

### Intended use

Mipa PUR HS 2K-Acryl-HS Fahrzeuglack is a weather- and yellowing- resistant High-Solid car paint for VOC-compliant partial or complete paintworks on trucks, busses and commercial vehicles. It provides particularly high opacity, spreading rate, gloss retention and resistance to chemical and mechanical strain.

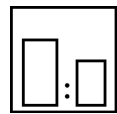
Spreading rate: 10,0 - 14,0 m<sup>2</sup>/l

### Processing instructions



#### Colour

Mipa Mix-System



#### Mixing ratio

##### Hardener

Mipa 2K-HS-Härter

Mipa 2K-MS-Härter

by weight (lacquer : hardener)

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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 Mipa 2K-Härter HS 10, MS 10

2 h Mipa 2K-Härter HS 25, MS 25

4 h Mipa 2K-Härter HS 35, MS 40



#### Thinner

Mipa 2K-Verdünnung kurz V 10

Mipa 2K-Verdünnung V 25

Mipa 2K-Verdünnung lang V 40



#### Spray viscosity

Nur bei Einsatz von HS-Härtern verdünnen, bei MS-Härtern ist keine Verdünnungszugabe nötig.

##### Gravity spray gun

25 - 30 s 4 mm DIN

##### Airmix/Airless

25 - 30 s 4 mm DIN



#### Application method

##### Application method

Gravity spray gun (high pressure)

HVLP (low pressure)

HVLP / internal nozzle pressure

Airmix / Airless

##### Hardener

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##### Pressure (bar)

2 - 2,5

2 - 2,2

0,7

100 - 120

##### Nozzle (mm)

1,2 - 1,3

1,2 - 1,3

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0,23 - 0,28

##### spray passes

1 - 2

1 - 2

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1

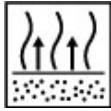
##### Thinner

5 - 10

5 - 10

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5 - 10



### 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 3 years in unopened original container

**VOC Regulation :** EU limit value for this product (category B/d): 420 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 avoid too high film builds (very high solid content as HS quality) strictly observe the recommended number of coats. Check colours before application. Always check colours after having added the hardener. The polishability of some colours may be limited due to the system. For subsequently matting with Mipa Multi Mat please observe the mixing ratios and information about application mentioned in the technical data sheet of Mipa Multi Mat.