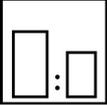


### Intended use

Water-based 1K zinc phosphate primer for steel, zinc substrates and aluminium. Can be applied by paint brush, roller and spraying. Recoatable with all solvent- and waterborne 1K and 2K paints.

### Processing instructions

	<b>Mixing ratio</b>						
	<b>hardener</b>		<b>by weight (lacquer : hardener)</b>	<b>by volume (lacquer : hardener)</b>			
	--		--	--			
	<b>Hardener</b>						
	--						
	<b>Pot life</b>						
	--						
	<b>Thinner</b>						
	Mipa WBS VE-Wasser						
	<b>Processing viscosity</b>						
	<b>gravity spray gun</b>			<b>Airmix/Airless</b>			
	30 - 40 s 4 mm DIN			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>	
	gravity spray gun/ HVL P	--	2,0 - 2,2	1,5 - 1,8	2 - 3	2 - 7 %	
	Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,28 - 0,33	1 - 2	0 - 2 %	
	paint brush, roller	--	--	--	--	0 %	
	<b>Drying time</b>						
	<b>hardener</b>	<b>object temperature</b>	<b>dust dry</b>	<b>set to touch</b>	<b>ready for assembly</b>	<b>sandable</b>	<b>recoatable</b>
	--	20 °C	20 - 30 min	30 - 40 min	24 h	--	45 min - 2 h (45 min in case of waterborne paints, 2 h in case of solventborne paints)
	--	60 °C	--	7 - 10 min	1 h	--	15 min

### Note

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<b>Characteristics:</b>	binder base: acrylic polyester hybrid solids content (% by weight): ~ 50 solids content (% by volume): ~ 37 delivery viscosity DIN 53211 4 mm (in s): thixotropic density DIN EN ISO 2811 (kg/l): ~ 1,3 gloss level ISO 2813 at 60° (GU): < 20 matt
<b>Properties:</b>	High corrosion protection Excellent resistance to chemical and mechanical strains Good resistance to grease and oils Heat resistance: - Short-term heat exposure: 180 °C - Permanent heat exposure: 130 °C Adhesion to steel, zined substrates and aluminium
<b>Theoretical spreading rate:</b>	~ 31,1 m <sup>2</sup> /kg for 10 µm dry film thickness. ~ 36,6 m <sup>2</sup> /l for 10 µm dry film thickness.
<b>Storage:</b>	For at least 1 year 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.
<b>VOC:</b>	< 119 g/l.
<b>Processing conditions:</b>	From + 10 °C and up to 70 % relative humidity. Ensure adequate air ventilation.
<b>Substrate preparation:</b>	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 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.
<b>Proposed coating structure:</b>	Steel, zined substrates, aluminium: Priming coat: WAY 1000-20 with 50 - 60 µm dry film thickness or with 25 - 30 µm dry film thickness on aluminium. Finishing coat: *WAY 2000-40 with 50 - 60 µm dry film thickness.

### Special notes:

\*Further Mipa topcoats are available. Please contact your technical adviser or our application technicians.

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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.

When alkyd resin (based) products are stored, a skin can form on the surface of the paint due to the system. This generally has no negative effects on the quality (material testing is recommended!).

If a skin has formed, it must be carefully removed before stirring (before tinting for bases) and the product must be sieved as required before application.

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.

To avoid possible occurring flash rust during the painting of bare and sandblasted steel parts add Mipa WBS Korrosionsinhibitor. Get more information about use in the data sheet Mipa WBS Korrosionsinhibitor.

### Cleaning of tools:

Clean tools immediately after use with Mipa WBS-Pistolenreiniger.