

### Intended use

Mipa 2K-HS-Express-Klarlack CX 4 is a high-quality acrylic clearcoat for a fast and efficient refinish (express technology), which ensures extremely fast drying by oven as well as by air. This special drying property offers saving potentials in terms of spray booth occupancy, stoving times as well as working time. This leads to a considerable reduction in operating costs and increases the throughput. Another major advantage is that Mipa 2K-HS-Express-Klarlack CX 4 can be polished quickly when it has been mixed with Mipa 2K-HS-Express-Härter HX 4:

After the drying of 10 minutes at 60 °C or 20 minutes at 40 °C, the painted parts can be polished immediately after the cooling. Alternatively it can be polished after a drying time of 1 hour at room temperature.

In combination with Mipa 2K-HS-Härter HS 10, the clearcoat can be polished as follows:

After the drying of 10 minutes at 60 °C or 15 minutes at 40 °C, the painted parts can be polished immediately after the cooling. Alternatively it can be polished after a drying time of 70 - 80 minutes at room temperature.

Mipa 2K-HS-Express Klarlack CX 4 is suitable for spot repair and partial paintwork and also for complete paintwork when mixed with hardener Mipa 2K-HS-Härter HS 25. In combination with hardener Mipa 2K-HS-Härter HS 25 the drying is as follows:

After the drying of 15 minutes at 60 °C or 30 minutes at 40 °C, the painted parts can be polished immediately after the cooling. Alternatively it can be polished after a drying time of 3 - 4 hours at room temperature.

Ready for use after adding the hardener. Perfectly resistant to weathering and environmental conditions, resistant to yellowing and durable gloss retention.

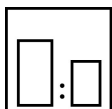
Spreading rate: 9,0 - 10,0 m<sup>2</sup>/l

### Processing instructions



#### Colour

colourless



#### Mixing ratio

##### Hardener

Mipa 2K-HS-Express-Härter HX 4	--
Mipa 2K-HS-Härter HS	--
Mipa 2K-HS-Härter HS 25	--

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

##### by volume (lacquer : hardener)

2 : 1
2 : 1
2 : 1



#### Hardener

##### for complete paintwork

Mipa 2K-HS-Härter HS 25

##### for partial paintwork

Mipa 2K-HS-Express-Härter HX 4  
Mipa 2K-HS-Härter HS 10



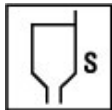
#### Pot life

approx. 45 min with Mipa 2K-HS-Express-Härter HX 4 at 20 °C  
approx. 45 min with Mipa 2K-HS-Härter HS 10 at 20 °C  
approx. 60 min with Mipa 2K-HS-Härter HS 25 at 20 °C



#### Thinner

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### Spray viscosity

Ready for use after adding the hardener

#### gravity spray gun

17 - 20 s 4 mm DIN

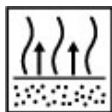
#### Airmix/Airless

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### Application mode

Application mode	Hardener	pressure (bar)	nozzle (mm)	spray passes	Thinner
gravity spray gun (high pressure)	--	2 - 2,5	1,2 - 1,3	1,5 - 2	--
HVLP (low pressure)	--	2 - 2,2	1,2 - 1,3	1,5 - 2	--
HVLP/ internal nozzle pressure	--	0,7	--	1,5 - 2	--



### Flash-off time

3 - 5 min between coats

5 - 10 min prior to oven drying

### Dry coat thickness

40 - 60 µm



### Drying time

object temperature	dust dry	set to touch	ready for assembly	sandable	recoatable
20 °C HX 4/ HS 10	15 - 20 min	35 - 45 min	2 h	--	--
20 °C HS 25	25 - 35 min	2 h	4 h	--	--
60 °C HX 4/ HS 10	--	10 min	after cooling	--	--
60 °C HS 25	--	15 min	after cooling	--	--

### 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:**

Infrared drying (with Mipa 2K-HS-Express-Härter HX 4):  
infrared drying shortwave approx. 8 min  
infrared drying mediumwave approx. 10 - 15 min

To ensure an optimal intermediate adhesion on basecoats, the clearcoat must be applied within 2 hours drying at room temperature. If this time is exceeded, it is necessary to add a hardener to the basecoat.

The quantities to be added are:

Mipa BC + 10 % (10:1) Mipa 2K-MS-Härter MS 10 or 2K-HS-Härter HS 10

Mipa WBC + 5 % (20:1) Mipa WBC-Härter