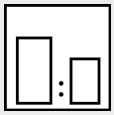
WAY 1000-20 WBS 1K Universal Primer

Intended use

Water-based 1K zinc phosphate primer for steel, zinced substrates and aluminium. 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

Processing 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 compound pressure	--	1,0 - 2,0 100 - 120	0,28 - 0,33	1 - 2	0 - 2 %
paint brush, roller	--	--	--	--	0 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	20 - 30 min	30 - 40 min	24 h	--	45 min - 2 h (45 min in case of waterborne paints, 2 h in case of solventborne paints)
--	60 °C	--	7 - 10 min	1 h	--	15 min

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Note

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

Properties:

high corrosion protection
excellent resistance to chemical and mechanical strains
good resistance to grease and oils
heat resistance:
- short-term heat exposure: 180 °C
- permanent heat exposure: 130 °C

adhesion to steel, zinced substrates and aluminium

Theoretical spreading rate:

~ 31,1 m²/kg for 10 µm dry film thickness
~ 36,6 m²/l for 10 µm dry film thickness

Storage:

For at least 1 year 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:

< 119 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

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:

steel, zinced substrates:
priming coat: WAY 1000-20 with 50 - 60 µm dry film thickness
finishing coat: *WAY 2000-40 with 50 - 60 µm dry film thickness

aluminium:
priming coat: WAY 1000-20 with 25 - 30 µm dry film thickness
finishing coat: *WAY 2000-40 with 50 - 60 µm dry film thickness

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Special notes:

*Further Mipa topcoats 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.

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.

To avoid possible occurring flash rust during the painting of bare and sandblasted steel parts add Mipa WBS Korrosionsinhibitor. Get more information about use in the data sheet Mipa WBS Korrosionsinhibitor.

Cleaning of tools:

Clean tools immediately after use with Mipa WBS-Pistolenreiniger.

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