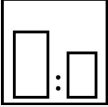








Intended use

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

Processing instructions

	Mixing ratio hardener						
			by weight (lacquer : hardener)	by volume (lacquer : hardener)			
	--	--	--	--			
	Hardener						
	--						
	Pot life						
	--						
	Thinner Mipa WBS VE-Wasser						
	Spray viscosity 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 - 2,2	1,5 - 1,8	2 - 3	2 - 7 %	
	Airmix / Airless	--	100 - 120	0,23 - 0,33	1 - 2	0 - 2 %	
	Streichen, Rollen	--	--	--	--	0 %	
	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

Note

Characteristics:	binder base:	styrene acrylic copolymer
	solids content (% by weight):	46 - 50
	solids content (% by volume):	36 - 37
	delivery viscosity DIN 53211 4 mm (in s):	60 - 80
	density DIN EN ISO 2811 (kg/l):	1,2 - 1,3
	gloss level ISO 2813 at 60° (GU):	10 - 20 matt
Properties:	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	
Theoretical spreading rate :	26,6 - 29,2 m ² /kg for 10 µm dry film thickness	
	33,4 - 34,0 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/d): 130 g/l. This product has the following maximum VOC-values: 68 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	
Proposed coating structure:	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 *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.

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.