PAINTNUTS
BODYSHOP SUPPLIES

TECHNICAL DATA SHEET
SOLVENT BASECOAT (BC)

Intended use

Mipa BC basecoat is a high performance basecoat/clearcoat tinting system. High hiding, easy application and fast drying improve color match and reduce cycle times. This System can be used for the repair of original basecoat/clearcoat finishes or a complete paint job of cars, busses and trucks. Mipa BC basecoat must be recoated with Mipa 2K-clearcoats.

All colours are free from lead and chromate pigments.

Spreading rate: 275 - 440 sq. ft/gal by 1 mil

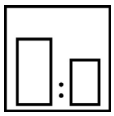
General informations

Colour

Mipa Color-System II, Color-System III

Mipa Mix Basic, Mipa Mix 5.0

Mipa Mix Elite



Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
see page 3 + 4	--	--

Hardener

for complete paintwork	for partial paintwork
--	--

Pot life

Mipa BC 2-Layer-Basecoat used with hardener 8 hours.

Thinner

2 : 1 by volume with Mipa BC-Thinner

2 : 1 by volume with Mipa BC-Thinner slow

2 : 1 by volume with Mipa Base-Coat Stabiliser

Spray viscosity

16 - 18 s 4 mm DIN

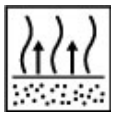
To increase the spraying viscosity, e.g. in case of higher processing temperatures, it's possible to use Mipa BC-Additiv VDG-HV (see technical data sheet of Mipa BC-Additiv VDG-HV) instead of "BC-VDG" (= Mipa BC-Thinner and part of BC-formulations in Mipa Mix).

gravity spray gun	Airmix/Airless
--	--

MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49(0)8703/922-0 · Fax: +49(0)8703/922-100 · mipa@mipa-paints.com · www.mipa-paints.com

Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
HVLP (low pressure)	--	28 - 36 psi (2 - 2,5 bar)	1,3 - 1,4	2 - 3	50 %
HVLP (low pressure)	--	28 - 36 psi (2 - 2,5 bar)	1,3 - 1,4	2 - 3	50 %
HVLP / internal nozzle pressure	--	9,8 psi (0,7 bar)	1,3 - 1,4	2 - 3	50 %



Flash-off time

5 - 8 min. between coats

Dry coat thickness

0,6 - 0,8 mil (15 - 20 µm)

Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
70 °F (20 °C)	5 min.	10 - 15 min.	--	--	10 - 20 min.

Note

Storage:

In tightly closed original containers at least 3 years shelf life.
Storage temperature range 50 - 86°F (10 - 30 °C)

Protect package from direct sunlight and heat.

VOC Information:

VOC as packaged:
less exempt solvents 734 g/l / 6.1 lb/gl
with exempt solvents 734 g/l / 6.1 lb/gl

VOC as applied:
less exempt solvents 787 g/l / 6.57 lb/gl
with exempt solvents 787 g/l / 6.57 lb/gl

Always check local VOC laws to ensure that the use of Mipa products is compliant in your area.

Processing conditions:

from 50 °F (10 °C) and up to 80 % relative air humidity.
Ensure an adequate supply and exhaust air ventilation.

Don`t apply Mipa BC basecoat directly in the sun.

MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49(0)8703/922-0 · Fax: +49(0)8703/922-100 · mipa@mipa-paints.com · www.mipa-paints.com

General informations:

Processing:
Ensure adequate air flow and proper air exhaust ventilation to enable proper drying of the basecoat.

Shake new Mipa BC-bases for 5 - 10 min. using a mechanical paint-shaker before placing on a mixing machine.
Mipa BC-bases on a mixing machine need to be agitated for 10 - 15 min. at the start of the working day and every 4 hours during the day to ensure good color matching. Check colour prior to application. Not suitable to be applied on thermoplastic paintworks!

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

Apply every layer medium-wet and flowing. Observe the flash-off times between the spray passes and let each layer dry to a mat finish. For sensitive color-shades, it`s allowed to spray a uniform mist coat (drop coat) from higher distance to the object to be painted. So, effect pigments are applied more homogenously. Be careful not to apply to much mist or drop coat as this may lead to marks and possibly to colour deviations or loss of gloss after clearcoat application.

Blending:
Mix Mipa BC 000 in a mixing ratio of 2:1 by volume with Mipa BC-Thinner to a ready-to-spray solution. Apply a wet, flowing film either on the blending zone or on the entire surface to be painted. Immediately afterwards, the actual BC colour can be applied by blending. BC 000 avoids the formation of dry, rough overspray in blending zones.

Alternative for blending: Mipa-Additive VDG-HV (ready to spray) can be used in same way.

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

It's necessary to add Mipa hardener to coating 1 to improve curing of the whole basecoat-clearcoat-system. Additional, adhesion of basecoat to clearcoat will be improved, too. The painting process is as follows:

Coating 1 = Mipa BC basecoat + Mipa 2K-hardeners. We recommend to use the hardener you will use in the Mipa clearcoat. Mixing ratio 10:1 by weight or volume, then thin with 40 - 50 % of Mipa BC-Thinner.

Intermediate flash-off: at least 10 - 15 minutes at room temperature.

Coating 2 can be applied with (very transparent Coating 2) or without hardener. 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. white, yellow or red 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 Mipa BC basecoat in mixing ratio 10:1 by weight or by volume.

The final flash-off time before overcoating with clearcoat should be at least 20 minutes at room temperature.

Please note:
Basecoat mixed with hardener has to be used the same day and can not be stored.

MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49(0)8703/922-0 · Fax: +49(0)8703/922-100 · mipa@mipa-paints.com · www.mipa-paints.com

BC T 980 and BC super black: To avoid clearcoat adhesion problems in case of resin-base and very high temperature of cars in the sun, we recommend adding hardener to Mipa BC basecoat in mixing ratio 10:1 by weight or by volume.

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 (mixed 2:1 with Mipa BC Thinner) or Mipa-Additive VDG-HV (ready to use). After approx. 5 - 10 minutes flash-off time at room temperature overcoat with BC topcoat.

Clearcoat application:

Mipa BC 2-layer basecoat can be overcoated with all Mipa 2K-Clearcoats.
Apply a first, medium and pinhole free layer. After a flash-off of approx. 3-10 minutes, apply the second final coat.

Tools should be cleaned immediately after use.

Safety aspect:
For professional use only. Not for sale to or use by the general public. Before opening the packages be sure you understand the warning Messages on the Labels and Safety Data Sheets of all components since the mixture will have the hazards of all of its parts.The manufacturer recommends the use of an air supplied Respirator when exposed to vapors or spray mist.

Medical Response:
Emergency Medical or Spill Control Information 011 49(0)700 24112112 (MIP)
US Emergency Phone Number (for transportation incidents only) 1-800-535-5053 (Infotrac)

Exclusive Importer: Fleetwood Products
3 American Way, Suite 15, Spotswood, NJ 08884 www.mipa-usa.com
fleetwood@mipa-usa.com. 732-416-9590 Phone, 732-416-9592 Fax.

MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49(0)8703/922-0 · Fax: +49(0)8703/922-100 · mipa@mipa-paints.com · www.mipa-paints.com

END OF DOCUMENT