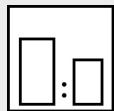


Intended use

Water-based 2K polyurethane acrylic topcoat with active corrosion protection for high-quality paintwork on commercial vehicles, machines and constructions. Excellent also for rolling or brush application. Adhesion on steel, zinc surfaces and aluminium. High UV and weather resistance as well as very good water resistance.

Processing instructions**Mixing ratio****hardener**

WPU 9430-25

by weight (lacquer : hardener)

5 : 1

by volume (lacquer : hardener)

5 : 1

**Hardener**

Mipa WPU 9430-25 WBS 2K PUR Hardener

**Pot life**

2 h at 20 °C*

**Thinner**

Mipa WBS VE-Wasser

**Processing viscosity**

Always stir first the hardener in the paint and then thin by adding Mipa WBS VE-Wasser. Never mix the water with the hardener.

gravity spray gun

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Airmix/Airless

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**Application mode****application mode****hardener****pressure
(bar)****nozzle
(mm)****spray
passes****dilution**gravity spray gun/
HVLP

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2,0 - 2,5

1,2 - 1,3

2 - 4

20 - 25 %

Airmix / Airless
compound pressure

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1,0 - 2,0
100 - 120

0,23 - 0,28

1 - 2

0 %

paint brush, roller

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0 - 5 %

**Drying time****hardener****object
temperature****dust dry****set to
touch****ready for
assembly****sandable****recoatable**

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20 °C

45 - 50 min

4 - 6 h

24 h

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60 °C

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30 min

45 min

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fully cured after 7 - 8 days (at 20 °C).

Note

Characteristics:	binder base: polyurethane polyester system solids content (% by weight): ~ 50 solids content (% by volume): ~ 30 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): 50 - 60 semi-gloss
Properties:	High water-resistance High UV and weather resistance Highly resistant to solvents Heat resistance: - Short-term heat exposure: 180 °C - Permanent heat exposure: 150 °C Adhesion to steel, zined substrates and aluminium
Theoretical spreading rate:	~ 24,4 m²/kg for 10 µm dry film thickness. ~ 27,8 m²/l for 10 µm dry film thickness.
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:	< 110 g/l. **
Processing conditions:	From + 10 °C and up to 70 % relative humidity. Ensure adequate air ventilation.
Substrate preparation:	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.
Proposed coating structure:	Single coat system Steel, zined substrates, aluminium: WPU 2500-50 with 60 - 70 µm dry film thickness. 2-coat system Steel, zined substrates, aluminium : Priming coat: ***WEP 1000-20 with 60 - 80 µm dry film thickness or with 25 - 30 µm dry film thickness on aluminium. Finishing coat: WPU 2500-50 with 50 - 60 µm dry film thickness.

Version: en 7/0424

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.

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Special notes:

*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 blister.

**This product contains the following maximum VOC-values:

- Applied by brush/ roller, spraying with hardener WPU 9430-25: < 110 g/l of VOC.

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

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.

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.

Check colour prior to application.

Especially UV-resistant pigmentations (e.g. pastel shades for facades) are available on demand.

Cleaning of tools:

Clean tools immediately after use with Mipa WBS-Pistolenreiniger.

If required we also offer cleaning agents that are suitable for 2-component mixing and dosing units. Please contact your technical adviser or our application technicians.