Intended use

All common metallic, pearl, xirallic and solid car colours can be mixed from mixing bases of the Mipa WBC 2-Schicht-Basislack-Mischsystem for refinish or complete car coatings by means of formulations. All Mipa WBC 2-Schicht-Basislacke (mixing bases) contain lead-free pigments. All pigments in use meet highest requirements in terms of lightfastness and weather resistance. To achieve highest colour precision it's necessary to shake these bases well before use (constant colouring power).Even a one-time withdrawal of mixing bases which have not been stirred sufficiently may destroy irreversibly the colouring power. Before placing a new basecoat can in the shelf, stir thoroughly manually or use a shaker, put the lid with spout and close tightly. Keep the cans closed as long as they are not needed. Generally, all mixing bases must be shaken or stirred regularly. Also the consistency of these bases, especially of the aluminium and pearl effect bases, must be controlled periodically. In the event of non-compliance, pigments may sediment and this leads to lumping and precipitation.

Recommendations:
1. Before every use, shake can thoroughly for approx. 20 - 30 seconds.
2. If a mixing base is not used for a longer period, the paint must be stirred manually before using.

Furthermore, the lid with spout must me checked before every use for paint residues as these may lead to contaminations. Always keep therefore the spout clean and tightly closed. Before applying, the colour must be checked by spraying a sample with clearcoat finish and compare it to the object. If necessary adjust the colour. Colour comparison can only be made with a sprayed (not applied by brush) dried sample under daylight conditions (or by means of a daylight lamp).

WBC base tinters for cars:

WBC A010 metallic extra fine / WBC A012 metallic very fine / WBC A013 brilliant metallic very fine/ WBC A014 brilliant metallic fine / WBC A015 metallic fine / WBC A016 brilliant metallic / WBC A018 metallic medium coarse / WBC A020 brilliant metallic coarse / WBC A030 metallic gold / WBC A031 metallic copper

WBC T100 green-gold / WBC T120 lemon-yellow / WBC R121 tinting yellow / WBC T140 yellow-orange / WBC T150 dark yellow / WBC T160 transparent oxide yellow / WBC T180 ochre / WBC T200 orange / WBC T202 orange / WBC T300 transparent oxide red / WBC T310 oxide red / WBC R311 tinting red / WBC T330 light red / WBC T340 light maroon / WBC T350 marron / WBC T360 marron-red/ WBC T370 rose red / WBC T380 red-violet / WBC T400 violet/ WBC R401 tinting violet / WBC T500 blue-violet / WBC T520 medium blue / WBS R521 tinting blue / WBC T540 blue / WBC T560 deep blue / WBC T580 turquoise-blue/ WBC T600 blue-green/ WBC T620 yellow-green/ WBC T900 white/ WBC T920 white plus/ WBC T950 black/ WBC R951 tinting black/ WBC T960 graphite black/ WBC T970 deep black/ WBC T980 super black

WBC effect tinters for cars:

WBC M10 pearl yellow/ WBC M20 pearl copper/ WBC M30 pearl red/ WBC M31 pearl red transparent/ WBC M32 pearl red fine/ WBC M33 pearl maroon/ WBC M40 pearl violet/ WBC M50 pearl blue/ WBC M51 pearl blue fine/ WBC M52 pearl blue-green/ WBC M60 pearl green/ WBC M90 pearl white extra fine/ WBC M91 pearl white fine/ WBC M92 pearl white/ WBC T910 satin white

WBC xirallic tinter for cars:

WBC X010 crystal gold / WBC X030 crystal red/ WBC X050 crystal blue/ WBC X060 crystal green/ WBC X080 crystal copper/ WBC X090 crystal white

Spreading rate: --

MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49 8703 92 20 · Fax: +49 8703 92 21 00 · mipa@mipa-paints.com · www.mipa-paints.com

Processing instructions

Colour

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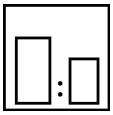

Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
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Hardener

for complete paintwork	for partial paintwork
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Pot life

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Thinner

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Spray viscosity

gravity spray gun	Airmix/Airless
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Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
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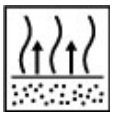

Flash-off time

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Dry coat thickness

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Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
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Note

Storage: --

VOC Regulation : --

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

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Processing instructions:

Put the lid with spout only if needed.

The application conditions have a decisive influence on the finish result and the shade of effect colours (metallic, pearl and xirallic):

1. Do not apply the first ½ spray pass too thick and too wet to ensure fast flash-off and to avoid floating of aluminium pigments. Achieving the optimal opacity at the first spray pass is not required.

2. Apply the second coat (spraying up and down) evenly wet. Observe spray pressure or the material output to avoid clouding and floating. Generally, by applying the second coat, full opacity is achieved.

3. The third spray pass is a drop coat. Due to the application with reduced spray pressure (approx. 1.0 bar) and from a slightly larger distance to the object (approx. 20 cm) the coat flows evenly.

This drop coat application levels irregularities, such as clouding after the second spray pass. Furthermore, the drop coat ensures an optimal effect which is necessary to achieve the exact colour. This spray pass is indispensable for all effect and aluminium colours. Spraying with higher spray pressure or omitting the application of the drop coat lead inevitably to colour deviations. After the drying of WBC basecoat layers, the clearcoat can be applied. As optimal finishing coat, we recommend Mipa 2K-Klarlacke. To comply with the VOC-regulations, Mipa 2K-HS-Klarlacke must be used.

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