# AY 100-20 1K Vario Primer

**Technical data sheet**

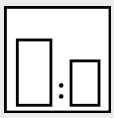


## Intended use

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) |
|---|---|---|
| -- | -- | -- |

### 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<br>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): | < 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 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: Mipa 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.

When alkyd resin (based) products are stored, a skin can form on the surface of the paint due to the system. This generally has no negative effects on the quality (material testing is recommended!).
If a skin has formed, it must be carefully removed before stirring (before tinting for bases) and the product must be sieved as required before application.

**Cleaning of tools:**

Clean tools immediately after use with Mipa Nitroverdünnung.





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