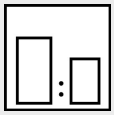
BC 200-30 Two-layer Basecoat Industry

Intended use

Solvent-based, two-layer basecoat, especially developed for industrial use. Recoating with Mipa 2K-Klarlack (clearcoat) generates a high-gloss weather-resistant finish.

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 BC-Verdünnung, Mipa BC-Verdünnung lang, Mipa Stabilisier-Verdünnung

Processing viscosity

gravity spray gun	Airmix/Airless
16 - 18 s 4 mm DIN	--

Application mode

application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
gravity spray gun/ HVLP	--	2,0 - 2,5	1,2 - 1,3	2 - 3	50 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	--	--	--	--	10 - 15 min

Note

Characteristics:

binder base:	physically drying, special resins
solids content (% by weight):	~ 37
solids content (% by volume):	~ 20
delivery viscosity DIN 53211 4 mm (in s):	110 - 140
density DIN EN ISO 2811 (kg/l):	~ 1,2
gloss level ISO 2813 at 60° (GU):	-

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Properties:
Short drying time
Excellent hiding power
Brilliant effects
Electrostatic application possible
High UV and weather resistance in combination with 2K clearcoats
Heat resistance:
- Short-term heat exposure: 180 °C
- Permanent heat exposure: 150 °C

Theoretical spreading rate:
~ 20,6 m²/kg for 10 µm dry film thickness.
~ 20,8 m²/l for 10 µm dry film thickness.

Storage:
For at least 3 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:
< 630 g/l.

Processing conditions:
From + 10 °C and up to 80 % 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 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.

Proposed coating structure:
3-coat system
Steel, zinced substrates:
Priming coat: *EP 100-20 with 50 - 60 µm dry film thickness.
Basecoat: BC 200-30 with 15 - 20 µm dry film thickness.
Cleacoat: *2K-MS-Klarlack C 75 with 50 - 60 µm dry film thickness.

Aluminium:
Priming coat: *EP 100-20 with 50 - 60 µm dry film thickness.
Basecoat: BC 200-30 with 15 - 20 µm dry film thickness.
Clearcoat: *2K-MS-Klarlack C 75 with 50 - 60 µm dry film thickness.

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Special notes:

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

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.

Mipa BC 200-30 must be stirred thoroughly (at least for 2 minutes), immediately after tinting and before applying. In doing so, it's recommended mixing mechanically by means of a stirrer or shaker.

Apply Mipa BC 200-30 evenly in thin, levelling layers. Don't apply too wet.

Flash-off time between coats is about 2 - 5 minutes.

Special substrate colours are prescribed in formulations of Mipa Mix System.

Multi layer coatings and colours, which have a low hiding power due to the system e.g. bright white colours tend to higher film build. This may result in highly delayed drying and in an increase of clearcoat adhesion problems. As a precaution, we recommend therefore adding hardener to basecoat layers as follows:
Mipa BC 200-30 + Mipa PU 900-25, PU 912-10, PU 912-25, PU 912-40, PU 933-10, PU 950-25 with the mixing ratio 10:1 by weight or by volume, then thin with 40 - 50 % Mipa BC-Verdünnung, Mipa BC-Verdünnung lang, Mipa Stabilisier-Verdünnung. The final flash-off time before overcoating with clearcoat should be at least 20 minutes at room temperature.

Note: Mipa BC 200-30 is NOT meant for car refinishing according to Directive 2004/42/EC.

Check colour shade prior to application.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.

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