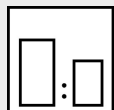


### Intended use

This waterborne 1K zinc phosphate primer for steel substrates can be applied by paint brush, roller, spraying and dipping. Recoatable with all solvent- and waterborne 1K and 2K paints.

### Processing instructions



#### Mixing ratio

hardener

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by weight (lacquer : hardener)

--

by volume (lacquer : hardener)

--



#### Hardener

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#### Pot life

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#### Thinner

Mipa WBS VE-Wasser



#### Processing viscosity

Dip coating: 19 - 21 s 4 mm DIN.

gravity spray gun

30 - 40 s 4 mm DIN

Airmix/Airless

50 - 60 s 4 mm DIN



#### Application mode

application mode

hardener

pressure  
(bar)

nozzle  
(mm)

spray  
passes

dilution

Gravity spray gun/  
HVL

--

2,0 - 2,2

1,5 - 1,8

2 - 3

2 - 7 %

Airmix / Airless  
compound pressure

--

1,0 - 2,0  
100 - 120

0,23 - 0,33

1 - 2

0 - 2 %

Brushing, rolling

--

--

--

--

0 %

Dip coating

--

--

--

1 - 2

5 - 8 %



#### Drying time

hardener

object  
temperature

dust dry

set to  
touch

ready for  
assembly

sandable

recoatable

--

20 °C

15 - 25 min

25 - 35 min 24 h

--

1 - 2 h (1 h for  
waterborne  
paints, 2 h for  
solventborne  
paints)

--

60 °C

--

5 - 7 min

45 min

--

25 min

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**Note**

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<b>Characteristics:</b>	binder base: styrene acrylic copolymer solids content (% by weight): ~ 50 solids content (% by volume): ~ 37 delivery viscosity DIN 53211 4 mm (in s): 80 - 100 density DIN EN ISO 2811 (kg/l): ~ 1,3 gloss level ISO 2813 at 60° (GU): < 20 matt
<b>Properties:</b>	short drying times corrosion protection high tolerance of grease and oil heat resistance: - short-term heat exposure: 120 °C - permanent heat exposure: 80 °C adhesion to steel
<b>Theoretical spreading rate:</b>	~ 29,2 m²/kg for 10 µm dry film thickness ~ 34,0 m²/l for 10 µm dry film thickness
<b>Storage:</b>	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.
<b>VOC:</b>	< 70 g/l.
<b>Processing conditions:</b>	From + 10 °C and up to 70 % relative humidity. Ensure adequate air ventilation.
<b>Substrate preparation:</b>	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
<b>Proposed coating structure:</b>	steel: priming coat: WSA 1000-20 with 50 - 60 µm dry film thickness finishing coat: *WAY 2000-40 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.

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.

When using as dip coating, the bath condition must be checked at regular intervals using several parameters. If you notice any abnormalities or have any questions, please contact your technical adviser or our application technicians.

Drying times reduce with increasing air velocity and decreasing 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.

**Cleaning of tools:**

Clean tools immediately after use with Mipa WBS-Pistolenreiniger.