

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 we 	by weight (lacquer : hardener) 		by volume (lacquer : hardener) 3 : 1 2 : 1		
	Hardener for complete paintwor Mipa 2K-HS-Härter HS 2 Mipa 2K-MS-Härter MS	Μ	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 at20 °C						
X	Thinner 10 - 20 % Mipa 2K-Verdünnung normal V 25 10 - 20 % Mipa 2K-Verdünnung lang V 40						
Şs	Spray viscosity gravity spray gunAirmix/Airless18 - 22 s 4 mm DIN-						
	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 Dry coat thickness						
	Dry coat inickness						

50 - 60 µm

Version: en 1019

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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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.

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