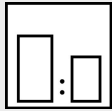


Intended use

High-quality 2-component clearcoat based on acrylic resin, with an excellent surface finish and excellent matt effect for high-quality industrial painting and automotive series painting.

Processing instructions**Mixing ratio****hardener**

PU 985-25

by weight (lacquer : hardener)

3 : 1

by volume (lacquer : hardener)

3 : 1

**Hardener**

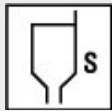
Mipa PU 985-25 2K PU Hardener

**Pot life**

with -25, approx. 3 h at 20 °C

**Thinner**

Mipa 2K-Verdünnung V 10, V 25, V 40

**Processing viscosity**

Ready for use after addition of hardener, if necessary thin with Mipa 2K-Verdünnung.

gravity spray gun

–

Airmix/Airless

–

**Application mode****application mode****hardener****pressure
(bar)****nozzle
(mm)****spray
passes****dilution**gravity spray gun /
HVLP

–

2,0 - 2,5

1,5

2 - 3

0 %

**Drying time****hardener****object
temperature****dust dry****set to
touch****ready for
assembly****sandable****recoatable**

–

80 °C

–

–

48 min

–

–

–

Infrared
drying
shortwave
at 80 °C

–

30 min

–

–

–

*Fully cured after 10 days (20 °C).***Note****Characteristics:**

binder base:

polyurethane acrylic system

solids content (% by weight):

~ 40

solids content (% by volume):

~ 38

delivery viscosity DIN 53211 4 mm (in s):

thixotropic

density DIN EN ISO 2811 (kg/l):

~ 1,1

gloss level ISO 2813 at 60° (GU):

5 - 10 matt

Version: en 1/0124

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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Properties:	Electrostatic application is possible Particularly good flow of the wet film during the drying process Highly UV-, weather and water-resistant High chemical resistance Highly resistant to solvents Scratch resistant Excellent chemical and mechanical resistance Heat resistance: - Short-term heat exposure: 180 °C - Permanent heat exposure: 150 °C
Theoretical spreading rate:	~ 50,1 m ² /kg, 3:1 by weight with PU 985-25 hardener, for 10 µm dry film thickness. ~ 53,1 m ² /l, 3:1 by weight with PU 985-25 hardener, for 10 µm dry film thickness.
Storage:	For at least 1 year in the unopened original container. Optimum storage conditions between + 5 °C and + 25 °C, avoid direct sunlight. Other storage conditions may lead to undesirable properties of the material.
VOC:	< 569 g/l.
Processing conditions:	From + 10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.
Substrate preparation:	Remove oil, grease, rust, mill scale, rolling skins, as well as other substances impairing the function of the coating! Attention: A direct adhesion cannot be taken as granted due to most different kinds of metals, alloys, metallic and conversion coatings and so on. The adhesion must therefore be tested on the original substrate. Steel: - Blast to cleaning degree Sa 2½, remove blast residues and overcoat promptly. - De-rust with hand and power tools to degree of cleanliness St 3. - Degrease with Mipa WBS Reiniger or Mipa Silikonentferner. Zincd substrates: - Clean the surface with the ammonia solution Mipa Zinkreiniger. - Sweep blast. Aluminium: - Degrease with Mipa 2K-Verdünnung, sand thoroughly with sandpaper P 360/400 and clean subsequently with Mipa Silikonentferner.
Proposed coating structure:	3-coat system Steel, zincd substrates, aluminium: Priming coat: *EP 100-20 with 50 - 70 µm dry film thickness or with 25 - 30 µm dry film thickness on aluminium. Finishing coat: *BC 200-30 / WBC 2000-30 with 15 - 20 µm dry film thickness. Clear coat: PU 850-10 with 40 - 50 µm dry film thickness.
Special notes:	*Further Mipa coats are available. Please contact your technical adviser or our application technicians. For professional use only. The gloss level may be higher or lower depending on the thickness of the coat, drying and color of the base coat.
Cleaning of tools:	Clean tools immediately after use with Mipa Nitroverdünnung.