

Intended use

This one-component water-based primer filler for car coating is suitable for iron, steel, zinc and aluminium substrates. It is overcoatable with all common solvent- and water-based 1K or 2K Mipa topcoats and characterized by its fast drying and good sandability. This product can also be used as insulating primer on old thermoplastic paintworks.

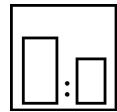
Spreading rate: 244 - 325 sq.ft/gal by 1 mil

General informations



Colour

dark grey approx. RAL 7011



Mixing ratio

Hardener

by weight (lacquer : hardener)

by volume (lacquer : hardener)

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Hardener

for complete paintwork

for partial paintwork

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Pot life

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Thinner

0 - 5 % Mipa WBC Thinner



Spray viscosity

gravity spray gun

Airmix/Airless

35 - 40 s 4 mm DIN

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Application mode

Application mode

Hardener

pressure (bar)

nozzle (mm)

spray passes

Thinner

HVLP (low pressure)

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1,6 - 2

1,3 - 1,8

2

0 - 5

HVLP / internal nozzle pressure

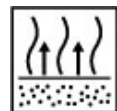
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0,7

1,3 - 1,8

2

0 - 5



Flash-off time

5 - 8 min between coats

Dry coat thickness

2 - 3 mil (50 - 75 µm)



Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
70° F (20° C)	20 - 30 min.	1 h	--	4 h	1 h
140° F (60° C)	5 min.	20 min.	--	30 min.	30 min.
infrared drying shortwave	--	--	--	8 min.	--
infrared drying mediumwave	--	--	--	10 - 15 min.	--

Note

Storage: In tightly closed original containers at least 2 years shelf life.
Storage temperature range 50 - 86°F (10 - 30 °C)
Protect package from direct sunlight and heat.
Protect package from frost.

VOC Information: VOC as packaged:
less exempt solvents 10 g/l / 0.1 lb/gal
with exempt solvents 10 g/l / 0.1 lb/gal

Regulated areas:

VOC Regulation:

RTS Combinations	WBS 1K-Grundierfiller	WBS 1K-Grundierfiller
Mixing ratio by volume	+ 0 % WBC Thinner (ready to use)	5 % WBC Thinner
Actual VOC (g/L)	5	4
Regulatory VOC (g/L)	10	10
Volatiles wt. %	43,1	45,8
Water wt. %	42,69	45,42
Exempt wt. %	-	-
Density (g/L)	1266	1250

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 supply and exhaust air ventilation.

General informations:

Drying times reduce with increasing air velocity and decreasing relative humidity. When drying with air guns, the drying time can be reduced considerably. Store in frost-free places. Galvanized substrates must be pre-treated with an ammonia solution (Mipa Zinkreiniger).

Optimum processing conditions:

air temperature 20-25°C; object temperature > 15°C; relative air humidity 40-60 %; air velocity >0,4 m/s

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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