



### MIROLOK 3512 Clear Plastic Primer

MIROLOK 3512 is a very fast drying, clear primer that provides excellent adhesion to plastic, acrylic, vinyl and LPM.

#### 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 is 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

**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:**

- MIROLAC NC Pigmented Undercoat or Topcoat
- MIROCAT PC Clear Sealer or Topcoat
- MIROBILD AC Clear or Pigmented Undercoat or Topcoat
- MIROTHANE PU Clear or Pigmented Undercoat or Topcoat
- MIROPOL PE Pigmented Undercoat
- MIROTEC WB Clear Sealer or Topcoat

**Recommended High Performance Topcoats**

- Interior – MIROTHANE PU 5555 Clear, MIROTHANE PU 5650 Pigmented.
- Exterior – MIROTHANE PU 5610 with PU 5789 Part B

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

**Shelf Life:** 24 months

**Packaging:** 4 litres & 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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