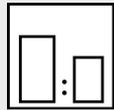


Intended use

Water-based 2K polyurethane acrylic topcoat with active corrosion protection for high-quality paintwork on commercial vehicles, machines and constructions. Excellent also for rolling or brush application. Adhesion on steel, zinc surfaces and aluminium. High UV and weather resistance as well as very good water resistance.

Processing instructions



Mixing ratio

hardener

WPU 9430-25

by weight (lacquer : hardener)

5 : 1

by volume (lacquer : hardener)

5 : 1



Hardener

Mipa WPU 9430-25



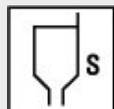
Pot life

2 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 the water with the hardener.

gravity spray gun

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Airmix/Airless

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Application mode

application mode

gravity spray gun/
HVLP

hardener

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pressure (bar)

2,0 - 2,5

nozzle (mm)

1,2 - 1,3

spray passes

2 - 4

dilution

20 - 25 %

Airmix / Airless
compound pressure

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1,0 - 2,0
100 - 120

0,23 - 0,28

1 - 2

0 %

paint brush, roller

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0 - 5 %



Drying time

hardener

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object temperature

20 °C

dust dry

45 - 50 min

set to touch

4 - 6 h

ready for assembly

24 h

sandable

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recoatible

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60 °C

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30 min

45 min

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

Note

Characteristics:	binder base:	polyurethane polyester system
	solids content (% by weight):	~ 50
	solids content (% by volume):	~ 30
	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):	50 - 60 semi-gloss
Properties:	high water-resistance	
	high UV and weather resistance	
	highly resistant to solvents	
	heat resistance:	
	- short-term heat exposure: 180 °C	
	- permanent heat exposure: 150 °C	
	adhesion to steel, zined substrates and aluminium	
Theoretical spreading rate:	~ 24,4 m ² /kg for 10 µm dry film thickness	
	~ 27,8 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:	< 110 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	
	zined 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: single coat system
steel, zincd substrates, aluminium:
WPU 2500-50 with 60 - 70 µm dry film thickness

2-coat system
steel, zincd substrates:
priming coat: ***WEP 1000-20 with 60 - 80 µm dry film thickness
finishing coat: WPU 2500-50 with 50 - 60 µm dry film thickness

aluminium:
priming coat: ***WEP 1000-20 with 25 - 30 µm dry film thickness
finishing coat: WPU 2500-50 with 50 - 60 µm dry film thickness

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 brush/ roller, spraying with hardener WPU 9430-25: < 110 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 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.