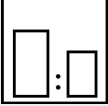


Intended use


Mipa 2K-WBS-Klarlack is a VOC-compliant waterborne acrylic clearcoat for partial or complete coating of passenger cars and commercial vehicles. This clearcoat provides a particularly high gloss finish and optimal flow on solventborne or waterborne basecoats. Mipa 2K-WBS-Klarlack can be polished immediately after for forced drying and is characterized by its high resistance to all weather conditions as well as to chemical and mechanical stress.


Processing instructions


	Mixing ratio		
	hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
	WPU 9430-25	4 : 1	4 : 1


	Hardener
	Mipa WPU 9430-25

	Pot life
	1,5 - 2 h at 20 °C*

	Thinner
	Mipa WBS VE-Wasser
	Mipa WBC-Verdünnung

	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	
	18 - 24 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	½ + 1	15 - 20 %

	Drying time						
	hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
	–	20 °C	1 h	6 - 8 h	24 h	–	–
	–	60 °C	–	45 min	1 h	–	–

Fully cured after 7 - 8 days (at 20 °C).

Note

Characteristics:	binder base:	polyurethane-polyester system
	solids content (% by weight):	~ 30
	solids content (% by volume):	~ 30
	delivery viscosity DIN 53211 4 mm (in s):	60 - 70
	density DIN EN ISO 2811 (kg/l):	~ 1,0
	gloss level ISO 2813 at 60° (GU):	> 80 glossy

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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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Properties:	highly resistant to water highly UV- and weather-resistant highly resistant to solvent scratch resistant excellent resistance to chemical and mechanical strains heat resistance: - short-term heat exposure: 180 °C - permanent heat exposure: 150 °C
Theoretical spreading rate :	~ 33,2 m ² /kg for 10 µm dry film thickness ~ 33,5 m ² /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:	< 340 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! 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 zincd 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, zincd substrates: priming coat: ***WEP 1000-20 with 50 - 60 µm dry film thickness basecoat: BC 200-30 / BC / WBC with 15 - 20 µm dry film thickness clearcoat: 2K-WBS-Klarlack with 50 - 60 µm dry film thickness aluminium: priming coat: ***WEP 1000-20 with 25 - 30 µm dry film thickness basecoat: BC 200-30 / BC / WBC with 15 - 20 µm dry film thickness clearcoat: 2K-WBS-Klarlack with 50 - 60 µm dry film thickness

Special notes:

*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 bubbling.

**This product has the following maximum VOC-values:
- Applied by spraying with hardener WPU 9430-25: < 340 g/l of VOC

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

For professional use only.

Drying times reduce with increasing air velocity and decreasing 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

Please consider: Due to the system this clearcoat is hazy in liquid state but completely clear after drying.

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.