WAY 2010-40 WBS Airless Single-layer Coat satin matt

Intended use

Fast drying one-layer paint to coat constructions (halls, pipes, doors, wall and ceiling panels, recipients, container, vehicle constructions) made of steel, zinced steel and aluminium. For interior and exterior use. Especially suitable for Airless and Airmix applications.

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 - 2,5	1,2 - 1,3	2 - 4	5 - 10 %
Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,28 - 0,33	1 - 2	0 - 5 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	15 - 25 min	25 - 35 min	8 h	--	--
--	60 °C	--	30 min	1 h	--	--

Fully cured after 4 - 5 days (at 20 °C).

Note

Characteristics:

binder base:	pure acrylate
solids content (% by weight):	~ 50
solids content (% by volume):	~ 35
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):	35 - 45 satin matt

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Properties:
Optimised for Airmix application
Short drying time
Highly water-resistant
Highly UV- and weather-resistant
Short-term heat exposure: 130 °C
Permanent heat exposure: 70 °C
Adhesion on steel, zinced substrates and aluminium

Theoretical spreading rate:
~ 30,6 m²/kg for 10 µm dry film thickness.
~ 34,2 m²/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:
< 34 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 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 P 360/400 and clean subsequently with Mipa Silikonentferner.

Mineral substrates (concrete, plaster):
- Mineral substrates (set, dimensionally stable, rough and solid), free from friable parts and other substances that may affect the adhesion (e. g. rubber marks, greases, oils, rust, dust, and similar).

Proposed coating structure:
Single coat system
Steel, zinced substrates, aluminium:
WAY 2010-40 with 50 - 70 µm dry film thickness.

2-coat system
Steel, zinced substrates, aluminium:
Priming coat: *WAY 1000-20 with 50 - 60 µm dry film thickness or with 25 - 30 µm dry film thickness on aluminium.
Finishing coat: WAY 2010-40 with 50 - 60 µm dry film thickness.

Concrete / mineral substrates:
Priming coat: Tiefgrund LH (exterior use) or Tiefgrund LF (interior use).
Finishing coat: WAY 2010-40 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.

When alkyd resin (based) products are stored, a skin can form on the surface of the paint due to the system. This generally has no negative effects on the quality (material testing is recommended!).
If a skin has formed, it must be carefully removed before stirring (before tinting for bases) and the product must be sieved as required before application.

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.

Especially UV-resistant pigmentations are available on demand.

Check colour shade prior to application.

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.

Depending on the surface roughness, gloss reduction might be possible.

Cleaning of tools:

Clean tools immediately after use with Mipa WBS-Pistolenreiniger.

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