

### Intended use

Mipa Rallye schwarz matt (black matt) is a weather and yellowing resistant two-component HS acrylic automotive finish to paint partially or completely vehicles in a uniform matt gloss finish.

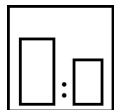
Spreading rate: –

### Processing instructions



#### Colour

black matt



#### Mixing ratio

##### Hardener

Mipa 2K-HS-Härter  
Mipa 2K-MS-Härter

##### by weight (lacquer : hardener)

–  
–

##### 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 with Mipa 2K-Härter HS 10, MS 10 at 20 °C  
4 h with Mipa 2K-Härter HS 25, MS 25 at 20 °C  
6 h with Mipa 2K-Härter HS 35, MS 40 at 20 °C



#### Thinner

10 - 20 % Mipa 2K-Verdünnung normal V 25  
10 - 20 % Mipa 2K-Verdünnung lang V 40



#### Spray viscosity

##### gravity spray gun

18 - 22 s 4 mm DIN

##### Airmix/Airless

–



#### Application mode

##### Application mode

gravity spray gun (high pressure)  
HVLP (low pressure)  
HVLP / internal nozzle pressure

##### Hardener

–  
–  
–

##### pressure (bar)

2 - 2,5  
2 - 2,2  
0,7

##### nozzle (mm)

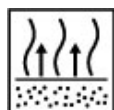
1,2 - 1,3  
1,2 - 1,3  
–

##### spray passes

1 - 2  
1 - 2  
–

##### dilution (%)

10 - 20  
10 - 20  
–



#### 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 2 years in unopened original containers.
- VOC Regulation:** EU limit value for this product (category B/e): 840 g/l.  
This product contains max. 600 g/l of VOC.
- Processing conditions:** From +10 °C and up to 80 % relative humidity. Ensure adequate air ventilation.
- Processing instructions:** Important: The spraying mode has an essential influence on the gloss level. Therefore the final coat should be applied thinly and homogeneously after approx. 5 -10 minutes flash-off time.