

Intended use

Mipa 2K-HS-Klarlack matt CCM with a gloss between 15 - 20 degrees at a 60°-angle is a VOC-conform High-Solid acrylic clearcoat to create high-quality matt coatings (partial or complete paintwork) on cars. It is also appropriate to adjust the gloss of Mipa 2K-HS-Klarlacke (clearcoats) and of Mipa 2K-HS-Express-Klarlack CX 2. It assures uniformly matted clear coatings on solvent-based and water-based basecoats. Mipa 2K-HS-Klarlack matt CCM provides high resistance to all kind of weathering as well as to chemical and mechanical stresses.

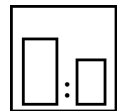
Spreading rate: 10,0 - 12,0 m²/l

Processing instructions



Colour

colourless



Mixing ratio

Hardener

Mipa 2K-MS-Härter MS 25 / 40

Mipa 2K-HS-Härter HS 25 / 35

by weight (lacquer : hardener)

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by volume (lacquer : hardener)

2 : 1

3 : 1



Hardener

for complete paintwork

Mipa 2K-MS-Härter MS 40

Mipa 2K-HS-Härter HS 35

for partial paintwork

Mipa 2K-MS-Härter MS 25

Mipa 2K-HS-Härter HS 25



Pot life

1 h at 20 °C



Thinner

Mipa 2K-Verdünnung normal V 25

Mipa 2K-Verdünnung lang V 40



Spray viscosity gravity spray gun

16 - 18 s 4 mm DIN

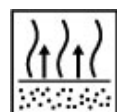
Airmix/Airless

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Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	dilution (%)
gravity spray gun (high pressure)	–	2 - 2,5	1,2 - 1,3	1,5	25
HVLP (low pressure)	–	2 - 2,2	1,2 - 1,3	1,5	25
HVLP / internal nozzle pressure	–	0,7	–	–	–



Flash-off time

5 - 10 min between the coats

30 - 45 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	25 - 35 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 2 years in unopened original container.
- VOC Regulation:** EU limit value for this product (category B/e): 840 g/l.
This product contains max. 495 g/l of VOC.
- Processing conditions:** From +10 °C and up to 80 % relative air humidity. Ensure an adequate air ventilation.

Processing instructions: Always stir Mipa 2K-HS-Klarlack matt CCM thoroughly before use, since sediment, that have not been stirred up, can lead to higher gloss levels and / or lumps.

Then adjust the spray viscosity and filter with a 125 µm filter before painting.

Optimal application on vertical surfaces:

- Apply first a thin and closed half coat.
- Intermediate flash-off time: 5 - 10 minutes at 20 °C.
- Then finish by applying 1 full coat.
- Final flash-off time: 30 - 45 minutes at 20 °C.

Optimal application on horizontal surfaces:

- Apply 1 flowing uniform layer.
- Intermediate flash-off time: 5 - 10 minutes at 20 °C.
- Then finish by applying 1 full coat.
- Apply a mist coat evenly on the still wet paint film with 2.0 bar spray pressure and from a larger distance.
- Final flash-off time: 30 - 45 minutes at 20 °C.

To ensure a uniform gloss level on large surfaces when painting passenger cars, it is advisable to integrate this into the daily routine as the last coat and to let it dry overnight at room temperature.

When applying matt clearcoats, the overlaps must be painted so that they run into each other as far as possible and excessive spray mist must be avoided, as this would lead to inhomogeneous matting and / or rough spots due to nibs in the coating.

In the case of application over a large area, where several vehicle parts are affected, we therefore recommend to remove bonnets, doors, tailgates, etc. and to coat them individually.

Since it is not possible to polish matt clearcoats, spot repairs are not possible. Therefore, always paint components over the entire surface. Under certain circumstances, it may be necessary to completely recoat entire vehicle sides to achieve a uniform matt finish.

Note also the following:

1. Colour matching/ gloss level determination:

As the gloss level of the matt clearcoat strongly influences the colour shade, you have to do spray-out cards before the actual refinishing.

Before comparing the spray-out cards to the old paintwork with regard to colour shade and gloss level match, the old coating must be cleaned carefully.

For the finishing coat the following must also be observed:

- Use of the same spray gun + nozzle with identical material and pressure settings.
- The application method + layer thicknesses must be identical
- Intermediate and final drying must be identical

2. cleanliness during application:

As polishing of matt varnishes is not possible due to the system, care must be taken to ensure that painting is done in a particularly clean and dust-free environment. This requires absolutely clean coating conditions, which makes it necessary to thoroughly clean the painting booth and check the ceiling and floor filters beforehand.

Possible gloss levels in combination with Mipa 2K-HS-Klarlacken CC 6 / CC 8 / CC 9 / CC 12 / CC 14 Thix and Mipa 2K-HS-Express-Klarlack CX 2:

Mipa 2K-HS-Klarlack matt + Mipa 2K-HS-Klarlack/ Mipa 2K-HS-Express-Klarlack CX 2,
mixing ratio 7:1 = satin matt

Mipa 2K-HS-Klarlack matt + Mipa 2K-HS-Klarlack/ Mipa 2K-HS-Express-Klarlack CX 2,
mixing ratio 4:1 = satin gloss

Mipa 2K-HS-Klarlack matt + Mipa 2K-HS-Klarlack/Mipa 2K-HS-Express-Klarlack CX 2,
mixing ratio 3:1 = semi-gloss