

Intended use

Mipa PUR HS is a 2K PUR-acrylic, weather- and UV- resistant High-Solid car paint for VOC-compliant partial or complete paintworks on trucks, busses and commercial vehicles. All toners are free from lead pigments. It provides particularly high opacity, spreading rate, gloss retention and high resistance to chemical and mechanical strain.

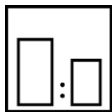
Spreading rate: 300 - 400 sq ft./gal. (6 - 8 m²/l) by 2 mil DFT

General informations



Colour

Mipa Color System II + System III solid
Mipa Mix Basic, Mipa Mix 5.0
Mipa Mix Elite



Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
Mipa 2K-HS-Hardeners	--	3 : 1
Mipa 2K-MS-Hardeners LV	--	2 : 1



Hardener

for complete paintwork

Mipa 2K-HS-Hardener HS 25 / HS 35
Mipa 2K-MS-Hardener MS 35 LV / MS 40 LV

for partial paintwork

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



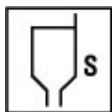
Pot life

1 h - 2K-Hardener HS 10, MS 10 LV at 70 °F (20°C)
2 h - 2K-Hardener HS 25, MS 25 LV at 70 °F (20°C)
3 h - 2K-Hardener HS 35, MS 35 LV at 70 °F (20°C)
4 h - 2K-Hardener MS 40 LV at 70 °F (20°C)



Thinner

Mipa 2K-Thinner V 25
Mipa 2K-Thinner slow V 40
Mipa ZERO VOC Thinner slow



Spray viscosity

To reduce paint viscosity for VOC < 2.8 use Mipa ZERO VOC Thinner slow.
18 - 22 s 4 mm DIN

gravity spray gun

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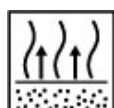
Airmix/Airless

25 - 30 s 4 mm DIN



Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
HVLP (low pressure)	MS LV Hardeners	29 - 36 psi	1,2 - 1,3	1,5 - 2	5 - 10 %
HVLP (low pressure)	HS Hardeners	2 - 2,5 bar	1,2 - 1,3	1,5 - 2	10 - 15 %
HVLP / internal nozzle pressure	–	9,8 psi (0,7 bar)	–	–	–
Airmix / Airless	MS 40 LV	1420 - 1710 psi (100 - 120 bar)	0,23 - 0,28	1	5 - 10 %



Flash-off time

10 - 15 min. between coats
10 - 15 min. before 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)	45 - 55 min.	5 - 6 h	12 - 24 h	–	–
140 °F (60 °C)	10 - 15 min.	25 - 30 min.	after cooling	–	–
Infrared drying shortwave	–	10 - 15 min.	–	–	–
Infrared drying mediumwave	–	15 - 25 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 341 g/l / 2.8 lb/gl
 with exempt solvents 341 g/l / 2.8 lb/gl

VOC as applied:
 3:1 with HS 10, HS 25, HS 35 + 15% 2K Thinner < 420 g/l / 3.5 lb/gl
 2:1 with all 2K MS-Hardeners LV + 10 % 2 K Thinner < 420g/l / 3.5 lb/gl.

Regulated areas:

VOC Regulation:

RTS Combinations	2K Hardener MS 10 LV	2K Hardener MS 25 LV
Mixing ratio by volume	2 : 1 + 10 % ZERO VOC Thinner slow	2 : 1 + 10 % ZERO VOC Thinner slow
Actual VOC (g/L)	535	536
Regulatory VOC (g/L)	287	286
Volatiles wt. %	44,6	44,7
Water wt. %	-	-
Exempt wt. %	26,7	26,8
Density (g/L)	1199	1199
RTS Combinations	2K Hardener MS 35 LV	2K Hardener MS 40 LV
Mixing ratio by volume	2 : 1 + 10 % ZERO VOC Thinner slow	2 : 1 + 10 % ZERO VOC Thinner slow
Actual VOC (g/L)	536	535
Regulatory VOC (g/L)	286	286
Volatiles wt. %	44,7	44,7
Water wt. %	-	-
Exempt wt. %	26,7	26,8
Density (g/L)	1199	1199

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:

To avoid too thick layers (very high solids content as HS quality) strictly observe the recommended number of coats. Always check colour shade before application after having added the hardener. The polishability of some colours may be limited due to the system.

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)

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