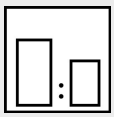
Intended use

Mipa WEE 1100-20 (series 6165-x-0) is a waterborne 1K zinc phosphate primer with good adhesion to steel, zinced steel, aluminium, anodic and cathodic e-coatings. Due to the special formulation, the product can also be used long-term in a material conveying system with ring mains without affecting the viscosity. In addition, the product has very good corrosion protection as well as fast drying and good water resistance. Can be overpainted with numerous water- or solvent-based 1K and 2K topcoats.

Colour: White. Further colour shades on request.

Processing instructions



Mixing ratio

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

Hardener

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Pot life

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Thinner

Mipa WBS VE-Wasser

Processing viscosity

gravity spray gun	Airmix/Airless
--	--

Application mode

application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
gravity spray gun / HVLP	--	2,0 - 2,2	1,5 - 1,7	2 - 3	--
Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,23 - 0,33	1 - 2	--

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	20 - 25 min	45 - 50 min	3 h	--	30 min
--	80 °C	--	--	20 min	--	--

Fully cured after 7 days (at 20 °C).

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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

Note

Characteristics:	binder base:	Polymerizate dispersion
	solids content (% by weight):	~ 57
	solids content (% by volume):	~ 43
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	~ 1,4
	gloss level ISO 2813 at 60° (GU):	< 20 matt

Properties:
suitable for use in ring mains
short drying time
very good corrosion protection
heat resistance:
- short-term heat exposure: 120 °C
- permanent heat exposure: 80 °C

adhesion to steel, zinced substrates, aluminium, anodic and cathodic e-coatings

Theoretical spreading rate:
~ 32,5 m²/kg for 10 µm dry film thickness
~ 42,3 m²/l for 10 µm dry film thickness

Storage:
For at least 2 years in 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:
< 65 g/l.

Processing conditions:
From + 10 °C and up to 70 % relative air 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

anodic and cathodic e-coatings:
- clean, sand slightly and degrease with Mipa Silikonentferner

Proposed coating structure:
steel, zinced substrates, aluminium, anodic and cathodic e-coatings:
priming coat: WEE 1100-20 with 50 - 60 µm dry film thickness
Decklackierung: *WPU 2487-XX with 50 - 60 µm dry film thickness

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Special notes:

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

For professional use only!

Paints that have been tinted with aluminium pastes must be protected from heat. Store at max. 35 °C. Failure to take this into account may lead to an internal pressure build-up.

Drying times reduce with increasing air velocity and degreasing relative humidity. When drying with air guns, the drying time can be reduced considerably. Optimum processing conditions: air temperature 20 - 25 °C, object temperature > 15 °C, relative air humidity 40 - 60 %, air velocity > 0,4 m/s.

Due to the risk of skinning, the paint in the container should be covered with foil when not in use or, in case of prolonged use, with a little water.

Specific system cleaning agents are available if required, please contact your technical advisor or our application technicians.

Cleaning of tools:

Clean tools immediately after use with Mipa WBS-Pistolenreiniger.

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