

Intended use

Two-component, acrylic-based clearcoat with 15-20 gloss units at a 60°-angle. Good resistances, uniformly matted surfaces. Appropriate to finish matt, satin matt and satin gloss metallic and effect coatings. For use on plastic parts e.g. bumpers, just add the additive Mipa 2K-Elastic. Depending on the quantity of Mipa 2K-Elastic added, the gloss level increases up to max. 70 gloss units. Possible gloss levels:

Satin matt:

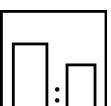
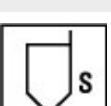
Mipa 2K-Klarlack matt CM + 5 - 10 % Mipa 2K-Elastic or
Mipa 2K-Klarlack matt CM + Mipa 2K-Klarlack glänzend (glossy) mixing ratio 3:1

Satin gloss:

Mipa 2K-Klarlack matt CM + 15 - 20 % Mipa 2K-Elastic or
Mipa 2K-Klarlack matt CM + Mipa 2K-Klarlack glänzend (glossy) mixing ratio 2:1

Spreading rate: 7,0 - 8,0 m²/l

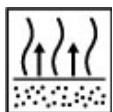
Processing instructions

	Colour colourless																								
	Mixing ratio Hardener by weight (lacquer : hardener) by volume (lacquer : hardener) Mipa 2K-MS-Härter -- 2 : 1																								
	Hardener for complete paintwork Mipa 2K-MS-Härter MS 25 / 40 for partial paintwork Mipa 2K-MS-Härter MS 10																								
	Pot life 1 h with Mipa 2K-MS-Härter MS 10 at 20 °C 4 h with Mipa 2K-MS-Härter MS 25 at 20 °C 6 h with Mipa 2K-MS-Härter MS 40 at 20 °C																								
	Thinner Mipa 2K-Verdünnung normal V 25 Mipa 2K-Verdünnung lang V 40																								
	Spray viscosity gravity spray gun 18 - 20 s 4 mm DIN Airmix/Airless --																								
	Application mode <table><thead><tr><th>Application mode</th><th>Hardener</th><th>pressure (bar)</th><th>nozzle (mm)</th><th>spray passes</th><th>dilution (%)</th></tr></thead><tbody><tr><td>gravity spray gun (high pressure)</td><td>--</td><td>2 - 2,5</td><td>1,2 - 1,3</td><td>2</td><td>10</td></tr><tr><td>HVLP (low pressure)</td><td>--</td><td>2 - 2,2</td><td>1,2 - 1,3</td><td>2</td><td>10</td></tr><tr><td>HVLP / internal nozzle pressure</td><td>--</td><td>0,7</td><td>--</td><td>--</td><td>--</td></tr></tbody></table>	Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	dilution (%)	gravity spray gun (high pressure)	--	2 - 2,5	1,2 - 1,3	2	10	HVLP (low pressure)	--	2 - 2,2	1,2 - 1,3	2	10	HVLP / internal nozzle pressure	--	0,7	--	--	--
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Version: en 1220

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**Flash-off time**

5 - 10 min between the coats
10 - 15 min before oven drying

Dry coat thickness

40 - 50 µm

**Drying time**

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	25 - 30 min	12 h	24 h	--	--
60 °C	--	30 min	2 h	--	--
Infrared drying shortwave	--	8 min	--	--	--
Infrared drying mediumwave	--	10 - 15 min	--	--	--

Note

Storage: at least 3 years in unopened original container

VOC Regulation: EU limit value for this product (category B/e): 840 g/l
This product contains max. 563 g/l of VOC.

Processing conditions: From +10 °C and up to 80 % relative air humidity. Ensure an adequate air ventilation.

Processing instructions: Important: The spray technique affects significantly the gloss level. The last coat should therefore be applied thinly and evenly after a flash-off of approx. 5-10 minutes.

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