
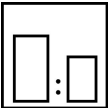





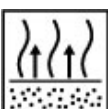


**Intended use**

Mipa WBC-Härter is a UV-resistant isocyanate hardener for Mipa WBC paints. The cross-linking of the hardener increases significantly the mechanical and chemical resistance of Mipa WBC paints. Thus, there is no need to overcoat these paints with a clearcoat when applying them in the interior. In doing so, please consider that only satin mat gloss levels can be realized.

Spreading rate: --

**Processing instructions**

	<b>Colour</b> colourless					
	<b>Mixing ratio</b>					
	<b>Hardener</b>	<b>by weight (lacquer : hardener)</b>	<b>by volume (lacquer : hardener)</b>			
	Mipa WBC-Härter	20 : 1	20 : 1			
	<b>Hardener</b>					
	<b>for complete paintwork</b>			<b>for partial paintwork</b>		
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	<b>Pot life</b> 2 - 3 h					
	<b>Thinner</b> 10 - 20 % Mipa WBC-Verdünnung					
	<b>Spray viscosity</b>					
	<b>gravity spray gun</b>			<b>Airmix/Airless</b>		
	22 - 25 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>Thinner</b>
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	<b>Flash-off time</b>					
	5 - 8 min between coats					
	10 - 15 min before oven drying					
	<b>Dry coat thickness</b> 15 - 20 µm					



**Drying time**

<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	5 - 10 min	2 h	12 h	--	--
60 °C	--	30 min	after cooling	--	--

**Note**

**Storage:** at least 2 years in unopened original container

**VOC Regulation :** --

**Processing conditions:** from +10 °C and up to 80 % relative air humidity. Ensure an adequate air ventilation.

**Processing instructions:** Attention: Add the thinner only after having mixed thoroughly the hardener with the paint! Mipa WBC-Härter is moisture-sensitive. Therefore, close the can immediately and tightly after every material withdrawal. The drying times are reduced when the air speed increases and the relative air humidity decreases. When drying with air guns the drying periods are reduced considerably.

Optimal processing conditions:  
air temperature: 20 - 25 °C  
object temperature: > 15 °C  
relative humidity of air: 40 - 60 %  
air velocity: 0,25 - 0,3 m/s