

Intended use

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

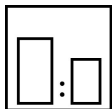
Spreading rate: 8,0 - 9,0 m²/l

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

by weight (lacquer : hardener)

by volume (lacquer : hardener)

Mipa 2K-HS-Härter
Mipa 2K-MS-Härter

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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 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

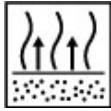
Airmix/Airless

20 - 25 s 4 mm DIN



Application method

Application method	Hardener	Pressure (bar)	Nozzle (mm)	spray passes	Thinner
gravity spray gun (high pressure)	--	2 - 2,5	1,3 - 1,5	1 - 2	0 - 15
HVLP (low pressure)	--	2 - 2,2	1,3 - 1,4	1 - 2	0 - 15
HVLP / internal nozzle pressure	--	0,7	--	--	--
Airmix / Airless	--	100 - 120	0,23 - 0,28	1	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

Object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
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.