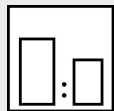


Intended use

Water-based 2K epoxy resin zinc phosphate primer for steel, zincd substrates, aluminium and common plastics. Ready-to-use for applications by 2-component mixing and dosing units. Recoatable with all waterborne or solventborne 1K and 2K topcoats.

Colour: grey

Processing instructions



Mixing ratio

hardener

WEP 9500-25

by weight (lacquer : hardener)

5 : 1

by volume (lacquer : hardener)

3,5 : 1



Hardener

Mipa WEP 9500-25



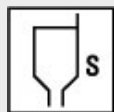
Pot life

3,5 h at 20 °C



Thinner

ready to use, if necessary thin with Mipa WBS VE-Wasser



Spray 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

brush, roller

hardener

–

–

–

pressure (bar)

2,0 - 2,2

100 - 120

–

nozzle (mm)

1,3 - 1,8

0,23 - 0,33

–

spray passes

2 - 3

1 - 2

–

dilution

0 %

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 1 h

ready for assembly

24 - 48 h

1 h

sandable

–

–

recoatable

2 h

30 min

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

Note

Characteristics:	binder base:	epoxy solid resin dispersion
	solids content (% by weight):	60 - 65
	solids content (% by volume):	43 - 46
	delivery viscosity DIN 53211 4 mm (in s):	thixotropic
	density DIN EN ISO 2811 (kg/l):	1,4 - 1,6
	gloss level ISO 2813 at 60° (GU):	10 - 20 matt
Properties:	active corrosion protection (zinc phosphate)	
	very good resistance to chemical and mechanical strains	
	suitable to insulate thermoplastic substrates	
	weldable according to sheet 0501 of DSV (German welding society) as per expertise (no. 27567004039) of SLV (Schweißtechnische Lehr- und Versuchsanstalten (German welding institutes))	
	heat resistance:	
	- short-term heat exposure: 180 °C	
	- permanent heat exposure: 150 °C	
	adhesion to steel, zincd substrates, aluminium and plastics (PMMA, PC, ABS, PBTP, GFK, PC/ABS-Blend)	
Theoretical spreading rate :	27,2 - 28,1 m ² /kg for 10 µm dry film thickness	
	37,8 - 38,6 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 Regulation :	EU limit value according to Directive 2004/42/EC for this product (category A/j) :140 g/l. This product has the following maximum VOC-values: applied by brush/ roller, spraying with hardener WEP 9500-25: < 70 g/l of VOC	
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	
	plastics:	
	- clean (remove completely any mould release agents), degrease with Mipa Kunststoffreiniger, sand slightly and degrease again with Mipa Kunststoffreiniger	

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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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Proposed coating structure: steel, zincd substrates:
priming coat: WEP 1010-20 with 50 - 60 µm dry film thickness
finishing coat: *WPU 2425-XX with 50 - 60 µm dry film thickness

aluminium, plastics:
priming coat: WEP 1010-20 with 25 - 30 µm dry film thickness
finishing coat: *WPU 2425-XX with 50 - 60 µm dry film thickness

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

Special notes:

For professional use only.

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.

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 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

Recoatable at the earliest after 30 min at 60 °C or 2 h at 20 °C and at the latest after 4 weeks. After drying for more than 4 weeks, intermediate sanding is required.

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.

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.