

Technical Data Sheet

Muki WB A

Product description

Muki WB A is a waterborne prefabrication primer based on an acrylic emulsion binder.

Typical use

Preconstruction primer on blast cleaned steel surfaces in automatic shoppriming plants to protect steel during transport, storage and production. Contains non toxic pigments, and dries quickly. May be overcoated (C1-C3) with water borne acrylics and alkyds or solvent borne acrylics, alkyds, epoxy/ polyamide paints.

Colours

Red

Product data

Property	Test/Standard	Description
Solids by volume		40 ± 2 %
Gloss level (60°)		Matt
VOC-EU	calculated	40 g/l
Water resistance		Good (not in immersion)

Typical film thickness per coat

	Dry film thickness (µm)	Wet film thickness (µm)	Theoretical spreading rate (m ² /l)
Min	20	50	20.0
Max	30	75	13.3
Normal	25	63	16.0

Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

Steel surfaces:

Blast-cleaning to Sa 2½ (ISO-8501-1:2007)

Other surfaces:

The coating may be used on other substrates. Please contact Nor-Maali Oy for more information.

Conditions during application

A The temperature of the substrate should be minimum +5 °C and at least 3 °C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Good ventilation is usually required in confined areas to ensure proper drying. Recommended steel temperature: 30 ± 2 °C.

Application

Application methods

- Spray: Use airless spray or conventional spray (thin 5-10 % with fresh clean water).
- Brush: Recommended for stripe coating and small areas, care must be taken to achieve the specified dry film thickness.
- Roller: May be used for small areas.

Thinner/Cleaning solvent

Clean water

Guiding data for airless spray

- Nozzle tip (inch/1000): 0,015-0,023" (0,38-0,53 mm)
- Pressure at nozzle (minimum): 15 Mpa (150 kp/cm², 2100 psi)
- Spray angle: 40-80 °
- Filter: Check to ensure that filters are clean

Drying and Curing time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- Good ventilation
- Typical film thickness
- One coat on top of inert substrate
- Relative humidity 70 %

Substrate temperature	+23 °C	+30 °C	+40 °C
Surface dry	5 min	2-4 min	1-3 min
Dry to handle	10 min	7 min	5 min
Dry to overcoat	10 min	7 min	5 min

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

Typical paint system

Muki WB A 1 x 25 µm (dry film thickness, measured on a smooth test panel)

Undamaged shopprimer can be overcoated with a choice of systems based on waterbased acrylic and alkyd or solventborne alkyd, acrylic, epoxy/polyamide paints.

If there is grease on Muki WB A’s surface, it should be removed with alkali- or emulsion cleaning or with thinner OH 02 before continue painting. Epoxy thinners or other strong solvents should not be used.

Procedure for preparation and cleaning of application equipment

To avoid solvent contamination of the water borne paint the spraying equipment has to be conditioned before use. All equipment containing solvents in the pump, hoses and gun have to be thoroughly cleaned according to the following instructions. If the application equipment is made in stainless steel, designed for and only used for application of water borne coatings this preparation and cleaning procedure is not needed.

- Before spraying Circulate Jotun Thinner No. 17 (OH 17) through the equipment and hoses. Then Jotun Thinner No. 4 (OH 04) before fresh clean water.

- After spraying Clean the equipment and hoses with water and detergent, then circulate Jotun Thinner No. 4 (OH 04) and finally Jotun Thinner No. 17 (OH 17).

Storage

The product must be stored above +4°C. Storage conditions are to keep the containers in a dry, cool and well ventilated space. Containers must be kept tightly closed. Muki WB A should be protected from temperatures higher than 40°C.

Handling

Handle with care. Stir well before use. With large covered containers (200 L) it is recommended that paint will be stirred continuously during use.

Packaging

	Volume (litres)	Size of containers (litres)
Muki WB A	20 / 200	20 / 200

Safety

Please follow the environmental and safety instructions displayed on the container and Safety Data Sheet. Use under well ventilated conditions. Do not breathe or inhale mist, use respirator mask. Avoid skin contact. Spillage on the skin should immediately removed with suitable cleanser, soap or water. In case of contact with eyes, rinse immediately with plenty of clean water and if necessary seek medical advice.

Disclaimer

The above information is given to the best of our knowledge based on laboratory tests and practical experience. However, as the paint is often used under conditions beyond our control, we cannot guarantee anything but the quality of the paint itself. We reserve the right to change the given data without notice. Please contact our office for more specific information.

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