

Intended use

All common metallic, pearl, crystal and solid car colours can be mixed from mixing bases of the Mipa WBC 2-Schicht-Basislack-Mischsystem for refinish or complete car coatings by means of formulations. All Mipa WBC 2-Schicht-Basislacke (mixing bases) contain lead-free pigments. All pigments in use meet highest requirements in terms of lightfastness and weather resistance. To achieve highest colour precision it's necessary to shake these bases well before use (constant colouring power). Even a one-time withdrawal of mixing bases which have not been stirred sufficiently may destroy irreversibly the colouring power. Before placing a new basecoat can in the shelf, stir thoroughly manually or use a shaker, put the lid with spout and close tightly. Keep the cans closed as long as they are not needed. Generally, all mixing bases must be shaken or stirred regularly. Also the consistency of these bases, especially of the aluminium and pearl effect bases, must be controlled periodically. In the event of non-compliance, pigments may sediment and this leads to lumping and precipitation.

Recommendations:

1. Before every use, shake can thoroughly for approx. 20 - 30 seconds.
2. If a mixing base is not used for a longer period, the paint must be stirred manually before using.

Furthermore, the lid with spout must be checked before every use for paint residues as these may lead to contaminations. Always keep therefore the spout clean and tightly closed. Before applying, the colour must be checked by spraying a sample with clearcoat finish and compare it to the object. If necessary adjust the colour. Colour comparison can only be made with a sprayed (not applied by brush) dried sample under daylight conditions (or by means of a daylight lamp).

WBC base tinters for cars:

WBC A010 metallic extra fine / WBC A012 metallic very fine / WBC A013 brilliant metallic very fine / WBC A014 brilliant metallic fine / WBC A015 metallic fine / WBC A016 brilliant metallic / WBC A018 metallic medium coarse / WBC A020 brilliant metallic coarse / WBC A030 metallic gold / WBC A031 metallic copper

WBC T100 green-gold / WBC T120 lemon-yellow / WBC R121 tinting yellow / WBC T140 yellow-orange / WBC T150 dark yellow / WBC T160 transparent oxide yellow / WBC T180 ochre / WBC T200 orange / WBC T202 orange / WBC T210 orange transparent / WBC T300 transparent oxide red / WBC T310 oxide red / WBC R311 tinting red / WBC T330 light red / WBC T340 light maroon / WBC T350 marron / WBC T351 marron highly transparent / WBC T360 marron-red / WBC T370 rose red / WBC T380 red-violet / WBC T400 violet / WBC R401 tinting violet / WBC T500 blue-violet / WBC T520 medium blue / WBS R521 tinting blue / WBC T540 blue / WBC T560 deep blue / WBC T580 turquoise-blue / WBC T600 blue-green / WBC T620 yellow-green / WBC T900 white / WBC T920 white plus / WBC T950 black / WBC R951 tinting black / WBC T960 graphite black / WBC T970 deep black / WBC T980 super black

WBC effect tinters for cars:

WBC M10 pearl yellow / WBC M20 pearl copper / WBC M30 pearl red / WBC M31 pearl red transparent / WBC M32 pearl red fine / WBC M33 pearl maroon / WBC M40 pearl violet / WBC M50 pearl blue / WBC M51 pearl blue fine / WBC M52 pearl blue-green / WBC M60 pearl green / WBC M90 pearl white extra fine / WBC M91 pearl white fine / WBC M92 pearl white / WBC T910 satin white

WBC crystal tinter for cars:

WBC X010 crystal gold / WBC X030 crystal red / WBC X050 crystal blue / WBC X060 crystal green / WBC X080 crystal copper / WBC X090 crystal white

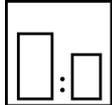
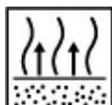
Spreading rate: --

Version: en 0226

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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Processing instructions

	Colour	--				
	Mixing ratio	--				
	Hardener	by weight (lacquer : hardener)		by volume (lacquer : hardener)		
		--		--		
	Hardener	--				
	for complete paintwork					for partial paintwork
		--				--
	Pot life	--				
	Thinner	--				
	Spray viscosity	--				
	gravity spray gun					Airmix/Airless
		--				--
	Application mode	--				
	Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	dilution (%)
		--	--	--	--	--
	Flash-off time	--				
Dry coat thickness						
--						
	Drying time	--				
	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
		--	--	--	--	--

Note

Storage: --

VOC Regulation: --

Processing conditions: from + 10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.

Processing instructions: Put the lid with spout only if needed. Shake thoroughly the bottles with tinters for approx. 20-30 s before every use.

Processing:

Check colour before application.

1st spray pass:

Apply a ½ spray pass semi-wet and flowing with a spray pressure of approx. 2 bar

Intermediate drying:

e.g. by means of an air gun until the WBC basecoat is completely dry

2nd spray pass:

Apply complete spray pass consisting of two half-wet coats ("up and down") keeping the same distance, spraying speed and spraying pressure as for the 1st spray pass.

Note: If the full hiding power is not yet ensured with the 2nd spray coat, apply a further spray coat after intermediate drying.

Drying:

7 min. by means of an air gun or

13 min. at 40 °C + cooling or

20 min. at room temperature

Drop coat only for metallic and effect colours:

the last spray pass of all effect and metallic paints is applied uniformly at a reduced spraying pressure of 1 bar. This drop coat is absolutely necessary to achieve colour accuracy. In addition, this drop coat can prevent irregularities, e.g. mottling.

Note: The colour shade of metallic and effect colours will tend to be "lighter" after the application of the drop coat. If the shade still appears too "dark" after the first drop coating, apply at most a second drop application to further lighten the shade.

After drying for approx. 5 min. at room temperature, apply the clearcoat.