

### Intended use

Mipa Binder AC is a system component for the mixing system Mipa OC 2K-PUR-Autolack, HS quality. By adding Mipa Binder AC it is possible to produce 2K-PUR acrylic car coatings (Mipa AC) in Medium-Solid quality (VOC < 480 g/l) which are resistant to weathering and yellowing and suitable for complete and partial paintworks.

Quantity to add: ready mixed Mipa OC colour + Mipa Binder AC (quantity is provided by Mipa Mix System), this mixture + hardener mixing ratio 2:1 by volume

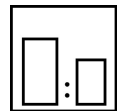
Spreading rate: 8,0 - 10,0 m<sup>2</sup>/l (Mipa AC)

### Processing instructions



#### Colour

Mipa Mix-System



#### Mixing ratio

##### Hardener

Mipa 2K-MS-Härter

**by weight (lacquer : hardener)    by volume (lacquer : hardener)**

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2 : 1



#### Hardener

##### for complete paintwork

Mipa 2K-MS-Härter MS 25

Mipa 2K-MS-Härter MS 40

##### for partial paintwork

Mipa 2K-MS-Härter MS 10

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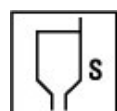
#### Pot life

2 - 8 h at 20 °C depending on the hardener in use



#### Thinner

0 - 10 % Mipa 2K-Verdünnung



#### Spray viscosity

##### Gravity spray gun

20 - 22 s 4 mm DIN

##### Airmix/Airless

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#### Application method

##### Application method

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 - 3

2 - 3

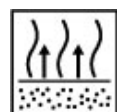
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##### Thinner

0 - 10

0 - 10

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#### Flash-off time

5 - 8 min between the coats

10 - 15 min before oven drying

**Dry coat thickness**  
50 - 60 µm



**Drying time**

Object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	35 - 45 min	5 - 6 h	12 - 24 h	--	--
60 °C	10 - 15 min	20 - 25 min	after cooling	--	--
Infrared drying shortwave	--	8 min	--	--	--
Infrared drying mediumwave	--	10 - 15 min	--	--	--

**Note**

**Storage:** at least 3 years in unopened original container

**VOC Regulation :**

**Processing conditions:** from +10 °C and up to 80 % relative air humidity. Ensure an adequate supply and exhaust air ventilation

**Processing instructions:** Check colour before application. Always check colours after having added the hardener. The addition of Binder AC may modify the colour.