Mipa WBC Binder 2K-Decklack matt

Technical data sheet

Intended use

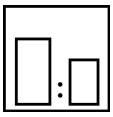
High-quality, water-borne matt 2K topcoat with particularly high mechanical and chemical resistance for coating plastic substrates like e.g. TPU, PA, ABS and PP for use in car interiors. Mipa WBC Binder 2K-Decklack matt is ideal for high quality coatings of dashboards, door panels, centre consoles etc., but also for the coating of primed metal substrates in interior and exterior use. Due to its special formulation, the product can be used as a ready-mixed paint or unpigmented as a clear protective coating (clearcoat) without affecting the mixing ratio with the hardener. After curing, this product fulfils the requirements for saliva and perspiration resistance according to DIN 53160-1 and -2.

Spreading rate: 14,5 - 15,1 m²/l (for 20 µm DFT)

Processing instructions

Colour

tintable with Mipa WBC-Mischlacken



Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
Mipa WBC-Härter	5 : 1	4 : 1

Hardener

for complete paintwork	for partial paintwork
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Pot life

max. 3 h at 20 °C

Thinner

20 - 25 % Mipa WBC-Verdünnung

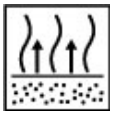
Spray viscosity

Always stir in first the hardener in the basic paint and then thin with Mipa WBC-Verdünnung. Never add the water to the hardener.

gravity spray gun	Airmix/Airless
16 - 18 s 4 mm DIN	--

Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
gravity spray gun (high pressure)	--	2 - 2,5	1,2 - 1,3	2 - 3	20 - 25 %
HVLP (low pressure)	--	2 - 2,2	1,2 - 1,3	2 - 3	20 - 25 %
HVLP / internal nozzle pressure	--	0,7	--	--	--



Flash-off time

5 - 8 min between coats

15 - 20 min prior to oven drying

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Dry coat thickness

normal coat thickness: 20 µm

up to max. 50 µm without blistering

Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	90 - 120 min	4 h	--	--	--
60 °C	--	1 h	--	--	--

Note

Storage: for at least 2 years in unopened 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 air humidity. Ensure an adequate air ventilation.

Drying times reduce with increasing air velocity and decreasing relative humidity.

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

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Processing instructions:

Gloss level DIN EN ISO 2813 at 60° angle (Gloss units): 5 - 10 matt

Possible gloss levels in combination with WBC Binder 2K-Decklack glänzend:

WBC Binder 2K-Decklack glänzend + WBC Binder 2K-Decklack matt mixing ratio 2:1 by weight/ by volume = 50 GU

WBC Binder 2K-Decklack glänzend + WBC Binder 2K-Decklack matt mixing ratio 1:1 by weight/ by volume = 30 GU

WBC Binder 2K-Decklack glänzend + WBC Binder 2K-Decklack matt mixing ratio 1:2 by weight/ by volume = 15 GU

Preparing the ready-to-use mixture Mipa WBC Binder 2K-Decklack matt:

Please note that the binders must be well shaken or stirred before tinting and also later before processing in order to ensure a homogeneous and correct gloss level.

70 parts by weight Mipa WBC Binder 2K-Decklack matt + 30 parts by weight Mipa WBC base tinter mixture

Please note: Due to the system, the binder additives will lighten the colour shade.

This mixture + Mipa WBC-Härter mixing ratio 5 : 1 by weight or 4 : 1 by volume

Important: Always stir in first the hardener in the basic paint and then thin with Mipa WBC-Verdünnung. Never add the water to the hardener.

Adjust the spray viscosity of this mixture with hardener by adding 20- 25 % Mipa WBC-Verdünnung.

Substrate preparation:

TPU, PA, ABS, PP:

Degrease with Mipa Silikonentferner or Mipa Kunststoffreiniger antistatisch or use preparation processes suitable for plastic parts like plasma processing or flame treatment. In order to ensure optimum adhesion, appropriate application tests are recommended!

If the above mentioned pre-treatment methods are not feasible, proceed as follows:

Degrease thoroughly the surfaces with Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.

Sand thoroughly with MP Soft Pad superfine using Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.

Clean again with Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.

Allow parts to dry thoroughly.

ATTENTION: Releasing agents must be removed completely! After the aforesaid preparation we recommend doing a wetting test with water. If the water rolls off quickly repeat the pre-treatment.

In case of other plastic types or adhesion problems, we recommend using Mipa 1K-Kunststoffprimer or Mipa 1K-Haftpromoter as adhesion promoter.

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For the coating of metal substrates a previous priming with suitable Mipa primers or fillers is necessary.

The following primers are recommended for steel, galvanised surfaces and aluminium:

Mipa 2K-Multifiller, Mipa 2K-Acryl-Grundierfiller, Mipa 2K-Acrylgrund, Mipa EP-Grundierfiller, Mipa EP-Primer-Surfacer, Mipa 2K-EP-Expressprimer EPX, Mipa 2K-Acryl-Epoxygrund

After drying, pre-sanding is necessary:

In case of one-layer topcoat use sanding paper P 400 for dry sanding or P 600 for wet sanding. In case of a two-layer topcoat we recommend to use the sanding paper P 500/ 600 for dry sanding and P 800/ 1000 for wet sanding.

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