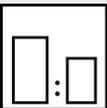


**Intended use**

Two-component medium-solid clearcoat based on high-quality acrylic resins with UV resistance and direct adhesion on bare ferrous and non-ferrous metals. The original appearance of the substrate is not changed.

Colour: Colourless.

**Processing instructions**

	<b>Mixing ratio</b>		
	<b>hardener</b>	<b>by weight (lacquer : hardener)</b>	<b>by volume (lacquer : hardener)</b>
	–	–	5 : 1

	<b>Hardener</b>
	Mipa MS 10, MS 25, MS 40

	<b>Pot life</b>
	Mit Härter MS 10 approx. 6 h at 20 °C
	Mit Härter MS 40 approx. 8 h at 20 °C

	<b>Thinner</b>
	Mipa 2K-Verdünnung V 10, V 25, V 40

	<b>Processing viscosity</b>	
	<b>gravity spray gun</b>	<b>Airmix/Airless</b>
	18 - 20 s 4 mm DIN	–

	<b>Application mode</b>					
	<b>application mode</b>	<b>hardener</b>	<b>pressure (bar)</b>	<b>nozzle (mm)</b>	<b>spray passes</b>	<b>dilution</b>
	gravity spray gun / HVLP	–	2,0 - 2,5	1,2 - 1,3	2	10 - 15 %

	<b>Drying time</b>						
	<b>hardener</b>	<b>object temperature</b>	<b>dust dry</b>	<b>set to touch</b>	<b>ready for assembly</b>	<b>sandable</b>	<b>recoatable</b>
	–	20 °C	20 - 30 min	6 - 8 h	24 h	–	–
–	60 °C	–	30 - 40 min	1 - 2 h	–	–	

Fully cured after 7 - 8 days ( at 20 °C).

**Note**

<b>Characteristics:</b>	binder base:	polyurethane acrylic system
	solids content (% by weight):	~ 51
	solids content (% by volume):	~ 45
	delivery viscosity DIN 53211 4 mm (in s):	75 - 85
	density DIN EN ISO 2811 (kg/l):	~ 1,0
	gloss level ISO 2813 at 60° (GU):	> 80 gloss

<b>Properties:</b>	highly UV- and weather-resistant short-term heat exposure: 150 °C permanent heat exposure: 130 °C adhesion on zinc-coated steel substrates, aluminium, copper and brass
<b>Theoretical spreading rate :</b>	~ 50,0 m <sup>2</sup> /kg, 5:1 by volume with MS 25, for 10 µm dry film thickness ~ 46,5 m <sup>2</sup> /l, 5:1 by volume with MS 25, for 10 µm dry film thickness
<b>Storage:</b>	For at least 3 years in the unopened original container. Optimum storage conditions between + 5 °C and + 25 °C, avoid direct sunlight. Other storage conditions may lead to undesirable properties of the material.
<b>VOC:</b>	–
<b>Processing conditions:</b>	From + 10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.
<b>Substrate preparation:</b>	Remove oil, grease, rust, mill scale, rolling skins, as well as other substances impairing the function of the coating!  Attention: A direct adhesion cannot be taken as granted due to most different kinds of metals, alloys, metallic and conversion coatings and so on. The adhesion must therefore be tested on the original metal substrate.
<b>Proposed coating structure:</b>	1-coat system zinc-coated steel substrates, aluminium, copper and brass 2K-Klarlack CA with 40 - 50 µm dry film thickness
<b>Special notes:</b>	For professional use only.  The reddish colour of the product disappears after application.  Mipa 2K-Klarlack CA can be tinted with Mipa Brillant Design or Mipa 2K-PUR-Autolack OC (max. addition: 20 %).  Mipa 2K-Klarlack CA cannot be used as a colourless protective coating on polished metals. In addition it is necessary to test preliminarily the adhesion on special metal substrates (e.g. very smooth and hard anodic coating) in order to assess if the product adheres directly without sanding.  If required we also offer hardeners and cleaning agents that are suitable for 2-component mixing and dosing units. Please contact your technical adviser or our application technicians.
<b>Cleaning of tools:</b>	Clean Tools immediately after use with Mipa Nitroverdünnung.