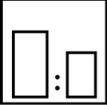


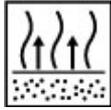
### Intended use

Waterborne 2K polyurethane soft paint with particularly soft feel effect for use in car interiors (e.g. coating of dashboards, door panels, centre consoles, etc.) and for coating of plastic parts in general in the areas of die-cast components, consumer care, furniture etc.. Mipa WBC Binder 2K-Softfeel provides direct adhesion on ABS and ABS-PC plastic substrates, but can also be used on primed metal substrates in interior use. The application of Mipa WBC Binder 2K-Softfeel improves considerably the haptic properties especially of hard plastic surfaces since the soft feel effect provides the sensation of a soft high-quality surface.

Spreading rate: 405 - 490 sq.ft/gal by 1 mil. 10 - 12 m<sup>2</sup>/l 25 µm

### General informations

	<b>Colour</b> tintable with Mipa WBC-paint					
	<b>Mixing ratio</b>					
	<b>Hardener</b>	<b>by weight (lacquer : hardener)</b>	<b>by volume (lacquer : hardener)</b>			
	Mipa WBC-Hardener	10 : 1	10 : 1			
	<b>Hardener</b>					
	<b>for complete paintwork</b>			<b>for partial paintwork</b>		
	–			–		
	<b>Pot life</b> max. 2 h at 70 °F (20 °C)					
	<b>Thinner</b> 20 - 25 % Mipa WBC-Thinner					
	<b>Spray viscosity</b> Always stir in first the hardener in the basic paint and then thin with Mipa WBC-Thinner. Never add the water to the hardener.					
	<b>gravity spray gun</b>			<b>Airmix/Airless</b>		
	50 - 60 s 4 mm DIN			–		
	<b>Application mode</b>					
	<b>Application mode</b>	<b>Hardener</b>	<b>pressure (bar)</b>	<b>nozzle (mm)</b>	<b>spray passes</b>	<b>dilution (%)</b>
	HVLP (low pressure)	–	29 - 36 psi (2 - 2,5 bar)	1,2 - 1,3	2 - 3	20 - 25 %
	HVLP (low pressure)	–	29 - 36 psi (2 - 2,5 bar)	1,2 - 1,3	2 - 3	20 - 25 %
	HVLP / internal nozzle pressure	–	9,8 psi (0,7 bar)	–	–	–



### Flash-off time

5 - 8 min between coats

15 - 20 min prior to oven drying

### Dry coat thickness

2 - 2,4 mil (50 - 60 µm)



### Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
70 °F (20 °C)	20 - 30 min	3 - 4 h	–	–	–
140 °F (60 °C)	–	45 min	–	–	–

### Note

#### Storage:

In tightly closed original containers at least 1 year shelf life.  
Storage temperature range 50 - 86°F (10 - 30 °C)  
Protect package from direct sunlight and heat.

#### VOC Information:

VOC as packaged:  
less exempt solvents 134 g/l / 1,1 lb/gl  
with exempt solvents 134 g/l / 1,1 lb/gl

Always check local VOC laws to ensure that the use of Mipa products is compliant in your area.

#### Processing conditions:

From 50 °F (10 °C) and up to 80 % relative air humidity. Ensure an adequate air ventilation.

Drying times reduce with increasing air velocity and decreasing relative humidity.

Optimum processing conditions:  
air temperature 70 - 80 °F (20-25°C)  
object temperature > 60 °F (15°C)  
relative air humidity 40-60 %  
air velocity 0,25 - 0,3 m/s

### General informations:

Gloss level DIN EN ISO 2813 at 60° angle (gloss units): < 6 very matt

Preparing the ready-to-use mixture Mipa WBC Binder 2K-Softfeel:

Please note that the binders must be well shaken or stirred before tinting and also later before processing in order to ensure a homogeneous and correct gloss level.

70 parts by weight Mipa WBC Binder 2K-Softfeel + 30 parts by weight WBC base tinter mixture

This mixture + Mipa WBC-Hardener mixing ratio 10 : 1 by weight/ by volume

Important: Always stir in first the hardener in the basic paint and then thin with Mipa WBC-Thinner. Never add the water to the hardener.

Adjust the spray viscosity of this mixture with hardener by adding 20- 25 % Mipa WBC-Thinner.

Substrate preparation:

ABS, ABS-PC:

Degrease with Mipa Silikonentferner or Mipa Kunststoffreiniger antistatic or use preparation processes suitable for plastic parts like plasma processing or flame treatment. In order to ensure optimum adhesion, appropriate application tests are recommended!

If the above mentioned pre-treatment methods are not feasible, proceed as follows:

Degrease thoroughly the surfaces with Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.

Sand thoroughly with MP Soft Pad superfine using Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.

Clean again with Mipa Kunststoffreiniger antistatisch or Mipa Silikonentferner.

Allow parts to dry thoroughly.

ATTENTION: Releasing agents must be removed completely! After the aforesaid preparation we recommend doing a wetting test with water. If the water rolls off quickly repeat the pre-treatment.

In case of other plastic types or adhesion problems, we recommend using Mipa 1K-Adhesion Promoter.

For the coating of metal substrates a previous priming with suitable Mipa primers or fillers is necessary.

The following primers are recommended for steel, galvanised surfaces and aluminium:

Mipa 2K-Multifiller, Mipa EP-Grundierfiller, Mipa 1K Fastfiller

After drying, pre-sanding is necessary:

In case of one-layer topcoat use sanding paper P 400 for dry sanding or P 600 for wet sanding. In case of a two-layer topcoat we recommend to use the sanding paper P 500/ 600 for dry sanding and P 800/ 1000 for wet sanding.

Notes about drying:

Drying at 20 °C for at least 1 day is required to form the basic adhesion. The final properties regarding full adhesion and softfeel effect are obtained after about 5 - 6 days drying at 20 °C.

Notes about dry film thickness:

The formation of the soft-feel effect depends on the film thickness and the composition of the plastic or its surface hardness. Therefore, coating tests should be carried out in advance on the plastic part to be painted to achieve the desired soft-feel effect.

Safety aspect:

For professional use only. Not for sale to or use by the general public. Before opening the packages be sure you understand the warning Messages on the Labels and Safety Data Sheets of all components since the mixture will have the hazards of all of its parts. The manufacturer recommends the use of an air supplied Respirator when exposed to vapors or spray mist.

Medical Response:

Emergency Medical or Spill Control Information 011 49(0)700 24112112 (MIP)  
US Emergency Phone Number (for transportation incidents only) 1-800-535-5053  
(Infotrac)

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