20 %

< 10 %



Drying time

hardener

–

–

object temperature

20 °C

60 °C

dust dry

20 - 30 min

–

set to touch

60 - 90 min

–

ready for assembly

24 h

1 h

sandable

5 h

–

recoatable

20 min

–

Recoatable after 20 minutes and at the latest after 24 hours. After a drying of >24 h, intermediate sanding is necessary!

Note

Characteristics:	binder base:	epoxy acrylic resin
	solids content (% by weight):	74 - 76
	solids content (% by volume):	53 - 55
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	1,5 - 1,6
	gloss level ISO 2813 at 60° (GU):	10 - 20 matt

Properties:	early recoatability
	excellent corrosion protection, contains zinc phosphate
	outstanding filling properties
	recoatible wet-on-wet
	very good spray mist absorption
	highly elastic film, good impact strength
	excellent resistance to solvents and chemical agents
	heat resistance: - short-term heat exposure: 180 °C
	- permanent heat exposure: 150 °C
adhesion on steel, zincd substrates, aluminium, GRP, e-coatings	

Theoretical spreading rate :	35,0 - 37,4 m ² /kg, 6:1 by weight with PU 914-10, for 10 µm dry film thickness
	51,1 - 53,4 m ² /l, 6:1 by weight with PU 914-10, for 10 µm dry film thickness

Storage:	at least 3 years in unopened original container.
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VOC Regulation :	EU limit value according to Directive 2004/42/EC for this product (category B/c): 540 g/l.
	This product has the following maximum VOC-values:
	applied by spraying with 2K-PU-Härter PU 914-10: < 490 g/l of VOC

Processing conditions:	from+ 10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.
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Substrate preparation:	Remove oil, grease, rust, mill scale, rolling skins, as well as other substances impairing the function of the coating!
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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

GRP:

- clean (remove completely any mould release agents), if necessary, sand slightly and degrease with Mipa Silikonentferner

e-coating:

- clean, slightly sand and degrease with Mipa Silikonentferner

Version: en 2/1020

This technical data sheet is supplied for informational purposes only! According to our information, all data and recommendations correspond to the state of art and are based on years of experience in manufacturing our products. They do not exempt the user from his obligation to verify professionally, on his own responsibility, the suitability of our products to the intended purpose under prevailing conditions. Safety data sheets and warnings on packaging must be observed. We reserve the right to modify and to complete the information content at any time, without prior notice or obligation to update.

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Proposed coating structure: steel, zincd substrates, e-coating, GRP:
priming coat: EA 100-20 with 70 - 110 µm dry film thickness
finishing coat: *PU 200-XX / PU 240-XX with 50 - 60 µm dry film thickness

aluminium:
priming coat: EA 100-20 with 40 - 60 µm dry film thickness
finishing coat: *PU 200-XX / PU 240-XX with 50 - 60 µm dry film thickness

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

Special notes: For professional use only.

If required we also offer 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.