

Intended use

Mipa 2K-HS-Express-Clearcoat CX 3 is a high-quality PUR clearcoat for fast and efficient refinishing (express technology), which generally does not require oven drying. Due to the special formulation, Mipa 2K-HS-Express-Clearcoat CX 3 already cures very quickly at room temperature 70° F (20 °C) and can be polished after only approx. 60 minutes of drying. To ensure optimum polishability, polishing should be carried out within 3 hours. It is therefore possible to save significantly heating-related costs. At the same time, very fast cycle times are possible, since the polishing work does not have to be interrupted by heating intervals. If required, oven drying is also possible, in which full polishing capability is achieved after drying for approx. 15 minutes at 140 °F (60 °C) or 30 minutes at 104 °F (40 °C) plus a cooling phase. Mipa 2K-HS-Express-Clearcoat CX 3 is particularly suitable for coating parts of passenger cars or a complete car side plus front flap as well as for use in the spot repair sector. Due to its special formulation, Mipa 2K-HS-Express-Clearcoat CX 3 is particularly elastic. This increases the process reliability of deformable parts such as bumpers during assembly. Ready for use after the addition of hardener. This product provides excellent resistance against all environmental and climatic conditions and offers durable gloss retention as well as an excellent scratch resistance.

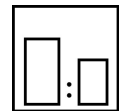
Spreading rate: 244 - 325 sq.ft/gal by 1 mil. 6,0 - 8,0 m²/l 25 µm

General informations



Colour

colourless



Mixing ratio

Hardener

Mipa 2K-HX-Hardener HX 25

by weight (lacquer : hardener)

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by volume (lacquer : hardener)

1 : 1



Hardener

for complete paintwork

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for partial paintwork

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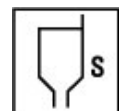
Pot life

40 min with Mipa 2K-HX-Hardener HX 25 at 70 °F (20 °C)



Thinner

ready for spraying after addition of hardener



Spray viscosity

gravity spray gun

14 - 16 s 4 mm DIN

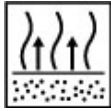
Airmix/Airless

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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	1,0 - 1,2	2	–
HVLP (low pressure)	–	29 - 33 psi 2 - 2,2 bar	1,0 - 1,2	2	–



Flash-off time

0 - 3 min. between the coats

0 - 3 min. before oven drying

Dry coat thickness

1,6 - 2 mil (40 - 50 µm)



Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
70 °F (20 °C)	10 - 15 min	30 - 45 min	1 h	--	--
140 °F (60 °C)	--	15 min	15 min	--	--

Note

Storage:

In tightly closed original containers at least 2 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 576 g/l / 4.8 lb/gl.
With exempt solvents 614 g/l / 5.16 lb/gl.

VOC as applied: < 410 g/l / 3.42 lb/gl.

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.
PUR-based clearcoats do not cure perfectly at a temperature of below 50 °F.

General informations:

It should be noted that the pot life and full cure depend on the prevailing humidity.

Masking or adhesive tapes that are overpainted with Mipa 2K-HS-Express-Clearcoat CX 3 must be removed immediately after painting. If this is not done, there is a risk that the fresh coating will be removed together with the adhesive tape.

2K hardeners must be added to Mipa two-layer basecoats when recoating with Mipa 2K-HS-Express-Clearcoat CX 3. The mixing ratios are:

Mipa BC + 10 % (10:1) all Mipa 2K-MS-or HS-Hardeners or HX 25.

Mipa WBC + 5 % (20:1) Mipa WBC-Hardener.

Since a slight, system-related color deviation is to be expected, especially with light metallic colors, due to the addition of hardeners, partial butt painting is not permitted. In contrast, this risk does not exist in the case of spot coating with a basecoat that is running out and the spot repair process.

Due to the system, irritation of the eyes and skin may occur during processing, therefore appropriate protective equipment must be worn.

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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