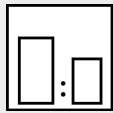



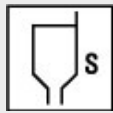




### Intended use

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

### Processing instructions

	<b>Mixing ratio</b>						
	<b>hardener</b>		<b>by weight (lacquer : hardener)</b>	<b>by volume (lacquer : hardener)</b>			
	--		--	--			
	<b>Hardener</b>						
	--						
	<b>Pot life</b>						
	2 days with Härterverdünnung						
	<b>Thinner</b>						
	Mipa UN-Verdünnung						
	Mipa Verdünnung UN 21						
	Mipa Härterverdünnung						
	<b>Processing viscosity</b>						
	<b>gravity spray gun</b>			<b>Airmix/Airless</b>			
	30 - 35 s 4 mm DIN			40 - 50 s 4 mm DIN			
	<b>Application mode</b>						
	<b>application mode</b>	<b>hardener</b>	<b>pressure (bar)</b>	<b>nozzle (mm)</b>	<b>spray passes</b>	<b>dilution</b>	
	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 %	
	<b>Drying time</b>						
	<b>hardener</b>	<b>object temperature</b>	<b>dust dry</b>	<b>set to touch</b>	<b>ready for assembly</b>	<b>sandable</b>	<b>recoatable</b>
	--	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

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<b>Characteristics:</b>	binder base:	alkyd resin
	solids content (% by weight):	~ 74
	solids content (% by volume):	~ 53
	delivery viscosity DIN 53211 4 mm (in s):	100 - 120
	density DIN EN ISO 2811 (kg/l):	~ 1,6
	gloss level ISO 2813 at 60° (GU):	< 20 matt

<b>Properties:</b>	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

<b>Theoretical spreading rate :</b>	~ 34,5 m <sup>2</sup> /kg for 10 µm dry film thickness
	~ 52,5 m <sup>2</sup> /l for 10 µm dry film thickness

<b>Storage:</b>	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.
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<b>VOC:</b>	< 419 g/l.*
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<b>Processing conditions:</b>	From + 10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.
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<b>Substrate preparation:</b>	Remove oil, grease, rust, mill scale, rolling skins, as well as other substances impairing the function of the coating!
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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

<b>Proposed coating structure:</b>	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
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<b>Special notes:</b>	*This product has the following maximum VOC-values: - Applied by spraying: < 490 g/l of VOC.
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\*\*Further Mipa topcoats 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.