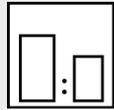


Intended use

Mipa WEP 2300-50 is a chemical- and abrasion-resistant 2K coating for metallic and mineral substrates in interior use. Suitable for coating floors in garages and warehouses.

Processing instructions



Mixing ratio

hardener

WEP 9300-25

by weight (lacquer : hardener)

4 : 1

by volume (lacquer : hardener)

3 : 1



Hardener

Mipa WEP 9300-25



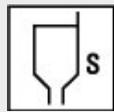
Pot life

3 - 4 h at 20 °C



Thinner

Mipa WBS VE-Wasser



Processing viscosity

gravity spray gun

25 - 30 s 4 mm DIN

Airmix/Airless

40 - 50 s 4 mm DIN



Application mode

application mode

gravity spray gun/
HVLP

hardener

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pressure (bar)

2,0 - 2,5

nozzle (mm)

1,3 - 1,8

spray passes

2 - 3

dilution

0 - 5 %

Airmix / Airless
compound pressure

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1,0 - 2,0
100 - 120

0,23 - 0,33

1 - 2

0 %

brush, roller

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0 %



Drying time

hardener

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object temperature

20 °C

dust dry

25 - 30 min

set to touch

4 - 6 h

ready for assembly

resistant to
mechanical
stress after 3
days

sandable

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recoatable

after 8 h,
walkable after
24 h

After drying of > 24h, intermediate sanding is necessary. Resistant to fork lift traffic and to chemicals after 7 days.

Note

Characteristics:	binder base:	dispersion of solid epoxy resin
	solids content (% by weight):	~ 59
	solids content (% by volume):	~ 39
	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):	35 - 45 semi-gloss
Properties:	highly scratch- and choc-resistant	
	highly abrasion-resistant, adapted to fork lift traffic	
	resistant to dilute acids and alkali, water, oils, fuel, de-icing salt (unsuitable for permanent stress, e.g. tanks, collecting troughs)	
	resistant to plasticiser	
	excellent adhesion to mineral substrates like e.g. concrete, cement screed	
Theoretical spreading rate:	~ 23,8 m ² /kg for 10 µm dry film thickness	
	~ 29,6 m ² /l for 10 µm dry film thickness	
	The dry film thickness of 200 µm must not be exceeded.	
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:	< 40 g/l.	
Processing conditions:	Do not apply at a object temperature below + 10 °C or above + 30 °C.	
	The substrate temperature must be minimum 3 °C above the dew point temperature of the air during the application and drying process (DIN EN ISO 12944-7)	
	The relative air humidity must not exceed 70 %.	
	Ensure adequate air ventilation.	
	Application of primer and paint should only be done at constant or decreasing temperatures to reduce the risk of blistering due to air heating in the pores of the substrate. (This also applies to all indoor applications that are exposed to the sun).	

Substrate preparation:

Substrate characteristics:

- Mineral substrates (set, dimensionally stable, rough and solid) must be free from friable parts and other substances that may affect the adhesion (e.g. rubber marks, greases, oils, rust, dust and similar).
- The equilibrium moisture content must have been achieved (concrete, cement screed < 4 % by weight, anhydrite screed < 0.3 % by weight, magnesite floor < 4 % by weight).
- The bond strength must be > 1.5 N/mm².
- The compression strength of the substrate must be > 25 N/mm².
- Ensure perfect insulation against earth moisture.

Check for laitance or brittle, non-adherent layers:

- By scratching the surface with a sharp device or a needle at different spots.

Result:

- Brittle layer of approx. 1 mm underneath a thin hard surface

Repair:

- Remove area mechanically by shot-blasting or milling to a solid substrate.
- Remove area by acid washing (apply a solution of hydrochloric acid (10 %), then wash again with clear water) to a solid substrate.

Check for dense concrete surfaces (smooth, hard and almost "shiny"):

- Test the absorbency by scratching and wetting at different spots.

Result:

- Only the scrapes become darker (indicates the absorption) and the area around the scratches show no absorption.

Repair:

- These dense layers must be removed mechanically by shot-blasting or milling until perfect absorbency is achieved.
- Remove area by acid washing (apply a solution of hydrochloric acid (10 %), then wash again with clear water) until perfect absorbency is achieved.

Oil, grease, wax and residues of soapsuds:

- Wash by using a cleaning agent (do not use products which contain care additives such as wax, silicone, a.s.o.) and repeat the operation if necessary.
- Sometimes deep penetrated substrates are impossible to clean. Remove by milling heavily contaminated areas and renew.

The pores have to be open and free of dust:

- Clean the surface by using a powerful industrial vacuum cleaner. This is particularly important when the floor has been treated mechanically.

Old paintworks:

- Sand slightly well adherent 2K-coatings. Test compatibility (on a sample area).
- Damaged coatings must be removed completely (mechanically or by paint remover).

Proposed coating structure:

In case of new, highly absorbent substrates, apply a priming coat with WEP 2300-50 diluted 1:1 with water. Work in the substrate using a sealer brush.

smooth coating:

priming coat: WEP 2300-50 diluted up to 10 %

finishing coat: WEP 2300-50 undiluted

non-slip coating:

priming coat: WEP 2300-50 diluted up to 10 %, incl. 10 - 30 % by weight of Mipa Grip-Substrat

finishing coat: WEP 2300-50 undiluted

Special notes:

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.

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.

Check colour prior to application.

Surfaces, on which Flock Chips have been scattered, are not suitable for garages and storehouses (as they are only suitable for foot traffic).

In case of adjacent surfaces use only the material of one batch number or intermix different batches to obtain the required quantity. Pour the mixed material in a new clean container and mix again thoroughly.

Cleaning of tools:

Clean tools immediately after use with Mipa WBS-Pistolenreiniger.