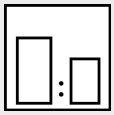
Intended use

This waterborne 1K zinc phosphate primer for steel substrates can be applied by paint brush, roller and spraying. Recoatable with all solvent- and waterborne 1K and 2K paints.

Processing instructions



Mixing ratio

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

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Pot life

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Thinner

Mipa WBS VE-Wasser

Spray 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 - 2,2	1,5 - 1,8	2 - 3	2 - 7 %
Airmix / Airless	--	100 - 120	0,23 - 0,33	1 - 2	0 - 2 %
Streichen, Rollen	--	--	--	--	0 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	15 - 25 min	25 - 35 min	24 h	--	1 - 2 h (1 h for waterborne paints, 2 h for solventborne paints)
--	60 °C	--	5 - 7 min	45 min	--	25 min

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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Note

Characteristics:	binder base:	styrene acrylic copolymer
	solids content (% by weight):	46 - 50
	solids content (% by volume):	36 - 37
	delivery viscosity DIN 53211 4 mm (in s):	80 - 100
	density DIN EN ISO 2811 (kg/l):	1,2 - 1,3
	gloss level ISO 2813 at 60° (GU):	10 - 20 matt

Properties:
short drying times
corrosion protection
high tolerance of grease and oil
heat resistance:
- short-term heat exposure: 120 °C
- permanent heat exposure: 80 °C

adhesion to steel

Theoretical spreading rate : 26,6 - 29,2 m²/kg for 10 µm dry film thickness
33,4 - 34,0 m²/l 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 Regulation : EU limit value according to Directive 2004/42/EC for this product (category A/d): 130 g/l.
This product has the following maximum VOC-values:
68 g/l of VOC

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!

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

Proposed coating structure: steel:
priming coat: WSA 1000-20 with 50 - 60 µm dry film thickness
finishing coat: *WAY 2000-40 with 50 - 60 µm dry film thickness

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

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Special notes:	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
Cleaning of tools:	Clean tools immediately after use with Mipa WBS-Pistolenreiniger.

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