PAINTNUTS

BODYSHOP SUPPLIES

TECHNICAL DATA SHEET

PRE-MIXED 2K DIRECT GLOSS

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Intended use

Mipa OC is a High Solid 2K PUR-Acrylic car refinishing paint with high UV resistance and good protection against weathering. It is especially suited for partial or complete paintworks of cars and commercial vehicles and provides particularly high coverage and spreading rate. All toners are free from lead.

Spreading rate: 300 - 400 sq ft./gal. (6 - 8 m²/l) by 2 mil DTF

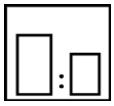
General informations

Colour

Mipa Color System II + System III solid

Mipa Mix Basic, Mipa Mix 5.0

Mipa Mix Elite



Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
Mipa 2K-HS-Hardeners	--	2 : 1
Mipa 2K-MS Hardeners LV	--	2 : 1

Hardener

for complete paintwork	for partial paintwork
Mipa 2K-HS-Hardener HS 25 / 35	Mipa 2K-HS-Hardener HS 10
Mipa 2K-MS-Hardener MS 35 LV / MS 40 LV	Mipa 2K-Hardener MS 10 LV / MS 25 LV

Pot life

1 h with Mipa 2K-Hardener HS 10, MS 10 LV at 70 °F (20 °C)

2 h with Mipa 2K-Hardener HS 25, MS 25 LV at 70 °F (20 °C)

3 h with Mipa 2K-Hardener HS 35, MS 35 LV at 70 °F (20 °C)

4 h with Mipa 2K-Hardener MS 40 LV at 70 °F (20 °C)

Thinner

0 - 5 % Mipa 2K-Thinner V 25

0 - 5 % Mipa 2K-Thinner V 25

0 - 5 % Mipa 2K-Thinner slow V 40

0 - 5 % Mipa ZERO VOC Thinner slow

Spray viscosity

20 - 22 s 4 mm DIN

gravity spray gun	Airmix/Airless
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Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
HVLP (low pressure)	--	29 - 36 psi	1,2 - 1,3	1,5 - 2	0 - 5
HVLP (low pressure)	--	2 - 2,5 bar	1,2 - 1,3	1,5 - 2	0 - 5
HVLP / internal nozzle pressure	--	9,8 psi (0,7 bar)	1,2 - 1,3	1,5 - 2	0 - 5

Version: us 0921

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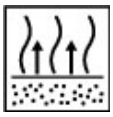

Flash-off time

5 - 8 min. between coats

10 - 15 min. before oven drying

Dry coat thickness

2 - 2,4 mil (50 - 60 µm)

Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
70 °F (20 °C)	25 - 35 min.	4 - 6 h	12 - 24 h	--	--
140 °F (60 °C)	10 - 15 min.	25 - 30 min.	after cooling	--	--
Infrared drying shortwave	--	10 - 15 min.	--	--	--
Infrared drying mediumwave	--	15 - 25 min.	--	--	--

Note

Storage:

In tightly closed original containers at least 3 years shelf life.
Storage temperature range 50 - 86°F (10 - 30 °C)
Protect package from direct sunlight and heat.

VOC Information:

VOC as packaged:
less exempt solvents 341 g/l / 2.8 lb/gl
with exempt solvents 341 g/l / 2.8 lb/gl

VOC as applied:
2:1 with Hardener HS 10, HS 25, HS 35 + 5 % 2K Thinner < 420 g/l / 3.5 lb/gl
2:1 with all 2K Hardeners MS LV + 5 % 2K Thinner < 420 g/l / 3.5 lb/gl

VOC Regulation:

RTS Combinations	2K Hardener MS 10 LV	2K Hardener MS 25 LV
Mixing ratio by volume	2 : 1 + 5 % ZERO VOC Thinner slow	2 : 1 + 5 % ZERO VOC Thinner slow
Actual VOC (g/L)	527	528
Regulatory VOC (g/L)	318	318
Volatiles wt. %	47,4	47,5
Water wt. %	-	-
Exempt wt. %	25	24,9
Density (g/L)	1112	1112
RTS Combinations	2K Hardener MS 35 LV	2K Hardener MS 40 LV
Mixing ratio by volume	2 : 1 + 5 % ZERO VOC Thinner slow	2 : 1 + 5 % ZERO VOC Thinner slow
Actual VOC (g/L)	527	527
Regulatory VOC (g/L)	318	318
Volatiles wt. %	47,4	47,4
Water wt. %	-	-
Exempt wt. %	24,9	24,9
Density (g/L)	1112	1112

Always check local VOC laws to ensure that the use of Mipa products is compliant in your area.

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Processing conditions:

from 50 °F (10 °C) and up to 80 % relative air humidity.
Ensure an adequate supply and exhaust air ventilation.
Acrylic-based products do not cure perfectly at a temperature of below 50 °F.

General informations:

To avoid too high film builds (very high solid content as HS quality) strictly observe the recommended number of coats. Check color shade before application after having added the hardener. The polishability of some colours may be limited due to the system. For subsequently matting with Mipa Multi Mat please observe the mixing ratios and information about application mentioned in the technical data sheet of Mipa Multi Mat.

For highest UV protection we recommend to use our Mipa 2K HS-Hardeners.
Using Mipa MS Hardeners and MS Hardeners LV, UV-protection will be reduced.

Tools should be cleaned immediately after use.

Safety aspect:
For professional use only. Not for sale to or use by the general public. Before opening the packages be sure you understand the warning Messages on the Labels and Safety Data Sheets of all components since the mixture will have the hazards of all of its parts.The manufacturer recommends the use of an air supplied Respirator when exposed to vapors or spray mist.

Medical Response:
Emergency Medical or Spill Control Information 011 49(0)700 24112112 (MIP)
US Emergency Phone Number (for transportation incidents only) 1-800-535-5053 (Infotrac)

Exclusive Importer: Fleetwood Products
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