

Intended use


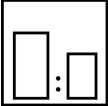





Mipa 2K-HS-Express-Klarlack CX 4 is a high-quality acrylic clearcoat for a fast and efficient refinish (express technology), which ensures extremely fast drying by oven as well as by air. This special drying property offers saving potentials in terms of spray booth occupancy, stoving times as well as working time. This leads to a considerable reduction in operating costs and increases the throughput. Another major advantage is that Mipa 2K-HS-Express-Klarlack CX 4 can be polished quickly:

After the drying of 10 minutes at 60 °C or 20 minutes at 40 °C, the painted parts can be polished immediately after the cooling. Alternatively it can be polished after a drying time of 1 hour at room temperature.

Mipa 2K-HS-Express-Klarlack CX 4 is also suitable for partial automobile paintwork. Ready for use after adding the hardener Mipa 2K-HS-Express-Härter HX 4. Perfectly resistant to weathering and environmental conditions, resistant to yellowing and durable gloss retention.

Spreading rate: 9,0 - 10,0 m²/l

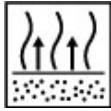
Processing instructions

	Colour colourless					
	Mixing ratio					
	Hardener		by weight (lacquer : hardener)	by volume (lacquer : hardener)		
	Mipa 2K-HS-Express-Härter HX 4	--		2 : 1		
	Hardener					
	for complete paintwork	--		for partial paintwork	--	
	Pot life					
	ca. 45 min with Mipa 2K-HS-Express-Härter HX 4 at 20 °C					
	Thinner					
	--					
	Spray viscosity					
	Ready for use after adding the hardener					
	gravity spray gun			Airmix/Airless		
	17 - 20 s 4 mm DIN			--		
	Application mode					
	Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
	gravity spray gun (high pressure)	--	2 - 2,5	1,2 - 1,3	1,5 - 2	--
	HVLP (low pressure)	--	2 - 2,2	1,2 - 1,3	1,5 - 2	--
	HVLP/ internal nozzle pressure	--	0,7	--	1,5 - 2	--

Version: en 0118

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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Flash-off time

3 - 5 min between the coats

5 - 10 min prior to oven drying

Dry coat thickness

40 - 60 µm



Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C	15 - 20 min	35 - 45 min	2 h	--	--
60 °C	--	10 min	--	--	--
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. 420 g/l of VOC.
- Processing conditions:** From +10 °C and up to 80 % relative air humidity. Ensure an adequate supply and exhaust air ventilation.
- Processing instructions:** To ensure an optimal intermediate adhesion on basecoats, the clearcoat must be applied within 2 hours drying at room temperature. If this time is exceeded, it is necessary to add a hardener to the basecoat.
The quantities to be added are:
- Mipa BC + 10 % (10:1) Mipa 2K-MS-Härter MS 10 or 2K-HS-Härter HS 10
- Mipa WBC + 5 % (20:1) Mipa WBC-Härter