

### Intended use

Two-component PUR acrylic paint for chassis with especially high solid content and very good chemical and mechanical resistance.

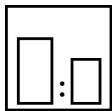
Spreading rate: 8,0 - 9,0 m<sup>2</sup>/l

### Processing instructions



#### Colour

RAL 9005 glossy, RAL 9011 MAN glossy  
RAL 9011 MAN satin gloss  
DB 7350 satin gloss  
RAL 3002 glossy



#### Mixing ratio

##### Hardener

Mipa 2K-HS-Härter  
Mipa 2K-MS-Härter

##### by weight (lacquer : hardener)

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##### by volume (lacquer : hardener)

3 : 1  
2 : 1



#### Hardener

##### for complete paintwork

Mipa 2K-HS-Härter HS 25 / 35  
Mipa 2K-MS-Härter MS 25 / 40

##### for partial paintwork

Mipa 2K-HS-Härter HS 10  
Mipa 2K-Härter MS 10



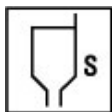
#### Pot life

1 h with Mipa 2K-Härter HS 10, MS 10 at 20 °C  
2 h with Mipa 2K-Härter HS 25, MS 25 at 20 °C  
4 h with Mipa 2K-Härter HS 35, MS 40 at 20 °C



#### Thinner

Mipa 2K-Verdünnung normal V 25  
Mipa 2K-Verdünnung lang V 40



#### Spray viscosity

Addition of thinner when using Mipa 2K-HS-Härter: 10 - 15 %  
Addition of thinner when using Mipa 2K-MS-Härter: 0 - 5 %

##### gravity spray gun

20 - 25 s 4 mm DIN

##### Airmix/Airless

20 - 25 s 4 mm DIN



#### Application mode

##### Application mode

gravity spray gun (high pressure)  
HVLP (low pressure)  
HVLP / internal nozzle pressure  
Airmix / Airless

##### Hardener

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##### pressure (bar)

2 - 2,5  
2 - 2,2  
0,7

##### nozzle (mm)

1,3 - 1,5  
1,3 - 1,4  
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0,23 - 0,28

##### spray passes

1 - 2  
1 - 2  
--  
1

##### dilution (%)

0 - 15  
0 - 15  
--  
0 - 15



**Flash-off time**

5 - 8 min between the coats  
 10 - 15 min before oven drying

**Dry coat thickness**

60 - 80 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>
20 °C	45 - 55 min	5 - 6 h	12 - 24 h	--	--
60 °C	10 - 15 min	25 - 30 min	after cooling-down	--	--
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/d): 420 g/l  
 This product contains max. 420 g/l of VOC.
- Processing conditions:** From +10 °C and up to 80 % relative air humidity. Ensure an adequate supply and exhaust air ventilation.
- Processing instructions:** Check colours before application. Check colour shades always after having added the hardener.