

Intended use

Mipa Body Coat WBS is a water-dilutable and environmentally friendly stone chip protection paint with sound-absorbing properties. Suitable also as an insulating primer with smooth surface.

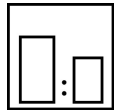
Spreading rate: 3,0 - 5,0 m²/l

Processing instructions



Colour

9105 black
9110 light grey



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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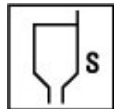
Pot life

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Thinner

ready for use



Spray viscosity

thixotropic (undiluted) when applied by means of underbody spray gun or Airmix/Airless; if used as insulating primer just add 10% water

gravity spray gun

Airmix/Airless

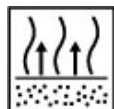
18 - 22 s 4 mm DIN

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Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
gravity spray gun	--	2 - 2,5	1,3 - 1,5	2	10
HVLP	--	2 - 2,2	1,3 - 1,5	2	10
Airmix / Airless	--	100 - 120	0,33 - 0,50	2	--
underbody spray gun/ UBS	--	4 - 6	5 - 10	2	--



Flash-off time

5 - 8 min between coats

10 - 15 min before oven drying

Dry coat thickness

100 - 300 µm

35 - 45 µm (as insulating primer)



Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	15 - 25 min	65 - 75 min	24 h	--	65 - 75 min
60 °C	--	15 - 25 min	1 h	--	15 - 25 min

Note

Storage: at least 2 years in unopened original container

VOC Regulation : EU limit value for this product (category B/e): 840 g/l
This product contains max. 50 g/l of VOC.

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

Processing instructions: The substrate must be dry, clean and free from grease and rust. Pre-treat iron and steel surfaces to protect against corrosion. Sand slightly aluminium surfaces and old paintwork. The underbody must be cleaned thoroughly. It must be dry, free from dust, grease, oil and rust. Old non-adherent underbody coating must be removed. Mask beforehand motor, exhaust pipes, stub axles, cardan shaft and brake system as they must not be sprayed!