

Intended use

High-quality, waterborne matt 2K textured paint for repair work on bumpers, trim strips, exterior mirrors, dashboards, door panels, centre consoles etc. for interior and exterior plastic substrates commonly used in vehicle construction. Due to the fine, sand-like texture, common plastic textures can be imitated easily with Mipa WBC Binder 2K-Strukturlack matt. This is particularly an advantage if these plastic textures has been removed by sanding during the repair work. Mipa WBC Binder 2K-Strukturlack matt is also suitable to coat primed metal substrates in interior and exterior use. As this product can be tinted with Mipa WBC, it is available in a large range of colours. After curing, it fulfills the requirements to sweat and saliva resistance according to DIN 53160-1 and -2.

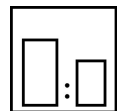
Spreading rate: 14,5 - 15,1 m²/l (for 20 µm DFT)

Processing instructions



Colour

tintable with Mipa WBC-Mischlacken



Mixing ratio

Hardener

Mipa WBC-Härter

by weight (lacquer : hardener)

5 : 1

by volume (lacquer : hardener)

4 : 1



Hardener

for complete paintwork

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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 the hardener thoroughly into the base paint first and only then dilute with Mipa WBC Verdünnung. Never add water to the hardener.

gravity spray gun

16 - 18 s 4 mm DIN

Airmix/Airless

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Application mode

Application mode

gravity spray gun (high pressure)

HVLP (low pressure)

HVLP / internal nozzle pressure

Hardener

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pressure (bar)

2 - 2,5

2 - 2,2

0,7

nozzle (mm)

1,2 - 1,3

1,2 - 1,3

–

spray passes

2 - 3

2 - 3

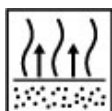
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Thinner

20 - 25 %

20 - 25 %

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Flash-off time

5 - 8 min between coats

15 - 20 min prior to oven drying

Dry coat thickness

30 - 50 µm



Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	45 - 60 min	4 h	–	–	–
60 °C	–	1 h	–	–	–

Note

Storage: at least 2 years in unopened original container
Store in frost-free places.

VOC Regulation : EU Limit value for this product of 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 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

Processing instructions:

Gloss level: matt

Prepare the ready-to-spray mixture of Mipa WBC Binder 2K-Strukturlack matt:

Please note that the binder must be shaken or stirred well before tinting and later before application in order to achieve a homogeneous and correct gloss level.

70 parts by weight of Mipa WBC Binder 2K-Strukturlack matt + 30 parts by weight of Mipa WBC tinter

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 y volume

Important: Always stir the hardener thoroughly into the base paint first and only then dilute with Mipa WBC Verdünnung. Never add water to the hardener.

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

Substrate pre-treatment:

TPU, PA, ABS, PP:

Degrease with Mipa Silikonentferner or Mipa Kunststoffreiniger antistatisch or use appropriate pre-treatment methods for plastic parts such as plasma processing or flame treatment. To ensure optimum adhesion it is recommend testing the recoatability.

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

Thoroughly degrease the surface with Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.

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

Clean again with Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.

Allow parts to dry completely.

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

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

When coating metal substrates, it is necessary to apply first a priming coat with appropriate Mipa primers or fillers.

Generally we recommend the following primers for application on steel, galvanised substrates 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 curing, it is necessary to sand the surface as follows:

Pre-sand with sandpaper P 400 dry or P 600 wet