# AK 100-20 Synthetic Primer

Technical data sheet



#### Intended use .

Fast drying synthetic primer for steel substrates. For interior and exterior use. Recoatable with Mipa 1K and 2K paints.

### Processing instructions



]	Mixing ratio hardener 	by weight (lacquer : hardener) 	by volume (lacquer : hardener) –
	Hardener 		
	<b>Pot life</b> 2 days with Härterverdünnung		
•	<b>Thinner</b> Mipa UN-Verdünnung Mipa Verdünnung UN 21 Mipa Härterverdünnung		
5	<b>Processing viscosity</b> gravity spray gun 30 - 35 s 4 mm DIN	<b>Airmix/Airless</b> 40 - 50 s 4 mm	DIN

Ŕ	Application mode application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
	gravity spray gun / HVLP	-	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%
	brushing, rolling		-	-	-	0 %



$\bigcirc$	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).

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Note			Professional Coating Systems			
Characteristics:	binder base: solids content (% by weight): solids content (% by volume): delivery viscosity DIN 53211 4 mm (in s): density DIN EN ISO 2811 (kg/l): gloss level ISO 2813 at 60° (GU):	alkyd resin ~ 74 ~ 53 100 - 120 ~ 1,6 < 20 matt				
Properties:	short drying time excellent filling properties electrostatic application possible corrosion protection short-term heat exposure 150 °C permanent heat exposure 120 °C adhesion on steel					
Theoretical spreading rate :	: ~ 34,5 m²/kg for 10 $\mu m$ dry film thickness ~ 52,5 m²/l for 10 $\mu m$ 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:	< 419 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 substanc 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:	e: steel: priming coat: AK 100-20 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 has the following maximum VOC-values: - Applied by spraying: < 490 g/l of VOC.					
	**Further Mipa topcoats are available. Please contact your technical adviser or our application technicians.					
	For professional use only.	sional use only.				
	The details of the paragraphs - Proposed coating structure, Chara spreading rate, VOC - refer to the colour shade RAL 7035. For ot 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.					

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**Cleaning of tools:** 

Clean tools immediately after use with Mipa Nitroverdünnung.

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