

**Intended use**

Mipa Rallye black mat is a weather and UV-resistant two-component acrylic automotive finish paint to give uniformly matted black surfaces. Used for partial or complete paintwork on cars, trucks, busses and commercial vehicles.

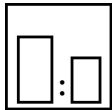
Spreading rate: –

**General informations**



**Colour**

black mat



**Mixing ratio**

**Hardener**

**by weight (lacquer : hardener)**

**by volume (lacquer : hardener)**

Mipa 2K-HS-Hardener –

3 : 1

Mipa 2K-MS-Hardener LV –

2 : 1



**Hardener**

**for complete paintwork**

**for partial paintwork**

Mipa 2K-HS-Hardener HS 25 / 35

Mipa 2K-HS-Hardener HS 10

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

Mipa 2K-Hardener MS 10 LV



**Pot life**

1 h with Mipa 2K-Hardener HS 10, MS 10 LV at 70 °F (20 °C)

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

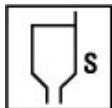
6 h with Mipa 2K-Hardener HS 35, MS 40 LV at 70 °F (20 °C)



**Thinner**

10 % Mipa 2K-Thinner medium V 25 or slow V 40

5 - 10 % Mipa 2K-Thinner medium V 25 or slow V 40



**Spray viscosity**

18 - 22 s 4 mm DIN

**gravity spray gun**

**Airmix/Airless**

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**Application mode**

**Application mode**

**Hardener**

**pressure (bar)**

**nozzle (mm)**

**spray passes**

**Thinner**

HVLP (low pressure)

2K HS Hardeners

29 - 36 psi

1,2 - 1,3

1,5 - 2

10 %

HVLP (low pressure)

2K MS Hardeners LV

2 - 2,5 bar

1,2 - 1,3

1,5 - 2

5 - 10 %

HVLP / internal nozzle pressure

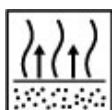
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9,8 psi (0,7)

1,2 - 1,3

1,5 - 2

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**Flash-off time**

5 - 8 min. between coats

10 - 15 min. before oven drying

**Dry coat thickness**

2 - 2,4 mil (50 - 60 µm)



**Drying time**

<b>object temperature</b>	<b>dust dry</b>	<b>set to touch</b>	<b>ready for assembly</b>	<b>sandable</b>	<b>recoatable</b>
70 °F (20 °C)	20 - 30 min.	5 - 6 h	12 - 24 h	--	--
140 °F (60 °C)	10 - 15 min.	25 - 30 min.	after cooling	--	--

**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 489 g/l / 4.1 lb/gl  
with exempt solvents 489 g/l / 4.1 lb/gl

VOC as applied:  
3:1 with HS Hardener + 10 % 2K Thinner < 527 g/l / 4.4 lb/gl  
2:1 with MS Hardeners LV + 10 % ZERO VOC Thinner slow < 420 g/l / 3.5 lb/gl  
2:1 with MS Hardeners LV + 10 % 2K Thinner < 491g/l / 4,1 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:**

Important: The spraying mode has an essential influence on the gloss level. Therefore the final coat should be applied thinly and homogeneously after approx. 5 -10 minutes flash-off time.

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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