

Intended use

Mipa 2K-HS-Express-Clearcoat CX 4 is a high-quality acrylic clearcoat for a fast and efficient refinish (express technology), which ensures extremely fast drying by oven as well as by air. This special drying property 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. Another major advantage is that Mipa 2K-HS-Express-Clearcoat CX 4 can be polished quickly when it has been mixed with Mipa 2K-HS-Express-Hardener HX 4:

After 5 minutes of drying at an object temperature of 60 °C, polishing can begin after a cooling phase of approx. 15 minutes. Alternatively, the polishing process can be started after 20 minutes drying at 40 °C object temperature plus cooling phase. Polishing is also possible after 1 hour of drying at room temperature.

Mipa 2K-HS-Express Clearcoat CX 4 is suitable for spot repair, partial paintwork and also for complete paintwork when mixed with Mipa 2K-HS-Hardener HS 25. In combination with Mipa 2K-HS-Hardener HS 25 the drying is as follows:

After the drying of 15 minutes at 140 °F (60 °C) or 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 - 3 hours at room temperature.

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

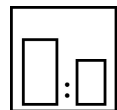
Spreading rate: 410 - 495 sq.ft/gal by 1 mil. 10 - 12 m²/l 25 µm

General informations



Colour

colorless



Mixing ratio

Hardener

by weight (lacquer : hardener)

by volume (lacquer : hardener)

Mipa 2K-HS-Express-Hardener HX 4

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2 : 1

Mipa 2K-HS-Hardener HS 25

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2 : 1



Hardener

for complete paintwork

Mipa 2K-HS-Hardener HS 25

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for partial paintwork

Mipa 2K-HS-Express-Hardener HX 4

Mipa 2K-HS-Hardener HS 25

Mipa 2K-HS-Hardener HS 10 only for spot repair



Pot life

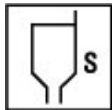
~ 45 min. with Mipa 2K-HS-Express-Hardener HX 4 / 70 °F

~ 60 min. with Mipa 2K-HS-Hardener HS 25 / 70 °F



Thinner

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Spray viscosity

Ready to use after adding the hardener.

gravity spray gun

Airmix/Airless

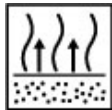
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Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
HVLP (low pressure)	--	29 - 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	--	1,5 - 2	--



Flash-off time

3 - 5 min. between coats

5 - 10 min. prior to oven drying

Dry coat thickness

1,8 - 2,4 mil 40 - 60 µm



Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
70°F (20°C) HX 4	15 - 20 min.	35 - 45 min.	2 h	--	--
70°F (20°C) HS 25	35 min.	2 h	3 h	--	--
140°F (60°C) HX 4	--	10 min.	after cooling down	--	--
140°F (60°C) HS 25	--	15 min.	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 406 g/l / 3.4 lb/gl

with exempt solvents 406 g/l / 3.4 lb/gl

VOC as applied:

2:1 with Hardener HX4 < 420 g/l / 3.5 lb/gl

2:1 with Hardener HS 25 < 440 g/l / 3.7 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.

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

General informations:

Infrared drying (with Mipa 2K-HS-Express-Hardener HX 4):
infrared drying shortwave approx. 8 min.
infrared drying mediumwave approx. 10 - 15 min.

To ensure an optimal intermediate adhesion on basecoats, the clearcoat we recommend to add a hardener to the basecoat.
The quantities to be added are:

Mipa BC + 10 % (10:1) Mipa 2K-Hardener you are using in the clearcoat.
Also possible: Mipa 2K Hardeners H10, MS10 LV, MS25 LV.

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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