



### MIROTHANE PU 5629 Pigmented 2K Metal Primer

MIROTHANE PU 5629 is a premium grade, high solids, low viscosity polyurethane primer for metal. Its excellent sanding properties provide an excellent base for MIROLON enamel and MIROTHANE PU polyurethane topcoats.

#### Product Advantages

- Easy to sand, powders easily making it ideal for hand sanding.
- High solids, low viscosity provides superior build with minimal thinning.
- Superior chemical and moisture resistance.
- Fast drying properties ensure early recoat and faster shipping & handling times

#### Typical Applications

Interior & exterior applications suitable for some automotive plastic & plastic parts, metal structural frames, machinery, caravans & earthmoving equipment.

#### Product Properties

Build:	Very High
Sandability:	Excellent
Vertical Hold Up:	Excellent
Solvent Resistance:	Excellent
Water Resistance:	Excellent
Levelling & Flow:	Excellent
Sink Back:	Minimal

#### Typical Properties

Colour:	White, Black, Tinted
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**Coverage:** 6-7 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.

**Mixing Ratio (by volume):** 3 Parts 5629 Part A + 1 Part 5747 Part B (3A:1B)

**Pot Life:** 2 hours at 25°C

*Pot life varies significantly with ambient temperature, humidity and the quantity mixed. Pot life is longer at lower temperatures and shorter at higher temperatures. The larger the quantity mixed, the shorter the pot life will be. Only mix the quantity required for the job.*

**Thinning:** Thin up to 20% with MIROSOL 1217 (Fast), 1263 (Medium), 1218 (Slow)

**Application Viscosity:** 25-30 seconds BS4 Flow Cup at 25°C.

**Wet Film Thickness (WFT):** 150-200 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).

<b>Drying:</b>	Dust Free:	10-20 minutes
	Touch Dry:	60 minutes
	Sanding:	6 hours
	Topcoat:	Within 24 hours of sanding
	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. To speed up dry time add up to 3% MIROTHANE PU 5795 Accelerator.*

**Metal Surface Preparation:** Remove contaminants by washing the surface with MIROSOL 1231 Wax & Grease Remover. Ensure all corrosive products, soluble salts, mill scale, loose or flaky paint is removed prior to coating. Linishing or abrasive blast cleaning may be required. At the time of the 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 & Zinalume:** Thoroughly clean the surface with a degreaser such as MIROSOL 1231 Wax & Grease Remover. Abrade the surface to provide a mechanical key for the MIROKEY VY 6615. Allow to dry and apply the recommended Mirotone metal products.

**Recommended Topcoats:** MIROLON AK 6970 Rapid Dry Topcoat  
MIROLON AK 6980 High Build Gloss Topcoat  
MIROTHANE PU 5610 Pigmented Topcoat  
Most commonly used decorative solvent and water based enamels

**Note:** *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 1222 or 1286 Thinner

**Shelf Life:** MIROTHANE PU Part A – 12 months  
MIROTHANE PU Part B – 12 months

**Packaging:** MIROTHANE PU Part A – Available in 5kg (3.4L) & 25kg (17L)  
MIROTHANE PU Part B – Available in 4 & 20L

Refer to the MIROTHANE PU Product Information Guide for more information.

### 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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