

## MIROLOK 3512 Clear Plastic Primer

MIROLOK 3512 is a very fast drying, clear primer that provides excellent adhesion to plastic, acrylic, vinyl and LPM. This rapid drying primer is designed to be applied directly over the substrate & can be over-coated with no sanding required.

### Product Advantages

- Easy to use, no mixing or pot life issues
- Fast drying
- Excellent adhesion
- No sanding required

### Typical Applications

Low pressure melamine (LPM), plastic substrates such as polypropylene, polyethylene and vinyl, acrylic substrates including PMMA and Perspex and DAP board.

Note: there are a wide range of plastic and acrylic substrates with different chemical compositions available in the market place, it is therefore essential that the user tests the adhesion of MIROLOK 3512 as part of the full coating system on a test sample before commencing commercial production.

**Coverage:** 10 m<sup>2</sup> per litre at 100 micron wet film build. This is dependent on the application equipment / gun set up and the article being coated.

**Thinning:** Not normally required. If cobwebbing occurs thin with MIROSOL 1231 Medium Thinner.

**Application Viscosity:** 12-14 seconds BS4 Flow Cup at 25°C

**Wet Film Thickness (WFT):** 75-100 microns per coat

### Application Methods:

Suction Gun:	Use 1.5 to 2mm (59-79 thou) orifice with 350-400kpa (50-55 psi).
Pressure Pot:	Use 1.5 to 2mm (59-79 thou) orifice with pressure pot air-cap. Gun pressure 350-400kpa (50-55 psi) and a pot pressure of 45kpa (6 psi) max.
Airless Spray:	Use 0.23 to 0.33mm (9-13 thou) orifice, 15cm fan (dependent on job) with regulated pump pressure of 350-400kpa (50-55 psi).
Air Mix Guns:	Settings similar to airless spray with the air-assisted regulator pressure at 70-90kpa (10-15psi).

**Drying:** Recoat: 1-5 minutes

Temperatures below 16°C will retard the curing reaction of the product. Drying time is also affected by wet film thickness, the higher the WFT the slower the rate of reaction & the longer the dry time.

**Application:**

All substrates must be free from dust, grease, dirt and all other contaminants before proceeding. Contaminants may be removed by washing the substrate with MIROSOL 1231 Wax & Grease Remover.

Apply a light even coat of MIROLOK 3512 per the Application Methods section.

**Recommended Topcoats:****Interior:**

- MIROTHANE PU 5555, 5577, 5610, 5690 or MIROLON AK 6970
- MIROTHANE PU Clear or Pigmented Undercoat or Topcoat
- MIROTEC WB Clear Sealer or Topcoat

**Exterior:**

- MIROTHANE PU 5610, MIROLON AK 6970 & 6910

If using a product other than a Mirotone topcoat it is up to the user to test the product prior to top coating to ensure compatibility. Some coatings may contain ingredients that reduce the adhesion of the full coating system including the primer.

**Application Equipment Clean Up:** Clean all equipment using MIROSOL 1231 Thinner

**Shelf Life:** 36 months

**Packaging:** 20 litres

**Health & Safety**

Before handling, refer to the Material Safety Data Sheet for health and safety information. Ensure that all personnel using this product have read and understood this data sheet and the associated MSDS and packaging label before using this product.

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