



MIROTONE

Leading the way in coating systems since 1938

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MIROBILD AC 3720 Pigmented Undercoat

Technical Data Sheet

MIROBILD AC 3720 is a high build, pigmented, acid catalysed undercoat for use on medium density fibreboard (MDF), particleboard or wood.

Product Advantages

- High build, enhances the finished appearance of the topcoat and can be applied directly over MDF to seal the fibres.
- Easy to sand.
- Excess MIROBILD AC 3770 topcoat may be added into MIROBILD AC 3720 undercoat to create a tinted undercoat. This improves coverage and reduces waste of topcoat.

Typical Applications

Interior only: Domestic & Commercial furniture, wardrobes, joinery and fixtures.

Product Properties

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

Typical Properties

Colour:	White
Gloss:	N/A

Coverage: 6-7 m² 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):

10 Parts MIROBILD AC 3720 Part A + 1 Part MIROBILD AC 3800 Universal Catalyst or MIROBILD AC 3810 Quick Dry Catalyst by volume.

Mix A & B and then add thinner. Allow mixed product to stand for 15 minutes prior to thinning, this will ensure that maximum film hardness and clarity is obtained. Failure to allow time for reaction to take place may result in a hazy film.

Pot Life: 1 day 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.

Thinning: Thin up to 20% with MIROSOL 1220 (Fast), 1294 (Medium), 1242 (Slow)

In hot or draughty conditions up to 10% MIROSOL 1218 Ultra Slow Thinner may be added. Do not exceed 10% addition as it will retard the drying and could lead to problems with sanding, printing and blocking. Use faster thinners to achieve the required viscosity and then use (only if required) a small amount of MIROSOL 1218 to improve flow and levelling.

In damp, cool or high humidity conditions, up to 10% MIROSOL 1297 Retarder may be added to help prevent blushing (a milkiness or haze in the film). Heating the application environment e.g. warming with infra-red lamps and avoid spraying early in the morning and late evening when temperatures are at their coldest, will also help to reduce the risk.

Application Viscosity: 40-50 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).
Curtain Coating: Viscosity 40-50 seconds.

Drying: Dust Free: 10-15 minutes
Touch Dry: 20-30 minutes
Sanding: 2 – 3 hours
Topcoat: Within 24 hours of sanding
Block Stacking: 24 hours

Low temperatures or heavy film thickness will retard drying times and cause frying upon application of subsequent coats.

Recommended Topcoat: MIROBILD AC 3770 Pigmented Topcoat

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

Shelf Life: MIROBILD AC Part A – 18 months
MIROBILD AC Part B – 12 months

Packaging: MIROBILD AC Part A – 20 litres
MIROBILD AC Part B – 0.5, 2, 4, 20 litres

Refer to the MIROBILD AC 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.