

### Product Information

#### Product description

**Operational Sector :** Fast drying synthetic resin primer suitable for application in thick layers on steel substrates to give excellent anti-corrosive protection (zinc phosphate). For the interior and exterior use. Re-coatable with Mipa 1K and 2K paints. Chromate and lead free.  
Available in oxide yellow, medium grey and brown oxide.

**Specification :**

<b>Binder base:</b>	Alkyd resin
<b>Solid content:</b>	72 - 75 by weight -% 52 - 54 by volume -%
<b>Delivery viscosity (DIN 53 211):</b>	thixotrope
<b>Density (DIN EN ISO 2811):</b>	1.5 - 1.6 kg / l
<b>Gloss (DIN EN ISO 2813):</b>	10 - 20 units / 60° (mat)

**Features :**

- speedy initial dry, high filling power
- electrostatically applicable
- Humidity Resistance ASTM D4585 500 hours
- Salt Fog Resistance ASTM B117 500 hours
- adhesion ASTM D4541 tractive power 300 psi
- Flexibility: ASTM D522, 1" mandrel passes
- Direct Impact ASTM D2794 30 in.
- short-term temperature exposure: 300°F
- permanent temperature exposure: 250°F

**Theoret. Consumption :** (5,5 – 6 m<sup>2</sup>/Ltr. or 225 – 250 sq ft/gal by 3 mil dry coat thickness)

**Storage :** In tightly closed original containers at least 3 years shelf life  
Storage temperature 50 – 86 °F (10 - 30 °C)  
Protect package from direct sunlight and heat.

**VOC-information :** VOC as packaged:  
less exempt solvents 405 g/l / 3.4 lb/gl  
with exempt solvents 405 g/l / 3.4 lb/gl  
This product contains max. 420 g/l VOC [3.5 lbs/gal]

#### Application

**Processing Conditions:** From + 50°F and up to 80 % relative air humidity.

**Substrate Preparation :** **Iron / Steel:** recommended surface preparation SSPC-SP6

Application Process :	Pressure [psi]	Nozzle [mm/inch]	Spraying Operations	Thinner
<b>Air / Flow jar</b>	29 - 44	1.5 - 1.8	1 - 2	20 - 30 %
<b>Pressure pot</b>	29 - 44	1.1 - 1.3	1 - 2	20 - 30 %
<b>Airless</b>	1450 - 2150	0.28 - 0.33 (50 - 95 °)	1	0 - 20 %
<b>Brushing, rolling</b>	-	-	-	0 – 15 %

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.



# AK 105

## 1K Synthetic HB Primer

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### Product Information

<b>Dry</b> Object temp. 70 °F	<b>dust dry</b> 10 - 15 min.	<b>set to touch</b> 45 - 60 min.	<b>handle</b> 2 - 4 h	<b>recoatable</b> after 1 hour with 1K paints after 4 hours with 2K paints
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**Full Cure:** after 5 - 7 days (70 °F).

**Thinner :** Mipa ZERO VOC Thinner

**Application Proposal :**

<b>Steel:</b>	
Base coat:	1K AK 105 (coat thickness: 2 – 3 mil)
Top coat:	1K AK 246 (coat thickness: 2 – 3 mil)
	2K PU 240 (coat thickness: 2 – 3 mil)

### Special Recommendations

Always check local VOC laws to ensure that the use of Mipa products is compliant in your area.

Keep the recommended coat thickness in order not to prolong drying. The application of higher thickness may remarkably prolong the drying time. Please check for colour accuracy prior to use.

About 5 days outdoor storage of primed parts is possible (base-coated parts only, not recoated with a top coat. Minimum dry film thickness 2 mil).

For recoating with Mipa 2K PU 240 topcoat we recommend to use Mipa AK 105 with 5 -10% Mipa 2K Hardener Mipa PU 912-25 LV or Mipa PU 912-40 LV.

Not recommended for immersion service in water and salt water.  
Not recommended for use with portable water.

### Safety aspect

For professional use only. Not for sale to or use by the general public. Before opening the packages be sure you understand the warning Messages on the Labels and Safety Data Sheets of all components since the mixture will have the hazards of all of its parts. The manufacturer recommends the use of an air supplied Respirator when exposed to vapors or spray mist.

### Medical Response

Emergency Medical or Spill Control Information 011 49(0)700 24112112 (MIP)  
Emergency Telephone Number (for transportation incidents only): 1-800-535-5053 (Infotrac)

General Importer: Mipa USA Inc. 3 American Way, Suite 15, Spotswood, NJ 08884  
www.mipa-usa.com. Info@mipa-usa.com. 732-416-9590 Phone, 732-416-9592 Fax.

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