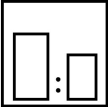








Intended use

Fast drying one-layer paint to coat constructions (halls, pipes, doors, wall and ceiling panels, recipients, container, vehicle constructions, transport racks) made of steel, zinc steel and aluminium. For interior and exterior use.

Processing instructions

	Mixing ratio						
	hardener	by weight (lacquer : hardener)		by volume (lacquer : hardener)			
	--	--		--			
	Hardener						
	--						
	Pot life						
	--						
	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	0,23 - 0,28	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):	~ 51
	solids content (% by volume):	~ 34
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	~ 1,4
	gloss level ISO 2813 at 60° (GU):	10 - 20 matt

Properties:	Short drying time Highly resistant to water Highly UV- and weather-resistant Heat resistance: - Short-term heat exposure: 130 °C - Permanent heat exposure: 70 °C Adhesion to steel, zincd substrates, aluminium and concrete
Theoretical spreading rate:	~ 27,6 m ² /kg for 10 µm dry film thickness. ~ 33,2 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:	< 20 g/l.
Processing conditions:	From + 10 °C and up to 70 % relative humidity. Ensure adequate air ventilation.
Substrate preparation:	<p>Remove oil, grease, rust, mill scale, rolling skins, as well as other substances impairing the function of the coating!</p> <p>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.</p> <p>Steel:</p> <ul style="list-style-type: none">- 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. <p>Zincd substrates:</p> <ul style="list-style-type: none">- Clean the surface with the ammonia solution Mipa Zinkreiniger.- Sweep blast. <p>Aluminium:</p> <ul style="list-style-type: none">- Degrease with Mipa 2K-Verdünnung, sand thoroughly with sandpaper P 360/400 and clean subsequently with Mipa Silikonentferner. <p>Mineral substrates (concrete, plaster):</p> <ul style="list-style-type: none">- Mineral substrates (set, dimensionally stable, rough and solid) must be 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:	<p>Single coat system Steel, zincd substrates, aluminium: WAY 2200-20 with 50 - 70 µm dry film thickness.</p> <p>2-coat system Steel, zincd 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 2200-20 with 50 - 60 µm dry film thickness.</p>

Special notes:

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

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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.

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.

Cleaning of tools:

Clean tools immediately after use with Mipa WBS-Pistolenreiniger