



Drying time at 20 °C

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| Dust dry after approx. | 30 - 60 min |
| Set to touch to a limited extent after approx. | 5 h |
| Stress-resistant to a limited extent after approx. | 1 - 2 h at 200 °C |
| Fully resistant after approx. | 1 h at 300 °C |

Processing conditions From +10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.

Storage Can be stored for 2 years in cool and dry places.

VOC-regulation EU limit value for the product (cat. B/e): 840 g/l
This product contains max. 716 g/l of VOC.

Safety information See safety data sheet

Processing instructions

Set to touch to a limited extent means: Slight chalking is still possible. The coating is still sensitive to mechanical and chemical stress. Therefore, it is necessary to handle the painted objects with care.

Stress-resistant to a limited extent means: A limited resistance to solvents (temporary exposure) is achieved after approx. 1 - 2 hours at 200°C. The coating is then less sensitive to mechanical and chemical stress.

Optimum film properties and full chemical and mechanical resistance are achieved after the 1st heat exposure of approx. 1 hour at minimum 300 °C.

To avoid bubbling in case of premature heat exposure, long final flash-off times must be observed or the temperature increase should be as slow as possible.

Substrate preparation:

The substrate must be clean and dry. Remove oil, grease, rust, corrosion as well as any other substances impairing the function of the coating!

Steel substrates:

1. Pre-clean with Mipa Silikonentferner.
2. Then dry sand with P 120 + final sanding with P 220 - 320.
3. Afterwards, degrease with Mipa Silikonentferner