



### MIROLON AK 6980 High Gloss Topcoat

MIROLON AK 6980 is a user friendly, single pack, pigmented topcoat ideal for light industrial metal fixtures and transportable containers such as trailers, rubbish/ skip bins and metal fabrications. MIROLON AK 6980 is a high build coating that dries to a high gloss finish. MIROLON AK 6980 can be applied directly over bare metal and over the MIROPRIME ZP 6920 High Build Zinc Phosphate Primer to achieve a high build coating system.

#### Product Advantages

- An easy to apply coating that can be applied directly over bare metal when needed.
- Excellent build reduces the number of topcoats required.
- Single pack, no pot life issues to manage.
- Formaldehyde free, safer for the applicator, zero formaldehyde emissions.
- Isocyanate free

#### Typical Applications

- Light industrial metal objects
- Skip bins
- Trailers
- Machinery
- Scaffolding
- Safes
- Shipping containers

#### Product Properties

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

#### Typical Properties

Colour:	White, matched to colour on request
Gloss:	Full Gloss (also available in a Matt finish)

**Coverage:** 8 m<sup>2</sup> per litre at 125 micron wet film build. This is dependent on the application equipment / gun set up and the article being coated.

**Thinning:** Thin 40-50% with MIROSOL 1230 (Medium) or 1286 (Fast)

**Application Viscosity:** 20-25 seconds BS4 Flow Cup at 25°C.

**Wet Film Thickness (WFT):** 125-150 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).
<b>Drying:</b>	
Dust Free:	10-15 minutes
Touch Dry:	30 minutes
Dry to Handle:	60-90 minutes
Recoat:	After 1 hour up to 24 hours
Full Cure:	48 hours

*Low temperatures and heavy film thickness will retard drying times.*

## Bare metal preparation:

**Recommended Undercoats:** Apply MIROLON AK 6980 directly over bare metal or alternatively use MIROPRIME ZP 6920 Rapid Dry Zinc Phosphate Primer to provide a higher build coating system. Other undercoats; MIROKEY VY 6615 Etch Primer, MIROPRIME ZP 6930 Rapid Dry Zinc Phosphate Primer or MIROTHANE PU 5629 2K Metal Primer.

All substrates must be structurally sound and free of all contaminants. Bare metal will need to be thoroughly cleaned with MIROSOL 1231 Wax and Grease Remove to remove all oils, grease and contaminants from the steel. All loose/ flaking paint should be removed by abrasive blast cleaning, sanding or power tool cleaning. Remove all dust and dirt by washing with a detergent based degreaser such as MIROSOL 1231.

## Aluminium, Galvanised steel and Zincalume

Thoroughly clean the surface with MIROSOL 1231 Wax and Grease remover. Abrade the surface to provide a mechanical key for the MIROKEY VY 6615. Allow MIROKEY 6615 to completely dry. Apply MIROPRIME ZP 6920 High Build Zinc Phosphate Primer. Allow to dry and apply the recommended Mirotone metal topcoats.

**Application Equipment Clean Up:** Clean all equipment using MIROSOL 1222 or 1286 Thinner

**Shelf Life:** 24 months

**Packaging:** 4 or 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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**Mirotone Pty Ltd Australia (Head Office)**  
ABN 40 000 041 136  
21 Marigold Street,  
Revesby NSW 2212 Australia  
P +61 2 9795 3700 F +61 2 9771 3601  
sales@mirotone.com.au

**Mirotone (NZ) Ltd New Zealand (Head Office)**  
32 Cryers Road,  
Auckland, 1730, New Zealand  
P +64 9 272 2730 F +64 9 272 2733  
information@mirotone.co.nz

**Mirotone (Thailand) Co., Ltd**  
83 Moo 4, Poochaosamingprai Rd,  
Samrong Klang, Prapradaeng,  
Samutprakam, 10130, Thailand  
P +66 2 754 4451 F +66 2 754 4450

[www.mirotone.com](http://www.mirotone.com)