Mipa WBS 1K-Grundierfiller

Product Information

This 1K waterborne primer-surfacer is designed for automotive finishes on iron, steel, zinc and aluminium supports. Recoatable with all common solvent-borne and water-borne Mipa 1K and 2K finishing paints. Fast drying and easy to sand. Can be used as insulating groundcoat for thermoplastic old coatings.
High covering rate: 6 - 8 m^2 / liter (by approx. 50 µm dry coat thickness)

Colour availability	deep gray (approx. RAL 7011)		
Mixing ratio	-		
Dilution	0 - 5 % demineralized water Mipa VE-Wasser		
Spraying viscosity 20° C	35 - 40 s 4 mm DIN		
Application	spraying pressure	spraying nozzle	spraying operations
HVLP	2,0 - 3,0 bar 0,7 bar nozzle int.pressure	1,7 - 1,9 mm	2
High pressure	3 - 4 bar	1,4 - 1,6 mm	2
Coat thickness / dry film	50 - 70 µm		
Curing time / Flash off time	5 - 8 min. between the spraying operations (the flashed off surface should show a dull lustre)		

Drying	recoat time	dust dry	set to touch	sandable
Object temp. 20° C	60 min.	25 min.	60 min.	4 h
Object temp. 60° C	30 min.	5 min.	20 min.	30 min
IR-drying (short waves)				8 min.

VOC regulation	EU limiting value for product (cat. B/c): 540 g/l (2007) This product contains max. 1 g/l VOC. [0.008 lbs/gal]

Process conditions:
From +10°C and up to 75% relative air humidity. The product should only be used in well ventilated rooms.

Recommendation for end-use:
A noticeable acceleration of the drying time is achieved by increasing the air speed and by lower relative air humidity. Over 50 % reduction in drying time by using air blowers. Store protected against frost. During the operation, keep the spray gun cup closed to avoid the hardening. Deep the spray gun nozzle in water after use. Galvanized supports should be cleaned first with ammonia alkaline wetting agent Mipa Zinkreiniger.

Optimal process conditions:
Air temperature: 20 - 25 °C; object temperature > 15 °C; rel. air humidity: 40 - 60 %,
air speed: > 0,3 m/s

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.