Mipa Zink-Spray

Item no 21346 0000

Technical data sheet

Intended use

Mipa Zink-Spray is a high-quality one-component zinc dust coating with active corrosion protection (dry film contains more than 90% zinc) that can be applied in thick layers and thus provides high protection for steel substrates. Also suitable for repairing damaged areas of galvanised parts, weld seams, etc.. Can be spot-welded after drying. Mipa Zinc Spray complies with DIN EN ISO 1461 and can be overcoated with Mipa 1K and 2K paints.

Processing instruction



Substrate

Iron and steel.

Pre-treatment / cleansing

Pre-clean with Mipa Silikonentferner.
Please refer to the section “Substrate preparation“ for detailed information.
The metallic substrate should be as white as possible in accordance with EN ISO 8501.

Characteristics

Heat-resistant up to 300 °C
High cathodic corrosion protection (more than 90 % zinc content in dry film)
Especially suitable for spot welding, as it conductive
Very suitable for touch-ups on welds etc.
Can be applied in thick layers (up to 120 µm DFT per spray pass without any problems)

Colour / gloss level zinc-grey / matt



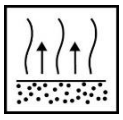
Preparation

Before use, shake can vigorously for 1 - 2 minutes!



Application

Spray to test - spray distance approx. 25 - 30 cm
Apply in a criss-cross fashion
Dry film thickness approx. 120 µm per spray pass



Flash-off time

1 - 2 min between coats



After use

After use, turn can upside down and spray until the valve is clean, this prevents the valve from clogging up.

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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Drying times at 20 °C	
Dust dry after approx.	10 min
Set to touch after approx.	30 min.
Overcoatable after approx.	6 h with 1K paint systems
	at the earliest 24 h with 2K paint systems
Completely dry after approx.	24 h

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. 600 g/l of VOC.
Safety information	See safety data sheet

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:
Blast clean to Sa 2½ standard, remove blast residues and overcoat promptly.

alternatively:

1. Pre-clean with Mipa Silikonentferner.
2. Then de-rust with hand and power tools to grade of cleanliness St 3.
3. Afterwards, degrease with Mipa Silikonentferner.

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