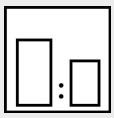
EA 100-20 2K-EP-AY-Grundierung

Technical data sheet

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	by weight (lacquer : hardener)	by volume (lacquer : hardener)
PU 914-XX	6 : 1	4 : 1

Hardener

Mipa PU 914-10, PU 914-25

Pot life

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

Thinner

Mipa 2K-Verdünnung V 10, V 25, V 40

Processing viscosity

gravity spray gun	Airmix/Airless
30 - 40 s 4 mm DIN	50 - 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	1,5 - 1,8	2 - 3	10 - 20 %
Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,28 - 0,33	1 - 2	< 10 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
-10	20 °C	20 - 30 min	60 - 90 min	24 h	5 h	20 min
-10	60 °C	--	--	1 h	--	--
-25	20 °C	approx. 50 min	approx. 2 h	24 h	12 h	40 min
-25	60 °C	--	--	1 h	--	--

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Note

Characteristics:	binder base:	epoxy acrylic resin
	solids content (% by weight):	~ 80
	solids content (% by volume):	~ 60
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	~ 1,8
	gloss level ISO 2813 at 60° (GU):	< 20 matt

Properties:

early recoatability
excellent corrosion protection, contains zinc phosphate
outstanding filling properties
recoatable 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, zinced substrates, aluminium, GRP, e-coatings

Theoretical spreading rate:

~ 37,6 m²/kg, 6:1 by weight with PU 914-10, for 10 µm dry film thickness
~ 55,5 m²/l, 6:1 by weight with PU 914-10, for 10 µm dry film thickness

Storage:

For at least 2 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:

< 375 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 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

zinced 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

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Proposed coating structure: steel, zinced 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

Special notes: *This product has the following maximum VOC-values:
- Applied by spraying with 2K-PU-Härter PU 914-XX: < 480 g/l of VOC.

**Further Mipa topcoats 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.

Recoatable at the earliest after 20 min at 20 °C and at the lastest after 4 weeks. After drying for more than 4 weeks, intermediate sanding is required.

Can be overcoated with putty after 60 minutes at 60 °C.

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.

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