

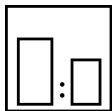
Intended use

Mipa 2K-HS-Klarlack CS 85 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 85 is particularly suitable for high-quality partial or complete paintworks on cars, motorcycles and commercial vehicles. Mipa 2K-HS-Klarlack CS 85 can be applied as topcoat on water-based or solvent-based basecoats and is VOC-conform.

Spreading rate: 6,0 - 8,0 m²/l

Processing instructions**Colour**

colourless

**Mixing ratio****Hardener**

Mipa 2K-HS-Härter

by weight (lacquer : hardener)

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by volume (lacquer : hardener)

2 : 1

**Hardener****for complete paintwork**

Mipa 2K-HS-Härter HS 25

Mipa 2K-HS-Härter HS 35

for partial paintwork

Mipa 2K-HS-Härter HS 10

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**Pot life**

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

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

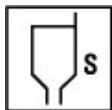
6 h with Mipa 2K-HS-Härter HS 35 at 20 °C

**Thinner**

Mipa 2K-Verdünnung kurz V 10

Mipa 2K-Verdünnung V 25

Mipa 2K-Verdünnung lang V 40

**Spray viscosity****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)

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2 - 2,5

1,2 - 1,3

1 - 2

15 - 20

HVLP (low pressure)

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2 - 2,2

1,2 - 1,3

1 - 2

15 - 20

HVLP / internal nozzle pressure

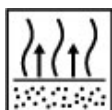
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0,7

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**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. 565 g/l of VOC.**Processing conditions:** From +10 °C and up to 80 % relative air humidity. Ensure an adequate air ventilation.**Processing instructions:** —