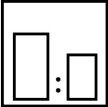



Intended use

Two-component medium-solid clearcoat based on high-quality acrylic resins with UV resistance and direct adhesion on bare ferrous and non-ferrous metals. The original appearance of the substrate is not changed.


Processing instructions


	Mixing ratio		
	hardener	by weight (lacquer : hardener)	by volume (lacquer : hardener)
	–	–	5 : 1

	Hardener
	Mipa MS 10, MS 25, MS 40

	Pot life
	Mit Härter MS 10 approx. 6 h at 20°C
	Mit Härter MS 40 approx. 8 h at 20°C

	Thinner
	Mipa 2K-Verdünnung

	Spray viscosity	Airmix/Airless
	gravity spray gun	–
	18 - 20 s 4 mm DIN	

	Application mode					
	application mode	hardener	pressure (bar)	nozzle (mm)	spray passes	dilution
	gravity spray gun / HVLP	–	2,0 - 2,5	1,2 - 1,3	2	10 - 15 %

	Drying time						
	hardener	object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
	–	20 °C	20 - 30 min	6 - 8 h	24 h	–	–
	–	60 °C	–	30 - 40 min	1 - 2 h	–	–

Fully cured after 7 - 8 days (at 20°C).

Note

Characteristics:	binder base:	polyurethane acrylic system
	solids content (% by weight):	49 - 51
	solids content (% by volume):	43 - 45
	delivery viscosity DIN 53211 4 mm (in s):	75 - 85
	density DIN EN ISO 2811 (kg/l):	0,9 - 1,0
	gloss level ISO 2813 at 60° (GU):	> 80 gloss

Properties:	highly UV- and weather-resistant short-term heat exposure: 150 °C permanent heat exposure: 130 °C adhesion on zinc steel substrates, aluminium, copper and brass colour: colourless
Theoretical spreading rate :	48,6 - 50,0 m ² /kg, 5:1 by volume with MS 25, for 10 µm dry film thickness 45,0 - 46,5 m ² /l, 5:1 by volume with MS 25, for 10 µm dry film thickness
Storage:	at least 3 years in unopened original containers.
VOC Regulation :	–
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 metal substrate.
Proposed coating structure:	1-coat system zinc steel substrates, aluminium, copper and brass 2K-Klarlack CA with 40 - 50 µm dry film thickness
Special notes:	For professional use only. The reddish colour of the product disappears after application. Mipa 2K-Klarlack CA can be tinted with Mipa Brillant Design or Mipa 2K-PUR-Autolack OC (max. addition: 20%). Mipa 2K-Klarlack CA cannot be used as a colourless protective coating on polished metals. In addition it is necessary to test preliminarily the adhesion on special metal substrates (e.g. very smooth and hard anodic coating) in order to assess if the product adheres directly without sanding. If required we also offer hardeners and cleaning agents that are suitable for 2-component mixing and dosing units. Please contact your technical adviser or our application technicians.
Cleaning of tools:	Clean Tools immediately after use with Mipa Nitroverdünnung.