



MIROTEC WB 8128 UNDERCOAT

MIROTEC WB 8128 is a pigmented, water based, single pack undercoat ideally suited to automatic lines. It may be applied by vacuum coater, curtain coater, roller coater and spray. Will air dry when needed but for optimum performance, force drying the coating in a purpose built oven is recommended. Use of an infra-red oven results in extremely fast curing.

Product Advantages

- Single pack, no pot life issues to manage
- Easy to sand
- Minimal sink back, evenly seals deeply machined fibre board
- Good opacity requiring minimal coats
- Excellent vacuum stability with minimal grit build up at template
- Reduction with water means less solvent into the atmosphere - low odour
- VOC (solvent content) is low, less than 60g/L

Typical Applications

Can be applied over most grades of MDF, Masonite and most timbers that have been thoroughly sanded.

Product Properties

Build:	Very Good
Sandability:	Excellent
Opacity:	Very Good
Solvent Resistance:	Resists splash and spillage
Water Resistance:	Excellent
Levelling & Flow:	Excellent
Sink Back:	Minimal

Typical Properties

Colour:	White
Gloss:	Matt

Coverage: 6-9m² per litre when applied with a conventional spray gun at 100 micron wet film build applied at 30-40 seconds application viscosity. This is dependent on the application equipment / gun set up and the article being coated.

Thinning: Thin up to 20% with water if required, depending upon application requirements.

Do not thin coating above the maximum set limit as the long term adhesion to the substrate will be severely compromised.

Application Viscosity: 25 - 45 seconds BS4 Flow Cup at 25°C.

Wet Film Thickness (WFT): 80-120 microns per coat.

Application Methods:

Vacuum Coater:

Vacuum: 100-150 mbar

Line Speed: 60-80 m/min

Substrate Temperature: 80°C

Oven Time: 60 seconds

Air Drying:

Touch Dry: 45 minutes

Hard Dry: 2 hours

Temperatures below 15°C will retard drying times

Forced Drying:

Dry time: 70°C 5 minutes

120°C 90 seconds

Cool Down: 20°C 10 mins

Block Stacking: Only after coated boards have been allowed to cool to room temperature and checked for suitability to be stacked.

Recommended Topcoats:

Most commonly used solvent and water based topcoats can be used. A test patch should always be evaluated prior to top coating to ensure compatibility.

Ensure MIROTEC WB 8128 is thoroughly sanded before topcoats are applied.

Application Equipment Clean Up: Clean all equipment with water following use and before coating has been allowed to dry.

Shelf Life: 12 months

Packaging: 200 litres and 1000 Pallecon

Refer to the MIROTEC WB Product Information Guide for more information.

Health & Safety

Before handling, refer to the Material Safety Data Sheet for health and safety information. Ensure that all personnel using this product have read and understood this data sheet and the associated MSDS and packaging label before using this product.

Mirotone Pty Ltd Australia (Head Office)
ABN 40 000 041 136
21 Marigold Street,
Revesby NSW 2212 Australia
P +61 2 9795 3700 F +61 2 9771 3601
sales@mirotone.com.au

Mirotone (NZ) Ltd New Zealand (Head Office)
32 Cryers Road,
Auckland, 1730, New Zealand
P +64 9 272 2730 F +64 9 272 2733
information@mirotone.co.nz

Mirotone (Thailand) Co., Ltd
83 Moo 4, Poochaosamingprai Rd,
Samrong Klang, Prapradaeng,
Samutprakam, 10130, Thailand
P +66 2 754 4451 F +66 2 754 4450

www.mirotone.com