

### Intended use

Mipa 2K-Clearcoat CPE is an elastic, satin gloss 2K MS clearcoat to recoat especially basecoats on plastic substrates. Excellent weather and UV resistance. High mechanical and chemical resistance. The gloss level corresponds to common reduced gloss plastic coatings.

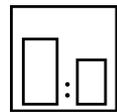
Spreading rate: 244 - 325 sq.ft/gal by 1 mil. 6,0 - 8,0 m<sup>2</sup>/l 25 µm

### General informations



#### Colour

colourless



#### Mixing ratio

##### Hardener

Mipa 2K-MS-Hardeners LV

by weight (lacquer : hardener)

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by volume (lacquer : hardener)

2 : 1



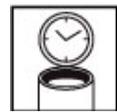
#### Hardener

##### for complete paintwork

Mipa 2K-MS-Hardener MS 10 LV - MS 40 LV

##### for partial paintwork

Mipa 2K-MS-Härter MS 10 LV



#### Pot life

2 h with Mipa 2K-MS-Härter MS 10 LV at 70 °F (20 °C)

4 h with Mipa 2K-MS-Härter MS 25 LV at 70 °F (20 °C)

6 h with Mipa 2K-MS-Härter MS 35 LV at 70 °F (20 °C)

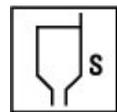
8 h with Mipa 2K-MS-Härter MS 40 LV at 70 °F (20 °C)



#### Thinner

10 - 15 % Mipa 2K-Thinner normal V 25

10 - 15 % Mipa 2K-Thinner slow V40



#### Spray viscosity

##### gravity spray gun

18 - 20 s 4 mm DIN

##### Airmix/Airless

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#### Application mode

##### Application mode

HVLP (low pressure)

##### Hardener

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##### pressure (bar)

29 - 35 psi  
2 - 2,5 bar

##### nozzle (mm)

1,2 - 1,3

##### spray passes

2

##### dilution (%)

10 - 15

HVLP (low pressure)

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29 - 35 psi  
2 - 2,5 bar

1,2 - 1,3

2

10 - 15

HVLP / internal nozzle pressure

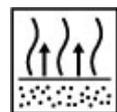
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10 psi -  
0,7 bar

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#### Flash-off time

5 - 8 min between the coats

10 - 15 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)	30 min.	12 h	24 h	--	--
140 °F (60 °C)	5 min.	30 min.	2 h	--	--
Infrared drying shortwave	--	8 min.	--	--	--
Infrared drying mediumwave	--	10 - 15 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 479 g/l / 4.0 lb/gl.  
With exempt solvents 479 g/l / 4.0 lb/gl.

VOC as applied: <415 g/l / 3.46 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 products do not cure perfectly at a temperature of below 50 °F.

#### General informations:

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: Mipa USA INC.

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