Intended use

Mipa 2K-HS-Express-Klarlack CX 3 is a high-quality PUR clearcoat for fast and efficient refinishing (express technology), which generally does not require oven drying. Thanks to its special formulation Mipa 2K-HS-Express-Klarlack CX 3 cures very quickly already at room temperature (20° C) and can be polished after only approx. 60 minutes. To ensure optimum polishability, polishing should be carried out within 3 hours. Thus, large savings are possible by eliminating heating-related costs. At the same time, cycle times are reduced since the painting process does not have to be interrupted because of heating intervals. If required, oven drying is also possible, where full polishability is achieved after drying for approx. 15 minutes at 60 °C or 30 minutes at 40 °C plus cooling phase. Mipa 2K-HS-Express-Klarlack CX 3 is particularly suitable for coating parts of passenger cars or a complete car side plus front flap as well as for use in the spot repair sector. Mipa 2K-HS-Express-Klarlack CX 3 is particularly elastic due to its special formulation. This increases the process reliability of deformable parts such as bumpers during assembly. Ready for use after addition of hardener. This product provides outstanding resistance to all environmental and climatic conditions and yellowing and offers durable gloss retention as well as an excellent scratch resistance.

Spreading rate: 6,0 - 8,0 m²/l

Processing instructions

Colour

colourless

Mixing ratio

Hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
Mipa 2K-HX-Härter HX 25	--	1 : 1

Hardener

for complete paintwork	for partial paintwork
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Pot life

40 min with 2K-HX-Härter HX 25 at 20 °C

Thinner

ready for spraying after addition of hardener

Spray viscosity

gravity spray gun	Airmix/Airless
14 - 16 s 4 mm DIN	--

Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
gravity spray gun (high pressure)	--	2 - 2,5	1,0 - 1,2	2	--
HVLP (low pressure)	--	2 - 2,2	1,0 - 1,2	2	--
HVLP / internal nozzle pressure	--	0,7	--	--	--

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.

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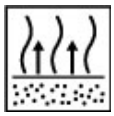

Flash-off time

0 - 3 min between the coats

0 - 3 min prior to oven drying

Dry coat thickness

40 - 50 µm

Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	10 - 15 min	30 - 45 min	1 h	--	--
60 °C	--	15 min	15 min	--	--
IInfrared drying shortwave	--	8 min	--	--	--
Infrared drying mediumwave	--	10 - 15 min	--	--	--

Note

Storage: at least 2 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 air ventilation.

Processing instructions: Please consider that pot life and curing depend on the prevailing air humidity.

Masking and adhesive tapes, which have been recoated with Mipa 2K-HS-Express-Klarlack CX 3, must be removed immediately after the application process. Otherwise, the fresh paint will be peeled off with the adhesive tape.

2K hardeners must be added to Mipa 2-Schicht Basislacke (basecoats) when recoating with Mipa
2K-HS-Express-Klarlack CX 3. The mixing ratios are:

Mipa BC + 10 % (10:1) Mipa 2K-MS-Härter MS 10 or 2K-HS-Härter HS 10 or HX 25

Mipa WBC + 5 % (20:1) Mipa WBC-Härter
Since a slight, system-related colour deviation is to be expected, especially with light metallic colours, due to the addition of hardeners, partial coatings edge to edge are not possible. This risk does not exist, however, when blending by fading out the basecoat and when using the spot repair application technique.

This product, as a system characteristic, may cause eye and skin irritation. Wear appropriate protective equipment.

In order to coat deformable plastic parts, Mipa 2K-HS-Express-Klarlack CX 3 must be plasticised with up to 15% of Mipa 2K-Elastic. This may slightly extend the drying time.

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