

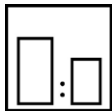
Intended use

Water-based two-layer basecoat to coat completely or partially vehicles, motorbikes and commercial vehicles. Overcoating with Mipa 2K clearcoats results in a weather-resistant, high-gloss top coating. All colours are free from lead and chromate pigments.

Spreading rate: 7,0 - 9,0 m²/l

Processing instructions**Colour**

Mipa Mix-System

**Mixing ratio****Hardener****by weight (lacquer : hardener)****by volume (lacquer : hardener)**

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**Hardener****for complete paintwork****for partial paintwork**

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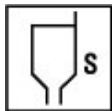
**Pot life**

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**Thinner**

10 - 20 % Mipa WBC-Verdünnung

10 - 20 % Mipa WBS Beschleuniger

**Spray viscosity****gravity spray gun****Airmix/Airless**

22 - 25 s 4 mm DIN

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**Application mode****Application mode****Hardener****pressure
(bar)****nozzle
(mm)****spray
passes****dilution
(%)**

gravity air gun (high pressure)

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2 - 2,5

1,2 - 1,3

2,5

10 - 20

HVLP (low pressure)

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2 - 2,2

1,2 - 1,3

2,5

10 - 20

HVLP / internal nozzle pressure

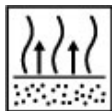
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0,7

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**Flash-off time**

5 - 8 min between coats

Dry coat thickness

15 - 20 µm



Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	--	--	--	--	20 min (surface must dry to matt finish)
40 °C	--	--	--	--	13 min + 5 min cooling
air gun	--	--	--	--	7 min

Note

Storage: at least 2 years in closed original containers
Frost-free storage.

VOC Regulation: EU limit value for this product (category B/d): 420 g/l
This product contains max. 420 g/l of VOC.

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

Drying times are reduced if the air speed increases and the relative air humidity decreases. In case of drying with air gun the drying time is reduced considerably. When drying with air guns the drying time is reduced by 50%.

Optimal processing conditions:
air temperature 20 - 25 °C
object temperature > 15 °C
relative humidity of air 40 - 60 %
air velocity 0,25 - 0,3 m/s

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.

Blending:

For blending difficult metallic and effect coatings, it is recommended to use Mipa WBC Beispritzlack.

3-coat application (Coating 1 + Coating 2 + clearcoat):

In this case use for Coating 1 Mipa WBC-Härter (hardener) to ensure an improved complete curing. The coating procedure is as follows:

Coating 1 = Mipa WBC Basislack + 5 % by weight or by volume Mipa WBC-Härter (first stir thoroughly the hardener in the WBC base paint), then thin by adding 10 - 20 % of Mipa WBC-Verdünnung (thinner) or Mipa WBS Beschleuniger (accelerator), intermediate flash-off time at least 20 minutes at room temperature.

Coating 2 can be applied without hardener. The final flash-off time before overcoating with clearcoat should be also at least 20 minutes at room temperature.

Application of poorly hiding colours:

WBC colours, which have only a limited hiding power due to the system; e.g. bright white colours; are usually applied in thicker coats, which may result in significantly retarded through drying and in an increase of adhesion problems when applying the clearcoat. To avoid possible problems, it is recommended to add hardener to the basecoat as follows:

Mipa WBC basecoat + 5 % by weight or by volume Mipa WBC-Härter (hardener, stir first the hardener in the WBC base paint), then thin by adding 10 - 20 % of Mipa WBC Verdünnung (thinner) or Mipa WBS Beschleuniger (accelerator), final flash-off time: 20 minutes at room temperature prior to clearcoat application.

Application of colours that contains Mipa WBC Vicrom:

Due to the fact that Mipa WBC Vicrom has a very fine pigmentation, the substrate needs to be prepared to prevent visible sanding marks:

1. final sanding with very fine sanding paper P 800 - 1000.
2. apply beforehand a uniform coat with Mipa WBC 000, after approx. 5 - 10 minutes flash-off time at room temperature overcoat with WBC topcoats.

Processing at high air humidity and/ or low air flow:

To improve the complete drying it is recommended to use exclusively Mipa WBS Beschleuniger (accelerator) instead of Mipa WBC-Verdünnung (thinner). The quantities to be added remain unchanged. This recommendation applies to standard coating system as well as to 3-layer coating systems. Furthermore, specified coat thicknesses as well as intermediate and final flash-off times are to be observed exactly and ensure not to apply the clearcoat too wet. If doing so, a loss of gloss or subsequent matting can be avoided successfully.

The optional addition of Mipa WBC-Additiv ETR (15 – 20 %) significantly increases the processing speed of Mipa WBC 2-Schicht-Basislack. The additive enables time-saving wet-on-wet painting without flash-off times between spray coats and is therefore particularly efficient for full or new paint jobs. In the case of high prevailing air humidity (relative air humidity > 60 %), the addition of 10 % - 20 % Mipa WBS Beschleuniger instead of Mipa WBC-Verdünnung enables an enormous increase in efficiency and performance.

A relative air humidity > 60 % usually leads to significant drying delays and performance losses in water-based paints due to the increased tendency of water vapor to condense. The addition of Mipa WBS Beschleuniger counteracts both impairments.

Notes:

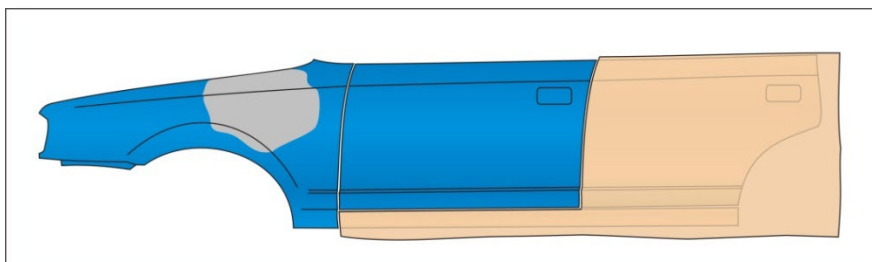
1. With the particularly efficient wet-on-wet painting with Mipa WBC-Additiv ETR, the spray pattern is "wetter" than with the conventional spraying process. The painting method influences the color tone in nuances.
2. Mipa WBC-Additiv ETR and Mipa WBS Beschleuniger can also be used in combination.

Clear coating:

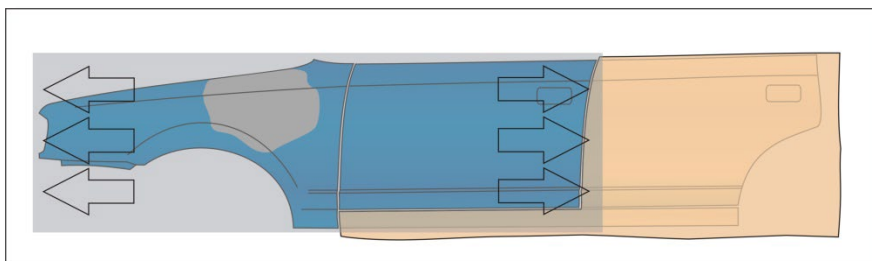
Mipa WBC base tinters are recoatable with all Mipa 2K clearcoats. To achieve the VOC-limit value use Mipa 2K HS clearcoats.

Mipa WBC: 2-Schicht-Beilackierverfahren

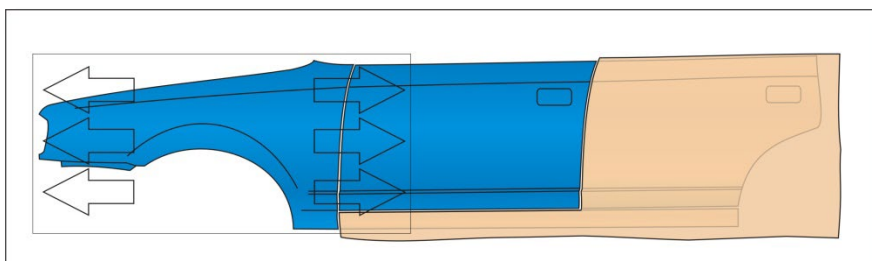
process step	paint system	+ hardener	+ thinner	spray passes
1. blending	WBC Beispritzlack	-	ready for use	1
flash-off time	approx. 5 minutes at room temperature			-
2. basecoat	WBC	-	10 - 20 % WBC Verdünnung or WBS Beschleuniger	2,5
flash-off time	at least 20 minutes at room temperature or approx. 13 minutes at 40 °C			-
3. clearcoat	Mipa 2K-Klarlacke	-	-	-



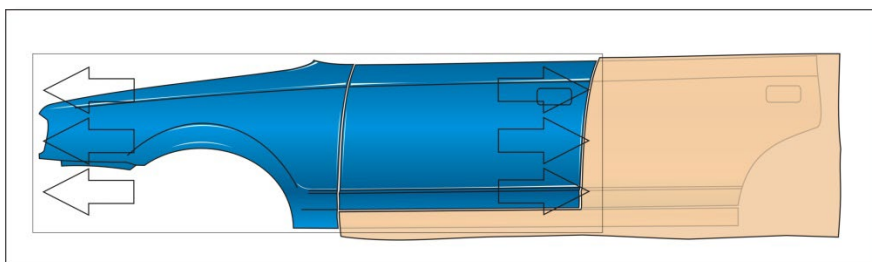
Initial situation:
Wing panel filled and sanded,
ready to be coated, faultless
door, sanded slightly with
very fine grit, blending zone



Application of Mipa WBC Beispritzlack:
pre-coat the whole surface
applying 1 wet closed film of
Mipa WBC Beispritzlack



Application of Mipa WBC:
Apply an uniform covering
layer on the wing panel
fading out into the still intact
existing finish on the front
part of the door until the best
possible colour and effect
transition is achieved

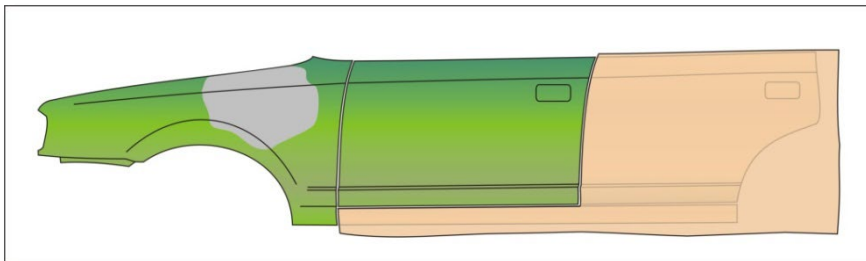


Clearcoat application:
Apply the clearcoat on both
wing panel + door

Mipa WBC: 3-coat blending Standard

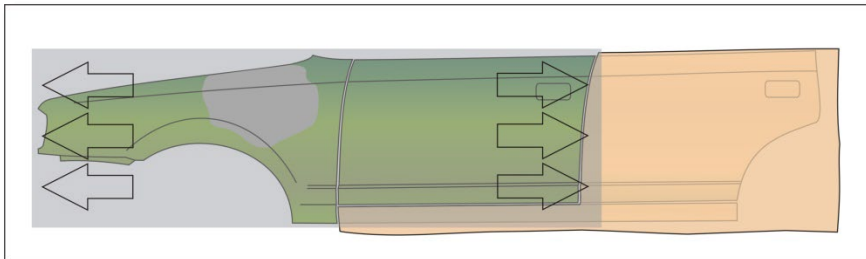
process step	paint system	+ hardener	+ thinner	spray passes
1. blending	WBC Beispritzlack	-	ready for use	1
flash-off time	approx. 5 minutes at room temperature			-
2. Coating 1*	WBC	5 % by weight or volume WBC-Härter	10 - 20 % WBC Verdünnung or WBS Beschleuniger	2,5
flash-off time	at least 20 minutes at room temperature or approx. 13 minutes at 40 °C			
3. Coating 2*	WBC	-	10 - 20 % WBC Verdünnung or WBS Beschleuniger	1 - 2
flash-off time	mind. 20 Minuten bei Raumtemperatur od. ca. 13 Minuten bei 40 °C			-
4. clearcoat	Mipa 2K-Klarlacke	-	-	-

*Mix Coating 1 and 2 only right before application!



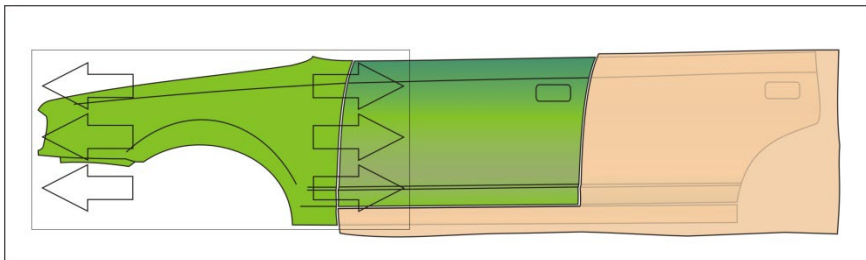
Initial situation:

Wing panel filled and sanded, ready to be coated, faultless door, sanded slightly with very fine grit, blending zone



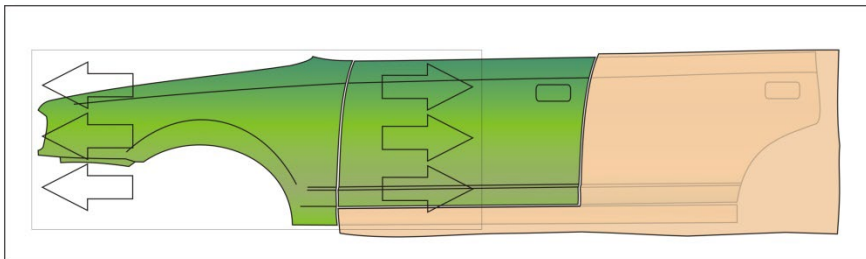
Application of Mipa WBC Beispritzlack:

pre-coat the whole surface applying 1 wet closed film of Mipa WBC Beispritzlack



Application of Coating 1:

Apply an uniform covering layer of Coating 1 on the wing panel fading out into the still intact existing finish on the front part of the door

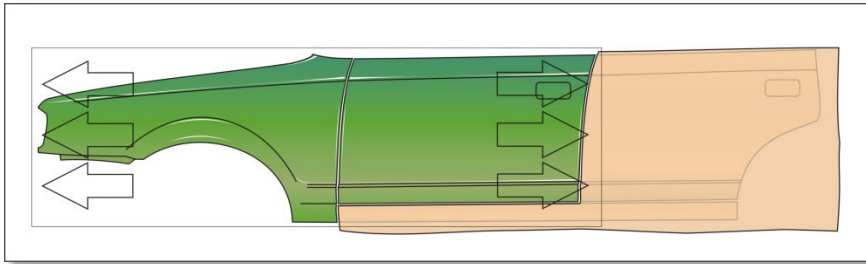


Application of Coating 2:

Apply 1 - 2 even spray passes on the wing and on the middle part of the door until the best possible colour and effect transition is achieved.

Important: The fading out zone of Coating 1 must be applied overlapping!

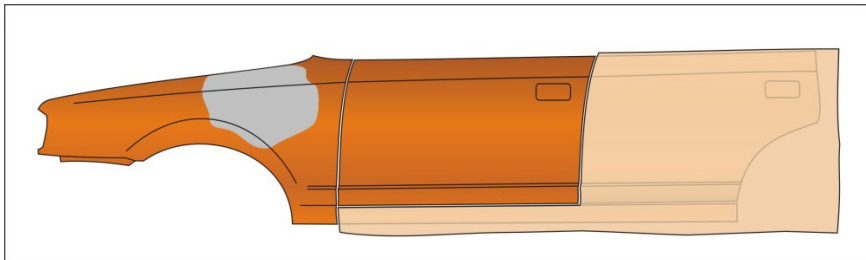
Mipa WBC: 3-coat blending Standard



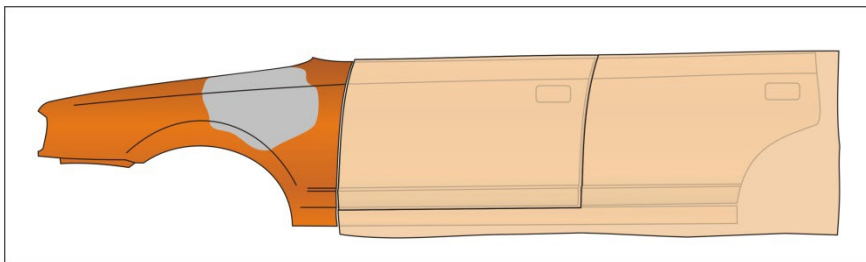
Clearcoat application:
 Apply clearcoat on both wing
 + door

Mipa WBC: 3-coat blending, if Coating 1 has low hiding power

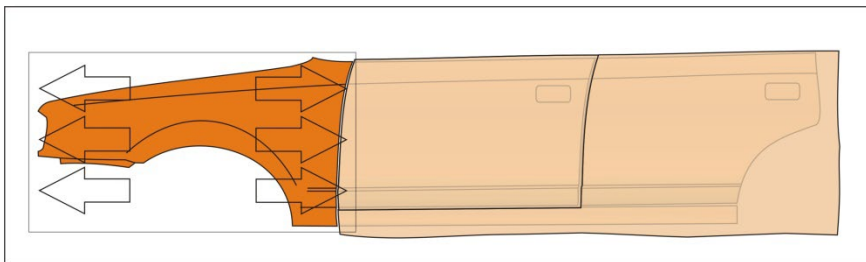
In this case, Coating 1 is applied first on the part to be repaired as covering coat. During this application the blending zone stays masked to avoid overspray deposits. Unmask thereafter the blending zone and apply Coating 1 feathering out.



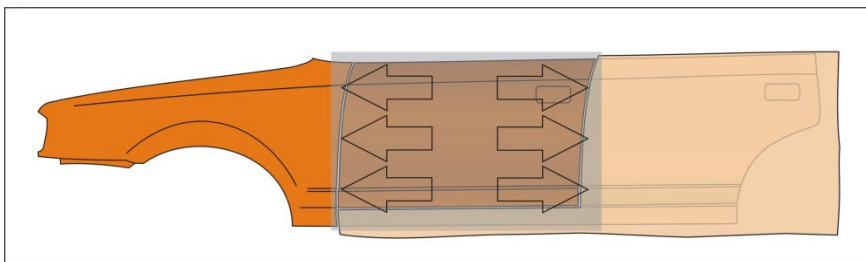
Initial situation:
 Wing panel filled and sanded,
 ready to be coated, faultless
 door, sanded slightly with
 very fine grit, blending zone



Mask the blending zone:
 In order to prevent excessive
 overspray deposits in the
 blending area, simply mask it.

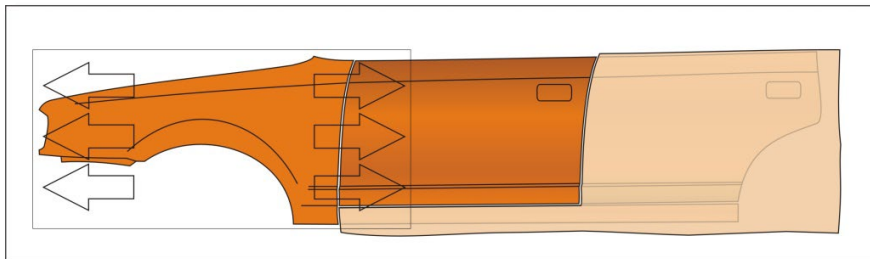


Application of Coating 1:
 First spray a covering coat of
 Coating 1 only on the wing.

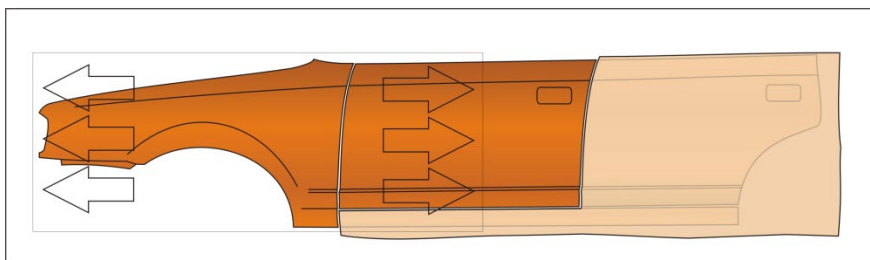


**Application of Mipa WBC
 Beispritzlack:**
 Unmask the door and pre-
 coat the whole surface
 applying 1 wet closed film of
 Mipa WBC Beispritzlack

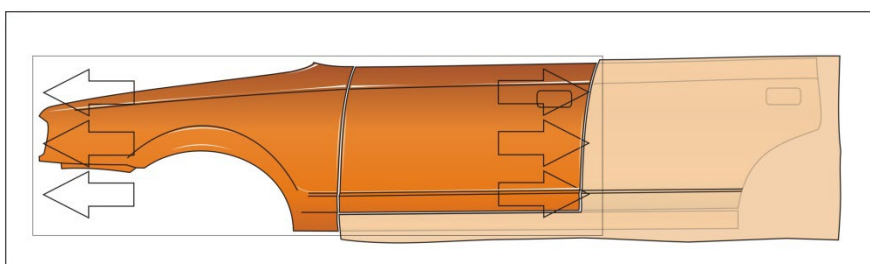
Mipa WBC: 3-coat blending, if Coating 1 has low hiding power



Application of Coating 1:
Apply an uniform covering layer of Coating 1 on the wing panel fading out into the still intact existing finish on the front part of the door.



application of Coating 2:
Apply 1 - 2 even spray passes on the wing and on the middle part of the door until the best possible colour and effect transition is achieved.
Important: The fading out zone of Coating 1 must be applied overlapping!



Clearcoat application:
Apply clearcoat on both wing + door