

## MIROKEY VY 6615 Etch Primer

MIROKEY VY 6615 is a high performance, zinc phosphate etch primer specifically designed for direct application over mild steel, zinc-anneal, chrome, brass, lead and lead alloys, stainless steel, aluminium and galvanised iron.

### Product Advantages

- Excellent adhesion to a variety of cleaned metal surfaces
- Single pack, easy to use
- Contains zinc phosphate, proven corrosion resistance
- Fast drying

### Typical Applications

Metal fabrication, box trailers, caravans, safes, plant & machinery, farming equipment, earth moving equipment, skip bins and automotive.

### Product Properties

Build:	Good
Sandability:	No sanding required
Vertical Hold Up:	Excellent
Solvent Resistance:	Dependent upon topcoat
Water Resistance:	Very good
Levelling & Flow:	Very good
Sink Back:	Minimal

### Typical Properties

Colour:	White, Grey & limited colour range
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**Coverage:** 7-10 m<sup>2</sup> per litre at 150 micron wet film build. This is dependent on the application equipment / gun set up and the article being coated.

**Thinning:** Thin 5 to 15% with MIROSOL 1234 or 1294 Medium Thinner.

**Application Viscosity:** 18-24 seconds BS4 Flow Cup at 25°C.

**Wet Film Thickness (WFT):** 100-150 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).
Brush / Roller:	Apply even coats to the recommended film build.

<b>Drying:</b>	Dust Free:	5-7 minutes
	Touch Dry:	10-15 minutes
	Topcoat:	3-4 hours
	Block Stacking:	24 hours

*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 and the longer the dry time.*

**Surface Preparation:** Remove contaminants by washing the surface with MIROSOL 1231 Wax & Grease Remover. Ensure all corrosive products, soluble salts, rust, millscale, loose or flaky paint is removed prior to coating. Linishing or abrasive blast cleaning may be required. At the time of application, the surface should have a surface temperature of between 18 to 25°C to reduce the risk of loss of adhesion due to condensation.

**Aluminium, Galvanised Steel & Zincalume:** Thoroughly clean the surface with MIROSOL 1231 Wax & Grease Remover. Apply one light coat of MIROKEY VY 6615 to provide adhesion for the following coats of MIROPRIME ZP 6940 Zinc Phosphate Primer or one of the recommended Mirotone topcoats. Apply MIROPRIME ZP 6940 over MIROKEY VY 6615 when a higher build sanding primer is required. Allow to dry & apply the recommended Mirotone metal topcoat.

#### **Recommended Topcoats:**

Exterior:	MIROTHANE PU 5610 Two Pack Acrylic Modified Polyurethane MIROLON AK 6980 High Build Gloss Topcoat Alkyd enamel topcoats designed for exterior exposure Suitable exterior grade two pack polyurethane coating
Interior:	MIROBILD AC 3750 Pigmented Topcoat MIROTHANE PU 5650 Polyurethane Pigmented Topcoats

*Note: Do not apply MIROLON AK 6970 Rapid Dry Topcoat over MIROKEY VY 6615 Etch Primer*

**Application Equipment Clean Up:** Clean all equipment using MIROSOL 1234 Thinner.

<b>Shelf Life:</b>	24 months
<b>Packaging:</b>	4 & 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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