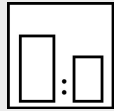


Intended use

This water-based 2K epoxy resin top coating for steel, zinc substrates, aluminium and common plastics can be applied by brushing, rolling or spraying.

Processing instructions



Mixing ratio

hardener

WEP 9500-25

by weight (lacquer : hardener)

5 : 1

by volume (lacquer : hardener)

3,7 : 1



Hardener

Mipa WEP 9500-25 WBS 2K EP Hardener



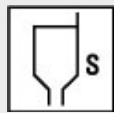
Pot life

3 - 4 h at 20 °C



Thinner

Mipa WBS VE-Wasser



Processing viscosity

gravity spray gun

30 - 40 s 4 mm DIN

Airmix/Airless

50 - 60 s 4 mm DIN



Application mode

application mode

gravity spray gun / HVLP

Airmix / Airless compound pressure

brsuh, roller

hardener

–

–

–

pressure (bar)

2,0 - 2,5

1,0 - 2,0
100 - 120

–

nozzle (mm)

1,4 - 1,8

0,23 - 0,33

–

spray passes

2 - 3

1 - 2

–

dilution

0 - 5 %

0 %

0 %



Drying time

hardener

–

–

object temperature

20 °C

60 °C

dust dry

45 - 55 min

–

set to touch

1 - 2 h

45 - 60 min

ready for assembly

24 - 48 h

60 min

sandable

–

–

recoatible

2 h

30 min

After a drying of more than 24 hours, intermediate sanding is necessary.

Note

Characteristics:

binder base:

solids content (% by weight):

solids content (% by volume):

delivery viscosity DIN 53211 4 mm (in s):

density DIN EN ISO 2811 (kg/l):

gloss level ISO 2813 at 60° (GU):

epoxy solid resin dispersion

~ 59

~ 39

Thixotrop

~ 1,5

35 - 45 semigloss

Properties:	Active corrosion protection (zinc phosphate) Very good resistance to chemical and mechanical strains Suitable to insulate thermoplastic substrates Heat resistance: - Short-term heat exposure: 180 °C - Permanent heat exposure: 150 °C Adhesion to steel, zinc substrates, aluminium and plastics (PMMA, PC, ABS, PBTP, GFK, PC/ABS-Blend)
Theoretical spreading rate:	~ 25,4 m ² /kg for 10 µm dry film thickness. ~ 31,9 m ² /l 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:	< 40 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. Zinc 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.
Proposed coating structure:	Single-coat system Steel, zinc substrates, aluminium: WEP 2000-50 with 50 - 60 µm dry film thickness. 2-coat system Steel, zinc substrates: Priming coat: *WEP 1000-20 with 60 - 80 µm dry film thickness. Finishing coat: WEP 2000-50 with 50 - 60 µm dry film thickness. Aluminium, plastics: Priming coat: *WEP 1000-20 with 25 - 30 µm dry film thickness. Finishing coat: WEP 2000-50 with 50 - 60 µm dry film thickness.

Special notes:

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

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The details of the paragraphs - Proposed coating structure, Characteristics, Theoretical spreading rate, VOC - refer to the colour shade RAL 7035. For other colour shades, these may deviate.

Water-based paints tinted with aluminium pastes have a limited shelf life, are sensitive and must be protected from heat. Store at max. 35 °C. Failure to comply may result in thickening and 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.

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.

Check colour prior to application.

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.