AY 100-20 1K Vario Primer

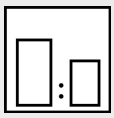
Technical data sheet

Intended use

This 1K acrylic primer provides active corrosion protection and excellent adhesion on steel and zinced steel as well as good adhesion properties on aluminium. Recoatable with solvent-based or water-based 1K or 2K paints.

Colour: RAL 7004 signal grey. Further colour shades on request.

Processing instructions



Mixing ratio

hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
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Hardener

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Pot life

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Thinner

Mipa UN-Verdünnung

Mipa Verdünnung UN 21

Processing viscosity

gravity spray gun	Airmix/Airless
25 - 30 s 4 mm DIN	40 - 50 s 4 mm DIN

Application mode

application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
gravity spray gun/ HVLP	--	2,0 - 2,5	1,4 - 1,5	2 - 3	10 - 15 %
Airmix / Airless compound pressure	--	1,0 - 2,0 100 - 120	0,28 - 0,33	1 - 2	0 - 5 %

Drying time

hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
--	20 °C	5 - 10 min	25 - 35 min	1 h	--	1 h
--	60 °C	--	--	30 min	--	--

Fully cured after 2 - 3 days (20 °C).

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Note

Characteristics:

binder base:	acrylic resin
solids content (% by weight):	~ 66
solids content (% by volume):	~ 45
delivery viscosity DIN 53211 4 mm (in s):	thixotropic
density DIN EN ISO 2811 (kg/l):	~ 1,5
gloss level ISO 2813 at 60° (GU):	10 - 20 matt

Properties:

short drying times
excellent filling properties
active corrosion protection (zinc phosphate)
electrostatic application possible
heat resistance:
- short-term heat exposure: 150 °C
- permanent heat exposure: 130 °C

adhesion on steel and zinced substrates
adhesion on aluminium Gt 0 - 1

Theoretical spreading rate :

~ 33,1 m²/kg for 10 µm dry film thickness
~ 45,7 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:

< 470 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

zinced substrates:
- clean the surface with the ammonia solution Mipa Zinkreiniger
- sweep blast

aluminium:
- degrease with Mipa 2K-Verdünnung, sand thoroughly with sandpaper P 360/400 and clean subsequently with Mipa Silikonentferner

Proposed coating structure:

steel, zinced substrates:
priming coat: AY 100-20 with 60 - 80 µm dry film thickness
finishing coat: **VC 200-50 with 50 - 60 µm dry film thickness

aluminum:
priming coat: AY 100-20 with 20 - 30 µm dry film thickness
finishing coat: **VC 200-50 with 50 - 60 µm dry film thickness

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Special notes:

*This product contains the following maximum VOC-values:
- Applied by spraying: < 550 g/l ov VOC.

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

For professional use only.

Cleaning of tools:

Clean tools immediately after use with Mipa Nitroverdünnung.

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