

Water thinnable two coat base tinter for the complete finishing or for spot repairs of cars, motorcycles and heavy goods vehicles. By overcoating with clearcoat Mipa 2K-Klarlacken a weather resistant surface of brilliant appearance will be created. All colours are lead and chromate free.  
Consumption: 7 - 9 m<sup>2</sup> / liter (by approx. 20 µm dry film thickness)

Colour availability	Mipa Color System		
Mixing ratio	10 - 20 % Mipa WBC-Verdünnung		
Thinner	Mipa WBC-Verdünnung		
Spraying viscosity 20°C	20 - 25 s 4 mm DIN		
Application	Spraying pressure	Spraying nozzle	Spraying operations
HVLP	2 - 2.5 bar	1.3 - 1.4 mm	2.5
Coat thickness / dry film	15 - 20 µm		
Curing time /Flash off time	5 - 8 min. between the spraying operations with the base tinter		
Dry	Recoatable with clearcoat Mipa 2K-Klarlacken:		
Object temp. 20°C:	20 min. (surface has to be completely satin gloss dried)		
Object temp. 60 °C	7 min. + allow 5 min cooling time		
with IR-drying (short wave)	2 min. + allow 5 min. cooling time		
with blower:	7 min.		
VOC content	EU limiting value for the product (cat. B/d): 420 g/l (2007) This product contains max. 420 g/l VOC [ 3.5 lbs/gal]		

**Processing conditions:**

From +10°C and up to 75% relative air humidity. Ass ure suitable ventilation.

**Special recommendations :**

Fast drying by higher air speed and lower relative air humidity conditions. By using a blower, the drying time will be accelerated with approx. 50 %. Storage protected against frost. Put on the pouring device only by necessity. Shake thoroughly for about 20 - 30 s before use.

**Optimal processing conditions:**

Air temperature: 20 - 25 °C; object temperature > 15 °C; rel. air humidity: 40 - 60 %, air speed: > 0.4 m/s

**Process recommendations:**

The first coat should be sprayed as a thin film, not too wet. By the second spraying operation the complete covering will be obtained in the most situations. To assure a perfect distribution of the aluminium pigments across the whole surface, a third thin coat is necessary (spraying mist technique). Spray as a mist the base tinter from a longer distance by using a reduced spraying pressure. To best bring out the special optical effect of this inovative product, it is advisable to follow the above recommendations. Do not apply directly on thermoplastic old coatings.

**Clearcoat:**

Mipa WBC-Basislacke could be recoated with all Mipa 2K-Klarlacken. For low emission VOC-limit values, the clear coats Mipa 2K HS-Klarlacke.

**Blending:**

For blending more difficult metallic- and effect tinters it is necessary to use the Mipa WBC Baseblend.

This data sheet is for information purpose only! To our knowledge the data provided complies with the latest standard and is based on years of experience in the manufacture of our products. However the data is not binding and without warranty. Please follow recommendations stated on the relevant safety data sheet and precautions stated on the product label. We reserve our right to make additions, deletions, or modifications to the information at any time without prior notification.