

## Product Information

This 1K waterborne primer-surfacer is designed for automotive finishes on iron, steel, zinc and aluminium supports. Recoatable with all common solvent-borne and water-borne Mipa 1K and 2K finishing paints. Fast drying and easy to sand. Can be used as insulating groundcoat for thermoplastic old coatings.

High covering rate: 6 - 8 m<sup>2</sup> / liter (by approx. 50 µm dry coat thickness)

Colour availability	deep gray (approx. RAL 7011)			
Mixing ratio	-			
Dilution	0 - 5 % demineralized water Mipa VE-Wasser			
Spraying viscosity 20°C	35 - 40 s 4 mm DIN			
Application	spraying pressure	spraying nozzle	spraying operations	
HVLP	2,0 - 3,0 bar 0,7 bar nozzle int.pressure	1,7 - 1,9 mm	2	
High pressure	3 - 4 bar	1,4 - 1,6 mm	2	
Coat thickness / dry film	50 - 70 µm			
Curing time / Flash off time	5 - 8 min. between the spraying operations (the flashed off surface should show a dull lustre)			
Drying	recoat time	dust dry	set to touch	sandable
Object temp. 20°C	60 min.	25 min.	60 min.	4 h
Object temp. 60°C	30 min.	5 min.	20 min.	30 min
IR-drying (short waves)				8 min.
VOC regulation	EU limiting value for product (cat. B/c): 540 g/l (2007) This product contains max. 1 g/l VOC. [ 0.008 lbs/gal]			

### Process conditions:

From +10°C and up to 75% relative air humidity. The product should only be used in well ventilated rooms.

### Recommendation for end-use:

A noticeable acceleration of the drying time is achieved by increasing the air speed and by lower relative air humidity. Over 50 % reduction in drying time by using air blowers. Store protected against frost. During the operation, keep the spray gun cup closed to avoid the hardening. Deep the spray gun nozzle in water after use. Galvanized supports should be cleaned first with ammonia alkaline wetting agent Mipa Zinkreiniger.

### Optimal process conditions:

Air temperature: 20 - 25 °C; object temperature > 15 °C; rel. air humidity: 40 - 60 %, air speed: > 0,3 m/s

This data sheet is for information purpose only! To our knowledge the data provided complies with the latest standard and is based on years of experience in the manufacture of our products. However the data is not binding and without warranty. Please follow recommendations stated on the relevant safety data sheet and precautions stated on the product label. We reserve our right to make additions, deletions, or modifications to the information at any time without prior notification.