

This 1K waterborne primer-surfacer is designed for automotive finishes on iron, steel, zinc and aluminium supports. Recoatable with all common solvent-borne and water-borne Mipa 1K and 2K finishing paints. Fast drying and easy to sand. Can be used as insulating groundcoat for thermoplastic old coatings.

High covering rate: 6 - 8 m<sup>2</sup> / liter (by approx. 50 µm dry coat thickness)

Colour availability	deep gray (approx. RAL 7011)				
Mixing ratio	-				
Dilution	0 - 5 % demineralized water Mipa VE-Wasser				
Spraying viscosity 20° C	35 - 40 s 4 mm DIN				
Application	spraying pressure	spraying nozzle	spraying operations		
HVLP	2,0 - 3,0 bar 0,7 bar nozzle int.pressure	1,7 - 1,9 mm	2		
High pressure	3 - 4 bar	1,4 - 1,6 mm	2		
Coat thickness / dry film	50 - 70 µm				
Curing time / Flash off time	5 - 8 min. between the spraying operations (the flashed off surface should show a dull lustre)				
Drying	recoat time	dust dry	set to touch	sandable	
	Object temp. 20° C	60 min.	25 min.	60 min.	4 h
	Object temp. 60° C	30 min.	5 min.	20 min.	30 min
	IR-drying (short waves)				8 min.
VOC regulation	EU limiting value for product (cat. B/c): 540 g/l (2007) This product contains max. 1 g/l VOC. [ 0.008 lbs/gal]				

### Process conditions:

From +10°C and up to 75% relative air humidity. The product should only be used in well ventilated rooms.

### Recommendation for end-use:

A noticeable acceleration of the drying time is achieved by increasing the air speed and by lower relative air humidity. Over 50 % reduction in drying time by using air blowers. Store protected against frost. During the operation, keep the spray gun cup closed to avoid the hardening. Deep the spray gun nozzle in water after use. Galvanized supports should be cleaned first with ammonia alkaline wetting agent Mipa Zinkreiniger.

### Optimal process conditions:

Air temperature: 20 - 25 °C; object temperature > 15 °C; rel. air humidity: 40 - 60 %, air speed: > 0,3 m/s

### Marking

WBS 1K-Grundierfiller

### VbF

n/a

### Hazardous materials ordinance

not applicable

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