

Intended use

Two-component, acrylic-based clearcoat with 15-20 gloss units at a 60°-angle. Good resistances, uniformly matted surfaces. Appropriate to finish matt, satin matt and satin gloss metallic and effect coatings. For use on plastic parts e.g. bumpers, just add the additive Mipa 2K-Elastic. Depending on the quantity of Mipa 2K-Elastic added, the gloss level increases up to max. 70 gloss units. Possible gloss levels:

Satin matt:

Mipa 2K-Klarlack matt CM + 5 - 10 % Mipa 2K-Elastic or

Mipa 2K-Klarlack matt CM + Mipa 2K-Klarlack glänzend (glossy) mixing ratio 3:1

Satin gloss:

Mipa 2K-Klarlack matt CM + 15 - 20 % Mipa 2K-Elastic or

Mipa 2K-Klarlack matt CM + Mipa 2K-Klarlack glänzend (glossy) mixing ratio 2:1

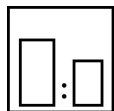
Spreading rate: 7,0 - 8,0 m²/l

Processing instructions



Colour

colourless



Mixing ratio

Hardener

Mipa 2K-MS-Härter

by weight (lacquer : hardener)

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by volume (lacquer : hardener)

2 : 1



Hardener

for complete paintwork

Mipa 2K-MS-Härter MS 25 / 40

for partial paintwork

Mipa 2K-MS-Härter MS 10



Pot life

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

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

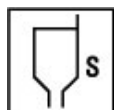
6 h with Mipa 2K-MS-Härter MS 40 at 20 °C



Thinner

Mipa 2K-Verdünnung normal V 25

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

10

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Flash-off time

5 - 10 min between the coats
10 - 15 min before oven drying

Dry coat thickness

40 - 50 µm



Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	25 - 30 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 3 years in unopened original container

VOC Regulation: EU limit value for this product (category B/e): 840 g/l
This product contains max. 563 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-Klarlack matt CM 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.