

Intended use

Mipa 2K-HS-Klarlack CS 90 is a scratch-resistant two-component HS acrylic clearcoat based on Reflow technology. Because of its resistance to micro-scratches (caused e.g. by car wash plants) and to chemicals, Mipa 2K-HS-Klarlack CS 90 is particularly suitable for high-quality partial or complete paintworks on cars, motorcycles and commercial vehicles. Mipa 2K-HS-Klarlack CS 90 is especially easy to apply and is perfectly suitable to overcoat waterborne basecoats. VOC-conform.

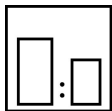
Spreading rate: 6,0 - 8,0 m²/l

Processing instructions



Colour

colourless



Mixing ratio

Hardener

Mipa 2K-Härter H 5

Mipa 2K-MS-Härter

Mipa 2K-HS-Härter

by weight (lacquer : hardener)

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by volume (lacquer : hardener)

2 : 1

2 : 1

3 : 1



Hardener

for complete paintwork

Mipa 2K-MS-Härter MS 25 / 40

Mipa 2K-HS-Härter HS 25 / 35

for partial paintwork

Mipa 2K-Härter H 5 (only Spot-Repair)

Mipa 2K-MS-Härter MS 10



Pot life

0,5 h with Mipa 2K-Härter H 5 at 20 °C

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

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

6 h with Mipa 2K-Härter MS 40 / HS 35 at 20 °C

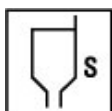


Thinner

Mipa 2K-Verdünnung kurz V 10

Mipa 2K-Verdünnung V 25

Mipa 2K-Verdünnung lang V 40



Spray viscosity

There is no need to add thinner when using the hardener Mipa 2K-Härter H 5 and MS-Härter.

Gravity spray gun

18 - 20 s 4 mm DIN

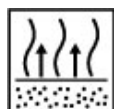
Airmix/Airless

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Application method

| Application method | Hardener | Pressure (bar) | Nozzle (mm) | spray passes | Thinner |
|-----------------------------------|----------|----------------|-------------|--------------|---------|
| gravity spray gun (high pressure) | – | 2 - 2,5 | 1,2 - 1,3 | 1 - 2 | 5 - 10 |
| HVLP (low pressure) | – | 2 - 2,2 | 1,2 - 1,3 | 1 - 2 | 5 - 10 |
| HVLP / internal nozzle pressure | – | 0,7 | – | – | – |



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 | 6 - 8 h | 24 h | – | – |
| 60 °C | – | 30 min | 1 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. 500 g/l of VOC.
- Processing conditions:** From +10 °C and up to 80 % relative air humidity. Ensure an adequate air ventilation.
- Processing instructions:** In case of BC-basecoats (solvent-based), it's necessary to apply first a thin coat (tack coat), which can be overcoated by applying 1-2 normal coats after approx. 3 - 5 min. flash-off time.