WPU 3000-70 WBS 2K PU Texture Topcoat satin gloss

Intended use

Waterborne 2K polyurethane texture paint for industrial coating of vehicles, machines, components, constructions, steel lockers and tools. For interior and exterior use.

Processing instructions

Mixing ratio

hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
WPU 9400-25	5 : 1	4 : 1

Hardener

Mipa WPU 9400-25 WBS 2K PUR Hardener

Pot life

3 h at 20 °C*

Thinner

Mipa WBS VE-Wasser

Processing viscosity

Always stir first into 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
thixotropic	thixotropic

Application mode

application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
gravity spray gun/ HVLP	--	2,0 - 2,5	1,8 - 3,0	2	10 - 15 %
paint pressure gun compound pressure	--	2,0 - 2,5 0,5 - 0,8	1,8 - 2,5	1 - 2	10 - 15 %
Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,23 - 0,33	1	5 - 10 %
paint brush, roller	--	--	--	--	0 - 5 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	50 - 60 min	6 - 7 h	24 h	--	--
--	60 °C	--	45 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):	~ 59
	solids content (% by volume):	~ 41
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	~ 1,5
	gloss level ISO 2813 at 60° (GU):	satin gloss**

Properties:

Highly resistant to water
Highly UV- and weather-resistant
Highly resistant to chemicals and solvents
Scratch-resistant
Free from silicone
Heat resistance:
- Short-term heat exposure: 180 °C
- Permanent heat exposure: 150 °C

Registered according to MAN standard (M 3094-3)

Theoretical spreading rate:

~ 35,4 m²/kg for a 10 µm dry film thickness.
~ 42,4 m²/l for a 10 µm dry film thickness.

Storage:

For at least 1 year 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.

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.

Proposed coating structure:

Steel, zinced substrates:
Priming coat: ***WEP 1000-20 with 60 - 80 µm dry film thickness.
Finishing coat : WPU 3000-70 with 50 - 60 µm dry film thickness.

Aluminium:
Priming coat: ***WEP 1000-20 mit 25 - 30 µm dry film thickness.
Finishing coat: WPU 3000-70 mit 50 - 60 µm dry film thickness.

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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 bubbling.

**Due to the special surface, a measurement according to DIN EN ISO 2813 is inappropriate!

***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.

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