

Mipa WBS EP-Grundierfiller is a waterthinnable, zinc phosphate primer-surfacer based on 2K epoxy resin for iron, steel, zinc, aluminium substrates as well as for common plastics. Chromate-free. It can be applied in high thickness coatings without pin hole danger and it is very well sandable after drying . Overpaintable with all common water-borne or solvent-borne 1K and 2K finishing paints. Consumption: 7 - 8 m² / liter by 50 µm dry film thickness.

Colour shade	light grey			
Mixing ratio	4 : 1 by volume			
Hardener	Mipa WBS EP-Härter			
Dilution	0- 5 % Mipa WBC-Verdünnung			
Spraying viscosity 20°C	30 - 40 s 4 mm DIN 53211			
Application	spraying pressure	spraying nozzle	spraying operations	
Air / Flowjar - Spray gun	3 - 5 bar	1.4 - 1.8 mm	2 - 3	
HVLP	3.5	1.3 - 1.5 mm	2 - 3	
Airless / Airmix	80 - 150 bar	0.3 - 0.45 mm	1 - 2	
Pot life	3.5 h (Attention: the end of the pot life is not connected to an increase of the viscosity. If the material is used beyond the recommended pot life, its mechanical and chemical resistance would be much reduced).			
Coat thickness / dry film	When applied as primer-surfacer 50 - 70 µm; when applied as sanding filler 150- 200 µm; as adhesion promoter 25 - 30 µm			
Flash off time	10 - 15 min. between the spraying operations			
Dry	recoatable	dust dry	set to touch	full hardness
Object Temp. 20°C	2 h	25 - 35 min.	approx. 3 h	approx. 6 h
Object Temp. 60°C	30 min.	10 - 15 min.	45 - 60 min.	60 min.
VOC compliant	EU limiting value for the product (cat. 2/c): 540 g/l. This product contains max 250 g/l VOC [2.08 lbs/gal].			

Remarks: Processing conditions: Do not apply at temperatures less than +10°C and up to 70 % air relative humidity. Provide adequate ventilation. A noticeable acceleration of the drying time is realized by increasing the air speed (for example by using the air blowers). **Optimal processing conditions:** Air temperature: 20 - 25 °C; Object temperature: > 15 °C; relative air humidity: 40 - 60 %; air speed: > 0.4 m/s. By drying times longer than 24 hours, an intermediate sanding is required.

This data sheet is for information purpose only! To our knowledge the data provided complies with the latest standard and is based on years of experience in the manufacture of our products. However the data is not binding and without warranty. Please follow recommendations stated on the relevant safety data sheet and precautions stated on the product label. We reserve our right to make additions, deletions, or modifications to the information at any time without prior notification.