Intended use

Fast drying primer with good filling power and high corrosion protection. Excellent flow. Outstanding adhesion on steel, aluminium, galvanized substrates and various plastics. Recoatable with 1K and 2K paints.
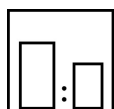
Spreading rate: 10,0 - 11,0 m²/l (for 25 µm DFT)

Processing instructions

Colour
dark grey (approx. RAL 7011)

Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
Mipa 2K-Härter H 10	5 : 1	4 : 1
Mipa 2K-MS-Härter MS 10	5 : 1	4 : 1
Mipa 2K-MS-Härter HS 10	5 : 1	4 : 1

Hardener

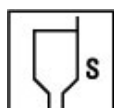| for complete paintwork	for partial paintwork
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Pot life
4 - 5 h with Mipa 2K-Härter H 10 / MS 10 / HS 10 at 20 °C

Thinner
0 - 5 % Mipa 2K-Verdünnung kurz V 10

0 - 5 % Mipa 2K-Verdünnung V 25

Spray viscosity

gravity spray gun	Airmix/Airless
20 - 25 s 4 mm DIN	-

Application mode

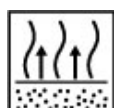| Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
gravity spray gun (high pressure)	--	1,6 - 2	1,4 - 1,5	2	0 - 5
HVLP (low pressure)	--	1,6 - 2	1,3 - 1,6	2	0 - 5
HVLP / internal nozzle pressure	--	0,7	--	--	--

Flash-off time
5 - 8 min between coats

10 - 15 min prior to oven drying

Dry coat thickness
20 - 30 µm

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Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	25 - 30 min	60 - 70 min	--	--	30 min
60 °C	10 - 15 min	20 - 30 min	--	--	15 min

Note

Storage: at least 3 years in unopened original container

VOC Regulation :

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

Processing instructions: Do not apply on thermoplastic substrates.

Remove non cured old paint works and priming coats.

The substrate must be clean, dry and free from grease.

Substrate preparation: All substrates must be cleaned beforehand with Mipa Silikonentferner. Galvanised substrates must be pre-treated with an ammoniac wetting agent.
Pretreatment: Sand aluminium with P 220, steel with P 120. After sanding clean again thoroughly with Mipa Silikonentferner.