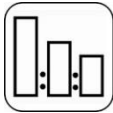


## Description

Two-pack, fast drying, light grey sanding primer filler with excellent application and sanding properties. Due to its fast ambient drying, it helps to reduce process time and provides exceptional enamel hold-out with all Nippon Paint nax Solvent-borne basecoats and topcoats.

## Suitable Substrates

Existing finishes	Glass reinforced laminates	nax polyester bodyfillers & putties
Steel	nax plastic primers	nax etching / wash primers
OEM Electro-coat	nax epoxy primers	



4 nax 2400 Urethane Primer Grey  
 1 nax 240 Urethane Primer Hardener  
 1-2 nax Premila Thinners

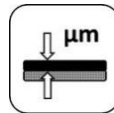


**Spray-gun Setup:**  
 Gravity fed | 1.4 - 1.8 mm

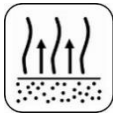
**Application Pressure:**  
 1.7 - 2.2 bar | 28-30 psi | At spray-gun air inlet  
 HVLP max 0.6-0.7 bar (8-10 psi) at the air cap



2 - 3 coats



40-50  $\mu\text{m}$  /coat (4:1:1)  
 30-40  $\mu\text{m}$  /coat (4:1:2)



**Between Coats:**  
 5 - 7 minutes at | 20°C | 70°F |

**Before 60°C (140°F) Baking:**  
 10 minutes at | 20°C | 70°F |



Dry to Sand	20°C (70°F)	30°C (86°F)	40°C (100°F)	60°C (140°F)	Infra-Red 4+8 minutes
	2 hours	1½ hours	1½ hours	30 minutes	



**Final dry sanding:**  
 P400 - P500



**Final wet sanding:**  
 P800 - P1000



**Re-coating**  
 With itself and all nax Premila primers, primer fillers and surfacers  
 With nax Premila 8000 Basecoat and nax Premila 7000 2K Solid Topcoat



nax 2400 Urethane Primer Grey	2 years
nax 240 Urethane Primer Hardener	2 years
nax Premila Thinners	2 years



▶ The VOC content of this product in ready to use form is maximum 606 g/liter



## Use suitable respiratory protection

Nippon Paint Automotive Refinishes recommends the use of fresh air supply respirator.

For detailed information read entire TDS.

## Description

Two-pack, fast drying, light grey sanding primer filler with excellent application and sanding properties. Due to its fast ambient drying, it helps to reduce process time and provides exceptional enamel hold-out with all Nippon Paint nax Solvent-borne basecoats and topcoats.

## Suitable Substrates

Existing finishes	Glass reinforced laminates	nax polyester bodyfillers & putties
Steel	nax plastic primers	nax etching / wash primers
OEM Electro-coat	nax epoxy primers	

**Notes:** In the following cases the use of etch primer is advised:  
a. When the system is required to meet the highest quality standard.  
b. Repairs that requires an extensive primer surfacer application, such as complete panel.

## Product and Additives

<b>Product</b>	nax 2400 Urethane Primer Grey	Acrylic resins	<b>Temperature Range</b>
<b>Hardeners</b>	nax 240 Urethane Primer Hardener	Poly-isocyanate resin	
<b>Thinners</b>	nax Premila 10 Fast Thinner	Blend of solvents	5-20°C
	nax Premila 20 Medium Thinner	Blend of solvents	20-35°C
	nax Premila 30 Slow Thinner	Blend of solvents	35-45°C
	nax Premila 40 Extra Slow Thinner	Blend of solvents	35-50°C
<b>Additives</b>	nax Softener		

## Surface Preparation



- ▶ Prior to any surface preparation, degrease the repair area using nax solvent-borne degreaser.
- ▶ Use clean quality rags or wiping towels, one for wetting and one for drying the surface.
- ▶ Apply sufficient degreaser to keep the surface wet and wipe degreaser off before it can evaporate.



- ▶ Removal of existing finish and initial sanding of polyester bodyfiller/putty: P120
- ▶ Feather edge before polyester/putty and finish, sanding for complete panel priming: P220
- ▶ Feather edge and final step before spraying primer/surfacer for spot repairs: P320
- ▶ Sound OEM electro (ED) coated parts: P320



- ▶ Prior to primer surfacer application degrease the application area using nax solvent-borne degreaser.
- ▶ Use clean quality rags or wiping towels, one for wetting and one for drying the surface.
- ▶ Apply sufficient degreaser to keep the surface wet and wipe degreaser off before it can evaporate.

**Notes:** Respect 100 grit maximum jump in dry sanding steps.

## Flexible Parts

Type of Plastic	Flexible	Soft	
nax 2400 Urethane Primer Grey	100	100	By volume
nax Softener	5	10	By volume

**Notes:** Hard plastic requires no softener.  
For plastic type information check nax Softener TDS (LAR.08.012).  
Stir well after adding the additive.  
Do not add more than 5% or 10% Softener, as the case may be, strictly under any circumstances to the primer.

## Tinting

nax 2400 Urethane Primer Grey can be custom tinted for special needs, up to 10% by volume with nax Premila MT Solid Toners added to the primer prior to addition of hardener and thinner. Once toner is added, stir the primer well prior to adding the hardener. Do not add more than 10% toner strictly under any circumstances to the primer.

## Mixing



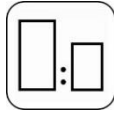
### Mixing Machine

For best performance, stir primer on mixing machine twice a day for 15 minutes.



### Product Mix

Stir well after each added component.



HB	MB	
4	4	nax 2400 Urethane Primer Grey
1	1	nax 240 Urethane Primer Hardener
1	2	nax Premila 10/20/30/40 Thinners

	Thinner Selection		
	Fast	Medium	Slow
	5-20°C	20-35°C	35-45°C
1-2 panels/spot	Fast	Medium	Slow
3-5 panels	Medium	medium	Slow
>5 panels	Slow	Slow	Slow

**Notes:** Stir well after each added component.

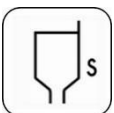
## Mixing (by weight) High Build (4 : 1 : 1)

RFU (ml)	nax 2400 Urethane Primer Grey (gr)	Nax 240 Urethane Primer Hardener (gr)	nax Premila Thinners (gr)
100	100	16	15
150	150	24	22
200	200	31	29
250	250	39	37
300	300	47	44
400	400	63	59
500	500	78	73
700	700	110	103
1000	1000	157	147

## Mixing (by weight) Medium Build (4 : 1 : 2)

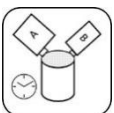
RFU (ml)	nax 2400 Urethane Primer Grey (gr)	Nax 240 Urethane Primer Hardener (gr)	nax Premila Thinners (gr)
100	86	13	25
150	129	20	38
200	171	27	50
250	214	34	63
300	257	40	75
400	343	54	101
500	429	67	126
700	600	94	176
1000	857	134	251

## Viscosity (DIN 4 Cup)



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ High Build	19-23 sec.	19-23 sec.	19-23 sec.
▶ Medium Build	14-18 sec.	14-18 sec.	14-18 sec.

## Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ High build	2 hrs.	30 min.	30 min.
▶ Medium build	3 hrs.	1.5 hrs.	45 min.

## Spray Gun Set-up / Application Pressure



	Spray-gun type	Nozzle size	Application pressure
▶	High build Gravity	1.6-1.8 mm	Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)
▶	Med. build Gravity	1.4-1.6 mm	1.7-2.2 bar at the spray gun air inlet

## Application



		Number of coats
▶	High build Depending on desired film build	2-3 coats
▶	Medium build	2-3 coats
▶	Apply one medium coat over the sanded repair area, then allow to flash for 5-7 minutes	
▶	Apply the 2 <sup>nd</sup> and 3 <sup>rd</sup> wet coat within each previous coats allowing 5-7 min. between coats.	

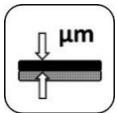
**Notes:** Allow each coat to flash-off naturally until the surface is completely matt. Do not force-dry by air support. Proper flash off helps achieving higher film build. Flash-off time depends on ambient temperature, applied layer thickness and airflow. For maximum build use large fluid tip and lower the application pressure.

## Drying Time



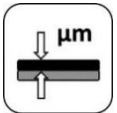
	20°C(70°F)	30°C(86°F)	>40°C(100°F)	60°C(140°F)	IR DRYING
▶	Dust dry 10 min.	5 min.	5 min.	-	n/a
▶	Dry to sand 2 hrs.	1½ hrs.	1½ hrs.	30 min.	n/a
▶	Flexible use 3 hrs.	2 hrs.	2 hrs.	40 min.	4+8 min.

## Film Thickness



▶	High build	Using the recommended application technique	50-60 µm/coat
▶	Medium build	Using the recommended application technique	30-40 µm/coat

## Coverage



By using the recommended application, the theoretical material coverage is:

7-10	m <sup>2</sup> /litre RTS mixture at	30-60 µm
75-108	ft <sup>2</sup> /litre RTS mixture at	30-60 µm

**Notes:** The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

## Finishing Surface Preparation



▶	Finishing dry sanding steps: 2K Topcoat / Basecoat	P400/P500
▶	Initial dry sanding step may be executed with a coarser grit:	P320
▶	For spot repair, finish the blending area with:	P500



▶	Finishing wet sanding steps: 2K Topcoat / Basecoat	P800/P1000
▶	Initial dry sanding step may be executed with a coarser grit:	P320
▶	Initial wet sanding step may be executed with a coarser grit: 2K Topcoat / Basecoat	P600/P800
▶	For spot repair, finish the blending area with:	P1000



- ▶ Prior to SB topcoat application degrease the surface using nax solvent-borne degreaser.
- ▶ Use clean quality rags or wiping towels, one for wetting and one for drying.
- ▶ Apply sufficient degreaser to keep the surface wet and wipe degreaser off before it can evaporate.

**Notes:** Respect 100 grit maximum jump in dry sanding steps and 200 grit maximum jump in wet sanding steps.

## Re-coating



With itself and all nax Premila primers, primer fillers and surfacers  
 With nax Premila 8000 Basecoat and nax Premila 7000 2K Solid Topcoat

Notes:

## Equipment Cleaning

Solvent borne gun cleaners.

## Solvent Content



▶ The VOC content of this product in ready to use form is max 606 g/liter

## Shelf-life



nax 2400 Urethane Primer Grey	2 years
nax 240 Urethane Primer Hardener	2 years
nax Premila Thinners	2 years
Minimum storage temperature:	5°C (41°F) Maximum storage temperature: 35°C (95°F)

Notes: Product shelf-life is determined when products are stored unopened at 20°C (70°F). Avoid extreme temperature fluctuation.

LAR.04.010. 080119

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