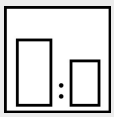
Intended use

High-quality, water-based 2K PU paint for coatings on plastics like e.g. TPU, PA, ABS and PP for interior and exterior use. This paint is characterized by its particularly high mechanical and chemical resistance. Its special formulation allows the product to be used as ready-for-use colour paint or unpigmented as clear protection coat (clearcoat), without changing mixing ratio with the hardener.

After curing, the product fulfils the requirements of saliva and sweat resistance according to DIN 53160-1 and -2.

Processing instructions



Mixing ratio

hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
WPU 9805-25	6 : 1	5 : 1

Hardener

Mipa WPU 9805-25

Pot life

Maximum 3 h at 20 °C*

Thinner

Mipa WBS VE-Wasser

Processing viscosity

Always stir first the hardener in the paint and then thin by adding Mipa WBS VE-Wasser. Never mix water with the hardener.

gravity spray gun	Airmix/Airless
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Application mode

application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
gravity spray gun/ HVLP	--	2,0 - 3,0	1,2 - 1,5	2 -3	5 - 10 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	80 - 90 min	6 - 8 h	48 h	--	--
--	60 °C	--	1 h	After cooling	--	--

Fully cured after 3 - 4 days (at 20 °C).

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Note

Characteristics:	binder base:	polyurethane polyester system
	solids content (% by weight):	~ 41
	solids content (% by volume):	~ 26
	delivery viscosity DIN 53211 4 mm (in s):	45 - 55 (at 20 °C)
	density DIN EN ISO 2811 (kg/l):	~ 1,3
	gloss level ISO 2813 at 60° (GU):	5 - 10 matt

Properties:
highly UV- and weather-resistant
very good water resistance
highly resistant to solvents and chemicals
scratch resistant
heat resistance:
- short-term heat exposure: 180 °C
- permanent heat exposure: 150 °C

adhesion to TPU (thermoplastic polyurethane), PA (polyamide), ABS, PP (polypropylene)

Theoretical spreading rate:
~ 29,1 m²/kg for 10 µm dry film thickness
~ 31,8 m²/l for 10 µm dry film thickness

Storage:
For at least 1 year 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:
< 80 g/l.

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

TPU, PA, ABS, PP:
Degrease with Mipa Silikonentferner or Mipa Kunststoffreiniger antistatisch or use an appropriate pre-treatment method like flame treatment or plasma processing. To ensure optimum adhesion it is recommend testing the recoatability.

Proposed coating structure:
single coat system
TPU, PA, ABS, PP:
WPU 4005-10 (usual film thickness: 20 µm, applicable up to max. 50 µm without blistering)

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Special notes:

*Attention: The end of pot life does not manifest itself by viscosity increase. Exceeding the pot life results in a lower resistance to mechanical and chemical strains, in a reduction of gloss and in a higher tendency to blister.

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.

Paints that have been tinted with aluminium pastes must be protected from heat. Store at max. 25 °C. Failure to take this into account may lead to an internal pressure build-up.

In case of water-based paints, the pH value can decrease due to the nature of the system and the environment (storage/transport/etc.) and may cause a decline of viscosity. Please use Mipa WBS Systemzusatz WPH in order to restore the initial viscosity. Please read carefully the technical data sheet regarding the use of WBS Systemzusatz WPH.

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.

Check colour prior to application.

Cleaning of tools:

Clean tools immediately after use with Mipa WBS-Pistolenreiniger.

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.

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