

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-Klarlack matt CM + 5 - 10 % Mipa 2K-Elastic or

Mipa 2K-Klarlack matt CM + Mipa 2K-Klarlack glänzend (glossy) mixing ratio 3:1

Satin gloss:

Mipa 2K-Klarlack matt CM + 15 - 20 % Mipa 2K-Elastic or

Mipa 2K-Klarlack matt CM + Mipa 2K-Klarlack glänzend (glossy) mixing ratio 2:1

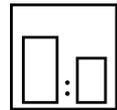
Spreading rate: 7,0 - 8,0 m²/l

Processing instructions



Colour

colourless



Mixing ratio

Hardener

Mipa 2K-MS-Härter

by weight (lacquer : hardener)

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by volume (lacquer : hardener)

2 : 1



Hardener

for complete paintwork

Mipa 2K-MS-Härter MS 25 / 40

for partial paintwork

Mipa 2K-MS-Härter MS 10



Pot life

1 h with Mipa 2K-MS-Härter MS 10 at 20 °C

4 h with Mipa 2K-MS-Härter MS 25 at 20 °C

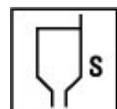
6 h with Mipa 2K-MS-Härter MS 40 at 20 °C



Thinner

Mipa 2K-Verdünnung V 25

Mipa 2K-Verdünnung lang V 40



Spray viscosity

gravity spray gun

18 - 20 s 4 mm DIN

Airmix/Airless

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Application mode

Application mode

gravity spray gun (high pressure)

HVLP (low pressure)

HVLP / internal nozzle pressure

Hardener

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pressure (bar)

2 - 2,5

2 - 2,2

0,7

nozzle (mm)

1,2 - 1,3

1,2 - 1,3

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spray passes

2

2

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Thinner

10

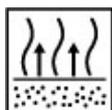
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Version: en 1220

This technical data sheet is supplied for informational purposes only! According to our information, all data and recommendations correspond to the state of art and are based on years of experience in manufacturing our products. They do not exempt the user from his obligation to verify professionally, on his own responsibility, the suitability of our products to the intended purpose under prevailing conditions. Safety data sheets and warnings on packaging must be observed. We reserve the right to modify and to complete the information content at any time, without prior notice or obligation to update.

MIPA SE · Am Oberen Moos 1 · D-84051 Essenbach · Tel.: +49(0)8703/922-0 · Fax: +49(0)8703/922-100 · mipa@mipa-paints.com · www.mipa-paints.com



Flash-off time

5 - 10 min between the coats
10 - 15 min before oven drying

Dry coat thickness

40 - 50 µm



Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	25 - 30 min	12 h	24 h	--	--
60 °C	--	30 min	2 h	--	--
Infrared drying shortwave	--	8 min	--	--	--
Infrared drying mediumwave	--	10 - 15 min	--	--	--

Note

- Storage:** at least 3 years in unopened original container
- VOC Regulation :** EU limit value for this product (category B/e): 840 g/l
This product contains max. 563 g/l of VOC.
- Processing conditions:** From +10 °C and up to 80 % relative air humidity. Ensure an adequate air ventilation.
- Processing instructions:** 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. 5-10 minutes.