

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-Clearcoat CM mat + 5 - 10 % Mipa 2K-Elastic or

Mipa 2K-Clearcoat CM mat + Mipa 2K-Clearcoat glossy mixing ratio 3:1

Satin gloss:

Mipa 2K-Clearcoat CM mat + 15 - 20 % Mipa 2K-Elastic or

Mipa 2K-Clearcoat CM mat + Mipa 2K-Clearcoat glossy mixing ratio 2:1

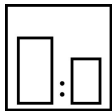
Spreading rate: 285 - 325 sq.ft/gal by 1 mil. 7,0 - 8,0 m²/l 25µm

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 35 LV / MS 40 LV

for partial paintwork

Mipa 2K-MS-Hardener MS 10 LV / MS 25 LV



Pot life

1 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)

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

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



Thinner

Mipa 2K-Thinner V 25

Mipa 2K-Thinner slow V 40



Spray viscosity

gravity spray gun

18 - 20 s 4 mm DIN

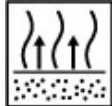
Airmix/Airless

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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 | 1,2 - 1,3 | 2 | 10 % |
| HVLP (low pressure) | -- | 29 - 32 psi 2 - 2,2 | 1,2 - 1,3 | 2 | 10 % |
| HVLP / internal nozzle pressure | -- | 10 psi 0,7 bar | -- | -- | -- |



Flash-off time

10 - 15 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 °C (20 °C) | 25 - 30 min. | 12 h | 24 h | -- | -- |
| 140 °F (60 °C) | -- | 30 min. | 1 h | -- | -- |

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 503 g/l / 4.2 lb/gl
with exempt solvents 503 g/l / 4.2 lb/gl

VOC as applied: < 492 g/l / 4.11 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:

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. 10 - 15 minutes. For a homogenous surface we recommend to use our slow hardeners Mipa 2K Hardener MS 35 LV / MS 40 LV and 2K Thinner slow.

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: Fleetwood Products

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