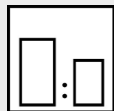


Intended use

High-quality 2K polyurethane acrylic paint to coat commercial vehicles, metal facades and highly stressed surfaces of constructions and machines. Excellent coverage and optimum adjustment for airmix application.

Applied on the chipboards, Mipa PU 242-90 is classified B1 according to the test to determine the fire behaviour as per DIN 4102-1.

Processing instructions



Mixing ratio

| hardener | by weight (lacquer : hardener) | by volume (lacquer : hardener) |
|---|--------------------------------|--------------------------------|
| PU 900-25, PU 912-XX, PU 933-10, PU 950-25 | 3 : 1 | 2 : 1 |
| PU 914-XX | 4 : 1 | 3 : 1 |
| PU 916-XX, A 60, Mipa H-XX | 5 : 1 | 4 : 1 |



Hardener

Mipa PU 900-25, PU 912-10, PU 912-25, PU 912-40, PU 933-10, PU 950-25, Mipa H-XX
Mipa PU 914-10, PU 914-25, PU 914-40
Mipa PU 916-10, PU 916-25
Mipa PUR Plus-Härter A 60



Pot life

with hardener -10 approx. 1 h at 20 °C
with hardener -40 approx. 8 h at 20 °C



Thinner

Mipa 2K-Verdünnung V 10, V 25, V 40



Processing viscosity

| gravity spray gun | Airmix/Airless |
|--------------------|--------------------|
| 20 - 25 s 4 mm DIN | 20 - 25 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 - 1,3 | 2 - 4 | 10 - 15 % |
| Airmix / Airless compound pressure | – | 1,0 - 2,0 100 - 120 | 0,23 - 0,28 | 1 | 10 - 15 % |



Drying time

| hardener | object temperature | dust dry | set to touch | ready for assembly | sandable | recoatable |
|----------|--------------------|-------------|--------------|--------------------|----------|------------|
| – | 20 °C | 25 - 30 min | 2 - 3 h | 6 - 8 h | – | – |
| – | 60 °C | – | – | 30 min | – | – |

Fully cured after 5 - 6 days (20 °C).

Note

| | |
|------------------------------------|---|
| Characteristics: | binder base: polyurethane acrylic system solids content (% by weight): ~ 63 solids content (% by volume): ~ 45 delivery viscosity DIN 53211 4 mm (in s): 140 - 160 density DIN EN ISO 2811 (kg/l): ~ 1,4 gloss level ISO 2813 at 60° (GU): > 80 gloss |
| Properties: | Electrostatic application is possible Highly resistant to water Highly UV- and weather-resistant Highly resistant to chemicals Very good opacity Excellent resistance to chemical and mechanical strains Highly resistant to solvents Scratch resistant Heat resistance: - Short-term heat exposure: 180 °C - Permanent heat exposure: 150 °C |
| Theoretical spreading rate: | ~ 43,4 m ² /kg, 5:1 by weight with PU 916-XX, for 10 µm dry film thickness. ~ 48,1 m ² /l, 5:1 by weight with PU 916-XX, for 10 µm dry film thickness. ~ 36,9 m ² /kg, 3:1 by weight with PU 912-25, for 10 µm dry film thickness. ~ 38,9 m ² /l, 3:1 by weight with PU 912-25, for 10 µm dry film thickness. |
| Storage: | For at least 3 years in the unopened original container. Optimum storage conditions between + 5 °C and + 25 °C, avoid direct sunlight. Other storage conditions may lead to undesirable properties of the material. |
| VOC: | < 440 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 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: Steel, zined substrates:
Priming coat: **EP 100-20 with 50 - 70 µm dry film thickness.
Finishing coat: PU 242-90 with 50 - 60 µm dry film thickness.

Aluminium:
Priming coat: **EP 100-20 with 25 - 30 µm dry film thickness.
finishing coat: PU 242-90 with 50 - 60 µm dry film thickness.

Special notes:

*This product has the following maximum VOC-values:
- Undiluted with 2K-PU-Härter PU 916-XX: < 480 g/l of VOC.
- Undiluted with 2K-PU-Härter PU 912-XX: < 550 g/l of VOC.

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

For professional use only.

The details of the paragraphs - Proposed coating structure, Characteristics, Theoretical spreading rate, VOC - refer to the colour shade RAL 7035. For other colour shades, these may deviate.

Especially UV-resistant pigmentations (e.g. pastel shades for facades) are available on demand.

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 blistering 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.

Depending on the hardener in use and on the processing condition, the gloss level may prove to be higher or lower. The mentioned data refer to the hardener of series: PU 900-25, PU 912-XX, PU 933-10, PU 950-25.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.