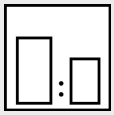
WEP 1010-20 grey WBS 2K EP Primer ready to use

Intended use

Water-based 2K epoxy resin zinc phosphate primer for steel, zinced substrates, aluminium and common plastics. Ready-to-use for applications by 2-component mixing and dosing units. Recoatable with all waterborne or solventborne 1K and 2K topcoats.

Colour: Grey. Further colour shades on request.

Processing instructions



Mixing ratio

hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
WEP 9500-25	5 : 1	3,5 : 1

Hardener

Mipa WEP 9500-25 WBS 2K EP Hardener

Pot life

3,5 h at 20 °C

Thinner

Mipa WBS VE-Wasser

Processing viscosity

Ready for use after adding hardener, if necessary thin with Mipa WBS VE-Wasser.

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 - 2,2	1,3 - 1,8	2 - 3	0 %
Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,23 - 0,33	1 - 2	0 %
brush, roller	--	--	--	--	0 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	45 - 55 min	1 - 2 h	24 - 48 h	--	2 h
--	60 °C	--	45 - 60 min	1 h	--	30 min

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Note

Characteristics:	binder base:	epoxy solid resin dispersion
	solids content (% by weight):	~ 65
	solids content (% by volume):	~ 46
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	~ 1,6
	gloss level ISO 2813 at 60° (GU):	< 20 matt

Properties:

Active corrosion protection (zinc phosphate)
very good resistance to chemical and mechanical strains
Suitable to insulate thermoplastic substrates
Weldable according to sheet 0501 of DSV (German welding society) as per expertise (no. 27567004039) of SLV (Schweißtechnische Lehr- und Versuchsanstalten (German welding institutes))
Heat resistance:
- Short-term heat exposure: 180 °C
- Permanent heat exposure: 150 °C

Adhesion to steel, zinced substrates, aluminium and plastics (PMMA, PC, ABS, PBTP, GFK, PC/ABS-Blend)

Theoretical spreading rate:

~ 28,1 m²/kg, 5:1 by weight with WEP 9500-25, for 10 µm dry film thickness.
~ 38,6 m²/l, 5:1 by weight with WEP 9500-25, 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:

< 70 g/l.

Processing conditions:

From + 10 °C and up to 70 % relative humidity. Ensure adequate air ventilation.

Substrate preparation:

Remove oil, grease, rust, mill scale, rolling skins, as well as other substances impairing the function of the coating!

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 substrate.

Steel:
- 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.

Zinced substrates:
- Clean the surface with the ammonia solution Mipa Zinkreiniger.
- Sweep blast.

Aluminium:
- Degrease with Mipa 2K-Verdünnung, sand thoroughly with sandpaper P 360/400 and clean subsequently with Mipa Silikonentferner.

Plastics:
- Clean (remove completely any mould release agents), degrease with Mipa Kunststoffreiniger, sand slightly and degrease again with Mipa Kunststoffreiniger.

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Proposed coating structure:

Steel, zinced substrates:
Priming coat: WEP 1010-20 with 50 - 60 µm dry film thickness.
Finishing coat: *WPU 2425-XX with 50 - 60 µm dry film thickness.

Aluminium, plastics:
Priming coat: WEP 1010-20 with 25 - 30 µm dry film thickness.
Finishing coat: *WPU 2425-XX with 50 - 60 µm dry film thickness.

Special notes:

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

For professional use only.

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.

Mix the hardener with the product by mechanical stirring (approx. 2 min.).

Attention: The end of pot life does not manifest itself by viscosity increase. Exceeding the pot life results in a lower resistance to mechanical and chemical strains, in a reduction of gloss and in a higher tendency to bubbling.

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

Recoatable at the earliest after 30 min at 60 °C or 2 h at 20 °C and at the lastest after 4 weeks. After drying for more than 4 weeks, intermediate sanding is required.

Can be overcoated with putty after 60 minutes at 60 °C.

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.

If required we also offer cleaning agents that are suitable for 2-component mixing and dosing units. Please contact your technical adviser or our application technicians.

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