

Intended use

Mipa 2K-HS-Clearcoat C 290 LV 2.1 is a VOC compliant acrylic clearcoat for complete or partial paintwork of cars and commercial vehicles and provides an optimal flow. C 290 LV 2.1 guarantees a fast and efficient brilliant refinish, which ensures fast drying by oven as well as by air. This special drying property in combination of long open time at application offers saving potentials in terms of spray booth occupancy, stoving times as well as working time. This leads to a considerable reduction in operating costs and increases the throughput.

After the drying of 15 - 20 minutes at 140 °F (60 °C) or 20 - 30 minutes at 104 °F (40 °C), the painted parts can be polished immediately after cooling down. Alternatively it can be polished after a drying time of 2,5 - 3 hours at room temperature.

Ready to use after adding the hardener. Perfectly resistant to weathering, environmental conditions and durable gloss retention.

VOC < 2.1 lbs/gal (250 g/l).

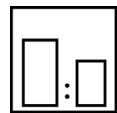
Spreading rate: 410 - 495 sq.ft/gal by 1 mil. 10 - 12 m²/l 25 µm

General informations



Colour

colorless



Mixing ratio

Hardener

Mipa 2K-HS-Hardener HS 25 LV

by weight (lacquer : hardener)

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by volume (lacquer : hardener)

2 : 1



Hardener

for complete paintwork

Mipa 2K-HS-Hardener HS 25 LV

for partial paintwork

Mipa 2K-HS-Hardener HS 25 LV

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Pot life

30 - 45 min.



Thinner

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Spray viscosity

Ready to use after adding the hardener.

gravity spray gun

15 - 16 sec. DIN 4 cup.

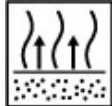
Airmix/Airless

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Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
HVLP (low pressure)	--	29 - 35 psi 2 - 2,5 bar	1,2 - 1,3	1,5 - 2	--
HVLP (low pressure)	--	29 - 32 psi 2 - 2,2 bar	1,2 - 1,3	1,5 - 2	--
HVLP/ internal nozzle pressure	--	10 psi 0,7bar	1,2 - 1,3	1,5 - 2	--



Flash-off time

10 - 15 min. between coats
10 - 15 min. prior to 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) HS 25 LV	20 - 30 min.	2 - 3 h	2 h	--	--
140°F (60°C) HS 25 LV	10 - 15 min.	10 - 15 min.	40 - 45 min.	--	--
--	--	--	after cooling down	--	--
--	--	--	after cooling down	--	--

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 303 g/l / 2.5 lb/gl
with exempt solvents 395 g/l / 3.3 lb/gl

VOC Regulation:

RTS Combinations	2K-HS-Hardener HS 25 LV
Mixing ratio by volume	2 : 1
Actual VOC (g/L)	438
Regulatory VOC (g/L)	256
Volatiles wt. %	42,4
Water wt. %	
Exempt wt. %	25,9
Density (g/L)	1,035

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

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

General informations: Infrared drying after 10 min. flash off:
infrared drying shortwave approx. 8 - 10 min.
infrared drying mediumwave approx. 10 - 15 min.

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)

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