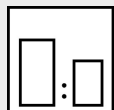


### Intended use

Fast-drying synthetic high-build primer with active corrosion protection (zinc-phosphate) for steel substrates. For interior and exterior use. Recoatable with Mipa 1K and 2K paints.

### Processing instructions



#### Mixing ratio

hardener

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by weight (lacquer : hardener)

--

by volume (lacquer : hardener)

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#### Hardener

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#### Pot life

2 days with Mipa Härterverdünnung



#### Thinner

Mipa UN-Verdünnung

Mipa Verdünnung UN 21

Mipa Härterverdünnung



#### Processing viscosity

gravity spray gun

30 - 35 s 4 mm DIN

Airmix/Airless

40 - 50 s 4 mm DIN



#### Application mode

application mode

hardener

pressure  
(bar)

nozzle (mm)

spray  
passes

dilution

gravity spray gun /  
HVL

--

2,0 - 2,5

1,3 - 1,8

2 - 3

10 - 15 %

Airmix / Airless  
compound pressure

--

1,0 - 2,0  
100 - 120

0,28 - 0,33

1 - 2

0 - 5 %

by brush, roller

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--

--

--

0 %



#### Drying time

hardener

object  
temperature

dust dry

set to  
touch

ready for  
assembly

sandable

recoatable

--

20 °C

15 - 20 min

45 - 60 min

4 - 5 h

--

1 - 2 h (1 h for  
1K paints, 2 h  
for 2K paints)

--

60 °C

--

--

30 min

--

--

Fully cured after 3 - 4 days (20 °C).

**Note****Characteristics:**

binder base:	alkyd resin
solids content (% by weight):	~ 75
solids content (% by volume):	~ 54
delivery viscosity DIN 53211 4 mm (in s):	thixotropic
density DIN EN ISO 2811 (kg/l):	~ 1,6
gloss level ISO 2813 at 60° (GU):	< 20 matt

**Properties:**

short drying time  
active corrosion protection (zinc phosphate)  
electrostatic application possible  
high-build, excellent filling properties  
high vertical stability  
short-term heat exposure 150 °C  
permanent heat exposure 120 °C  
adhesion on steel

**Theoretical spreading rate :** ~ 35,3 m²/kg for 10 µm dry film thickness  
~ 54,5 m²/l for 10 µm dry film thickness

**Storage:**

For at least 3 years in the unopened original container. Optimum storage conditions between + 5 °C and + 25 °C, avoid direct sunlight. Other storage conditions may lead to undesirable properties of the material.

**VOC:**

< 400 g/l.\*

**Processing conditions:**

From + 10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.

**Substrate preparation:**

Remove oil, grease, rust, mill scale, rolling skins, as well as other substances impairing the function of the coating!

Attention: A direct adhesion cannot be taken as granted due to most different kinds of metals, alloys, metallic and conversion coatings and so on. The adhesion must therefore be tested on the original metal substrate.

steel:

- blast to cleaning degree Sa 2½, remove blast residues and overcoat promptly
- de-rust with hand and power tools to degree of cleanliness St 3
- degrease with Mipa WBS Reiniger or Mipa Silikonentferner

**Proposed coating structure:**

steel:  
priming coat: AK 105-20 with 50 - 60 µm dry film thickness  
finishing coat: \*\*AK 200 / AK 240 / AK 250 with 50 - 60 µm dry film thickness

**Special notes:**

\*This product contains the following maximum VOC-values:

- Applied by spraying: < 490 g/l.

\*\*Further Mipa primers are available. Please contact your technical adviser or our application technicians.

For professional use only.

The details of the paragraphs - Proposed coating structure, Characteristics, Theoretical spreading rate, VOC - refer to the colour shade RAL 7035. For other colour shades, these may deviate.

Do not overcoat with high-solid Mipa 2K topcoats.

Without top coating, the primed objects can be stored outside for approx. 5 days.

**Cleaning of tools:**

Clean tools immediately after use with Mipa Nitroverdünnung.