

Intended use

Mipa Rallye schwarz matt (black matt) is a weather and yellowing resistant two-component HS acrylic automotive finish to paint partially or completely vehicles in a uniform matt gloss finish.

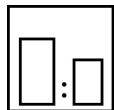
Spreading rate: –

Processing instructions



Colour

black matt



Mixing ratio

Hardener

Mipa 2K-HS-Härter
Mipa 2K-MS-Härter

by weight (lacquer : hardener)

–
–

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



Thinner

10 - 20 % Mipa 2K-Verdünnung V 25
10 - 20 % Mipa 2K-Verdünnung lang V 40



Spray viscosity

gravity spray gun

18 - 22 s 4 mm DIN

Airmix/Airless

–



Application mode

Application mode

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

Hardener

–
–
–

pressure (bar)

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

nozzle (mm)

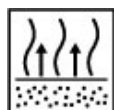
1,2 - 1,3
1,2 - 1,3
–

spray passes

1 - 2
1 - 2
–

Thinner

10 - 20
10 - 20
–



Flash-off time

5 - 8 min between coats
10 - 15 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	45 - 55 min	5 - 6 h	12 - 24 h	--	--
60 °C	10 - 15 min	25 - 30 min	after cooling	--	--
Infrared drying shortwave	--	8 min	--	--	--
Infrared drying mediumwave	--	10 - 15 min	--	--	--

Note

Storage: at least 2 years in unopened original containers

VOC Regulation : EU limit value for this product (category B/e): 840 g/l
This product contains max. 600 g/l of VOC.

Processing conditions: from +10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.

Processing instructions: Important: The spraying mode has an essential influence on the gloss level. Therefore the final coat should be applied thinly and homogeneously after approx. 5 -10 minutes flash-off time.