Mipa BC 2-Schicht-Basislack

Intended use

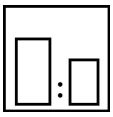
Solvent-based two-layer basecoat to coat completely or partially vehicles, motorbikes and commercial vehicles. Overcoating with Mipa 2K clearcoats results in a weather-resistant, high-gloss top coating. All colours are free from lead and chromate pigments.

Spreading rate: 7,0 - 9,0 m²/l

Processing instructions

Colour

Mipa Mix-System



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

2 : 1 by volume with Mipa BC-Verdünnung

2 : 1 by volume with Mipa BC-Verdünnung slow

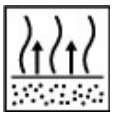
Spray viscosity

To increase the spraying viscosity, e.g. in case of higher processing temperatures, it's possible to use Mipa BC-Additiv VDG-HV (see technical data sheet of Mipa BC-Additiv VDG-HV) instead of "BC-VDG" (= Mipa BC-Verdünnung and part of BC-formulations).

gravity spray gun	Airmix/Airless
16 - 18 s 4 mm DIN	--

Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
gravity spray gun (high pressure)	--	2 - 2,5	1,2 - 1,3	2 - 3	--
HVLP (low pressure)	--	2 - 2,2	1,2 - 1,3	2 - 3	--
HVLP / internal nozzle pressure	--	0,7	--	--	--



Flash-off time

2 - 5 min between coats

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Dry coat thickness
15 - 20 µm

Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	--	--	--	--	10 - 15 min

Note

Storage: at least 2 years in unopened original container

VOC Regulation : This product contains > 420 g/l of VOC.

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

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Processing instructions:

Put the lid with spout only if needed. Stir the tinter thoroughly before every use.

Processing:

Stir Mipa BC-Lack very thoroughly before use. Check colour prior to application. Not suitable to be applied on old thermoplastic paintworks!

Apply 2-3 layers of Mipa BC-Lack uniformly as follows:

Apply every layer semi-wet and flowing. Observe the flash-off times between the spray passes and let each layer dry to a matt finish.

Do not apply too wet (to avoid mottling when applying effect colours). In case of mottling, allow the film to start drying and spray a uniform mist coat from higher distance to the object to be painted. In so doing, effect pigments are spread more homogenously and mottling can be removed. Be careful not to apply to much spray mist as this may lead to marks and possibly to colour deviations!

Blending:

For blending difficult metallic and effect colours, we recommend the use of Mipa BC 000.

Mipa BC 000 is mixed with Mipa BC-Verdünnung (thinner) (mixing ratio: 2:1 by volume) to a ready-to-spray solution and is applied as a wet, flowing film either on the blending zone or on the entire surface to be painted. Immediately afterwards, the actual BC colour is applied by blending. The still wet pre-coat BC 000 avoids the formation of rough overspray in blending zones.

3-layer coating (Coating 1 + Coating 2 + clearcoat):

It's necessary to add Mipa Härter to Coating 1 to improve the through drying. The painting process is as follows:

Coating 1 = Mipa BC-Basislack (basecoat) + Mipa 2K-Härter H 10 or Mipa 2K-MS-Härter MS 10 (hardener), Mixing ratio 10:1 by weight or volume, then thin with 40-50 % of Mipa BC-Verdünnung (thinner)

Intermediate flash-off: at least 5-10 minutes at room temperature..

Coating 2 can be applied without hardener as usual. The final flash-off time should be at least 20 minutes at room temperature prior to clearcoat appplication.

Application of poorly covering colours:

BC colours, which have a low hiding power due to the system; e.g. bright white colours; tend to higher film build. This may result in highly delayed drying and in an increase of clearcoat adhesion problems. As a precaution, we recommend therefore adding hardener to basecoat layers as follows:

Mipa BC-Basislack + Mipa 2K-Häter H 10 (hardener) or Mipa 2K-MS-Härter MS 10, mixing ratio 10:1 by weight or by volume, then thin with 40-50% Mipa BC-Verdünnung. The final flash-off time before overcoating with clearcoat should be at least 20 minutes at room temperature.

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Application of colours which contain Mipa Vicrom:

Due to the fact that Mipa Vicrom has a very fine pigmentation, the substrate needs to be especially prepared to prevent visible sanding marks:

1. final sanding with very fine wet sanding paper P 800 – 1000 or dry sanding paper P 1200 - 1500

2. apply beforehand a uniform closed layer with Mipa BC 000, after approx. 5 - 10 minutes flash-off time at room temperature overcoat with BC topcoats. Alternatively, it's possible to apply a 2K cleacoat as intermediate coat instead of Mipa BC 000. In this case just apply a closed flowing layer which can be overcoated after a short drying (dust dry).

Clearcoat application:

Mipa BC 2- Schicht-Basislacke (2-layer basecoats) can be overcoated with all Mipa 2K-Klarlack (clearcoats). When using Mipa 2K-HS-Klarlack (high solid clearcoats), please consider the following note:

Apply a 1st thin and closed layer. When applying too wet, wetting problems may occur, which lead to poor levelling properties. After a flash-off of approx. 3-5 minutes, apply the 2nd, final flowing layer.

Single-layer coating for interior use (e.g. engine compartment):

Cross-linking with the hardener increases considerably the mechanical and chemical resistance of Mipa BC 2-Schicht-Basislacke. Therefore, these coatings can be applied without clearcoat finish in engine compartments. We recommend the following mixing ratios:

Mipa BC-Basislack + Mipa 2K-Härter H 10 or Mipa 2K-MS-Härter MS 10;
mixing ratio to achieve a semi-gloss coating:

by volume: 2:1 (paint: hardener), afterwards thin with 30-40% Mipa BC-Verdünnung

Mipa BC-Basislack + Mipa 2K-Härter H 10 or Mipa 2K-MS-Härter MS 10;
mixing ratio to achieve a satin matt coating:

by volume: 5:1 (paint: hardener), afterwards thin with 30-40% Mipa BC-Verdünnung

Note: Since the gloss level strongly depends on the colour in use, we recommend a test application to assess the actual gloss level.

Pot life 2 - 3 hours at 20°C

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