Mipa Rapidprimer

Technical data sheet

Intended use

Mipa Rapidprimer is a one-component adhesion primer with active corrosion protection for vehicles. It is suitable for iron, steel, zinc and aluminium substrates as well as for recoatable plastics commonly used in the automotive industry (we recommend verifying the recoatability). Apply only on well degreased substrates. Sand slightly zinc and aluminium. Do not apply on thermoplastic substrates. This product cannot be overcoated with polyester spray filler. Overcoatable with solvent-based and water-based 1K and 2K paints.

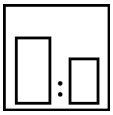
Spreading rate: 6,0 - 8,0 m²/l

Processing instructions



Colour

red brown



Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
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Hardener

for complete paintwork	for partial paintwork
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Pot life

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Thinner

50 % Mipa 2K-Verdünnung kurz V 10

50 % Mipa 2K-Verdünnung normal V 25

50 % Mipa Verdünnung UN / UN 21



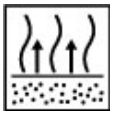
Spray viscosity

gravity spray gun	Airmix/Airless
18 - 22 s 4 mm DIN	--



Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	dilution (%)
gravity spray gun (high pressure)	--	1,6 - 2	1,3 - 1,8	1 - 2	50



Flash-off time

5 - 8 min between coats

10 - 15 min before oven drying

Dry coat thickness

10 - 15 µm

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Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	5 - 10 min	20 - 30 min	--	--	40 - 50 min

Note

Storage: at least 2 years in unopened original containers

VOC Regulation: EU limit value for this product (category B/c): 780 g/l
This product contains max. 680 g/l of VOC.

Processing conditions: from +10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.

Processing instructions: The weldability has been tested according to the directive of DVS (German Welding Society) sheet 0501 and certified with expertise no 275/670/99/925 by Schweißtechnischen Lehr- und Versuchsanstalt Halle/Germany (German Welding institutes).

Substrate preparation:

The substrate must be clean and dry.

Remove oil, grease, rust, mill skill, rolling skin as well as other substances impairing the function of the coating!

Remove old coatings or primers that have not cured or are not sound.

Do not use on thermoplastic substrates.

Steel substrates:
1. Pre-clean with Mipa Silikonentferner.
2. Then dry sand with P 120.
3. Afterwards, degrease with Mipa Silikonentferner.

Aluminium substrates + galvanised substrates (strip galvanising / continuous hot-dip galvanising) and electrogalvanising:
1. Pre-clean with Mipa Silikonentferner.
2. Then dry sand with P 220.
3. Afterwards, degrease with Mipa Silikonentferner.

Galvanised substrates (batch galvanising / discontinuous hot-dip galvanising), surface cleansing with the ammonia solution Mipa Zinkreiniger:
1. Mix Mipa Zinkreiniger 1 : 1 with water.
2. Wet sand thoroughly with a corundum synthetic non-woven web to a matt finish.
3. Allow the resulting metallic grey suspension to work for approx. 10 minutes.
4. Sand again.
5. Afterwards, rinse thoroughly with water and allow the surface to dry.

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