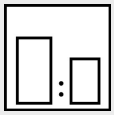
WPU 2220-30 WBS 2K PU Topcoat Industry satin matt

Intended use

Waterborne, satin matt 2K topcoat for industrial coating of machines, components, constructions, agricultural machinery and construction vehicles.

Processing instructions



Mixing ratio

hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
WPU 9000-25, WPU 9400-25	6 : 1	5 : 1
WPU 9410-25	5 : 1	4 : 1

Hardener

Mipa WPU 9000-25, Mipa WPU 9400-25

Mipa WPU 9410-25 WBS 2K PUR Hardener

Pot life

3,5 h at 20 °C*

Thinner

Mipa WBS VE-Wasser

Processing viscosity

Always stir first the hardener into the paint and then thin by adding Mipa WBS VE-Wasser. Never mix water with the hardener.

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 - 2,5	1,2 - 1,5	2 - 4	15 - 20 %
Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,23 - 0,33	1 - 2	0 - 10 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	20 - 30 min	5 - 6 h	24 h	--	--
--	60 °C	--	30 min	45 min	--	--

Fully cured after 7 - 8 days (at 20 °C).

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Note

Characteristics:	binder base:	polyurethane polyester system
	solids content (% by weight):	~ 55
	solids content (% by volume):	~ 38
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	~ 1,4
	gloss level ISO 2813 at 60° (GU):	20 - 30 satin matt

Properties:

Highly UV- and weather-resistant
Highly resistant to bubbling up to a dry film thickness of approx. 100 µm
Highly resistant to solvents
Heat resistance:
- Short-term heat exposure: 180 °C
- Permanent heat exposure: 150 °C

Adhesion to steel, zinced substrates and plastics (PC, ABS, PBTP, GRP)

Theoretical spreading rate:

~ 27,8 m²/kg for 10 µm dry film thickness.
~ 33,1 m²/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:

< 100 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:

Single coat system
Steel, zinced substrates and plastics (PC, ABS, PBTP, GRP):
WPU 2220-30 with 60 - 70 µm dry film thickness.

2-coat system
Steel, zinced substrates:
Priming coat: ***WEP 1000-20 with 60 - 80 µm dry film thickness.
Finishing coat: WPU 2220-30 with 50 - 60 µm dry film thickness.

Aluminium:
Priming coat: ***WEP 1000-20 mit 25 - 30 µm dry film thickness.
Finishing coat: WPU 2220-30 mit 50 - 60 µm dry film thickness.

Special notes:

*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.

**This product contains the following maximum VOC-values:
- Applied by spraying with the hardeners WPU 9000-25 or WPU 9400-25 : < 100 g/l of VOC.
- Applied by spraying with the hardener WPU 9410-25 : < 360 g/l of VOC.

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

For professional use only.

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.

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.

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.

Check colour prior to application.

Especially UV-resistant pigmentations (e.g. pastel shades for facades) are available on demand.

Depending on the hardener in use and on the processing condition, the gloss level may prove to be higher or lower. The mentioned data refer to the hardener WPU 9410-25. When using the hardener WPU 9000-25 and 9400-25, the figures will be significantly higher.

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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