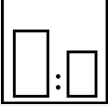








Intended use

High-quality waterborne glossy 2K polyurethane paint that provides particularly high resistance to chemical agents and UV. Especially suitable for coatings on vehicles, metal facades as well as machines and constructions exposed to high strain. Its very slow initial drying and the related very good spray mist absorption render the product perfect for application on large surfaces.

Processing instructions

	Mixing ratio hardener		by weight (lacquer : hardener)	by volume (lacquer : hardener)				
	WPU 9425-25		4 : 1	4 : 1				
	Hardener	Mipa WPU 9425-25						
	Pot life	3,5 h at 20 °C*						
	Thinner	Mipa WBS VE-Wasser						
	Processing viscosity	Always stir first the hardener in the paint and then thin by adding Mipa WBS VE-Wasser. Never mix water with the hardener.						
	gravity spray gun		Airmix/Airless					
	--		--					
	Application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution		
	gravity spray gun/ HVLP	--	2,0 - 2,5	1,2 - 1,3	2	20 - 25 %		
	Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,23 - 0,28	1 - 2	0 - 10 %		
	Drying time	hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
	--		20 °C	1 - 1,5 h	8 - 10 h	24 h	--	--
	--		60 °C	--	1,5 h	1,5 h	--	--

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

Note

Characteristics:	binder base: polyurethane polyester system solids content (% by weight): ~ 51 solids content (% by volume): ~ 34 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): 50 - 60 semi-gloss
Properties:	high water resistance highly UV- and weather-resistant highly resistant to solvents scratch-resistant excellent resistance to chemical and mechanical strains heat resistance: - short-term heat exposure: 180 °C - permanent heat exposure: 150 °C
Theoretical spreading rate:	~ 27,5 m ² /kg for 10 µm dry film thickness ~ 30,6 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:	< 60 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 metal 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 zincd 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
Proposed coating structure:	steel, zincd substrates: priming coat: ***WEP 1000-20 with 60 - 80 µm dry film thickness finishing coat: WPU 2425-30 with 50 - 60 µm dry film thickness aluminium: priming coat: ***WEP 1000-20 with 25 - 30 µm dry film thickness finishing coat: WPU 2425-30 with 50 - 60 µm dry film thickness

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This technical data sheet is supplied for informational purposes only! According to our information, all data and recommendations correspond to the state of art and are based on years of experience in manufacturing our products. They do not exempt the user from his obligation to verify professionally, on his own responsibility, the suitability of our products to the intended purpose under prevailing conditions. Safety data sheets and warnings on packaging must be observed. We reserve the right to modify and to complete the information content at any time, without prior notice or obligation to update.

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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 blister.

**This product contains the following maximum VOC-values:
- Applied by spraying with hardener WPU 9425-25: < 210 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 shade prior to application.

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

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.