

### Intended use

Mipa 2K-Klarlack CPE with gloss level 60 - 75 gloss units at a 60° angle is a satin gloss, especially elastic acrylic clearcoat for high-quality complete or partial paintworks in the automotive sector. This clearcoat ensures a uniform satin gloss clear coat on solvent- or water-based basecoats. Mipa 2K-Klarlack CPE is highly resistant to all weather conditions as well as to chemical and mechanical stresses. In addition, Mipa 2K-Klarlack CPE is a component of numerous Mipa Mix formulations for plastic and/or special coatings. Due to the high elasticity of Mipa 2K-Klarlack CPE, there is no need to add an additional elasticising additive when coating plastic substrates.

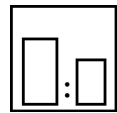
Spreading rate: 6,0 - 8,0 m<sup>2</sup>/l

### Processing instructions



#### Colour

colourless



#### 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 / 40

##### for partial paintwork

Mipa 2K-MS-Härter MS 10



#### Pot life

2 h with Mipa 2K-MS-Härter MS 10 at 20 °C

6 h with Mipa 2K-MS-Härter MS 25 at 20 °C

8 h with Mipa 2K-MS-Härter MS 40 at 20 °C



#### Thinner

10 - 15 % Mipa 2K-Verdünnung normal V 25

10 - 15 % Mipa 2K-Verdünnung lang V 40



#### Spray viscosity

##### gravity spray gun

18 - 20 s 4 mm DIN

##### Airmix/Airless

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#### Application mode

##### Application mode

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

2

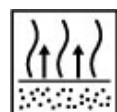
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##### dilution (%)

10 - 15

10 - 15

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#### Flash-off time

5 - 8 min between coats

10 - 15 min before oven drying

**Dry coat thickness**  
 50 - 60 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	30 min	12 h	24 h	--	--
60 °C	5 min	30 min	2 h	--	--
Infrared drying shortwave	--	8 min	--	--	--
Infrared drying mediumwave	--	10 - 15 min	--	--	--

**Note**

- Storage:** for at least 3 years in unopened original container
- VOC Regulation:** EU limit value for this product of category B/e: 840 g/l  
 This product contains max. 575 g/l of VOC.
- Processing conditions:** from +10 °C and up to 80 % relative air humidity. Ensure adequate air ventilation.

**Processing instructions:** Always stir Mipa 2K-Klarlack CPE 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.

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.