NIPPON PAINT

nax PREMILA 2K

nax Premila

Technical Data Sheets

P: 1800 810 114 | nipponpaintautomotive.com.au

Contents

CLEARCOATS

Description

Innovative high solid automotive finish with incorporation of CyGLAZ Technology to integrate superb toughness, high flexibility and excellent chemical resistance. The product is specially designed to exhibit excellent mar and scratch resistance to withstand day to day wear and tear e.g. car wash, acid rain, bird droppings etc., to ensure longer lasting beautiful look.

Suitable Substrates

nax Premila 8000 Basecoat
nax E-Cube WB Basecoat

2 nax Crystal 9905 Mirror Image Clear 2K 2:1
1 nax Crystal 905 2K Hardener

Spray-gun setup:
Gravity fed | 1.3-1.4 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

1 ½ - 2 coats

20 - 30 µm /coat

Between coats:
10 - 15 minutes at | 20°C | 70°F

Before 60°C (140°F) baking:
15 minutes at | 20°C | 70°F

	20°C (70°F)	30°C (86°F)	40°C(100°F)	60°C (140°F)	Infra-Red
Dust dry	90 min.	45 min.	30 min.	n/a	
Dry to handle	10 hrs.	5 hrs.	3 hrs.	45 min.	4+8 minutes
Dry to polish	10 hrs.	5 hrs.	4 hrs.	2 hrs. after cooldown	

nax Crystal 9905 Mirror Image Clear 2K 2:1	4 years
nax Crystal 905 2K Hardener	2 years

VOC

- The VOC content of this product in ready to use form is maximum 747 g/liter

Use suitable respiratory protection

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

For detailed information read entire TDS

nax Crystal 9905 Mirror Image Clear 2K 2:1

Description

Innovative high solids automotive finish with incorporation of CyGLAZ Technology to integrate superb toughness, high flexibility and excellent chemical resistance. The product is specially designed to exhibit excellent mar and scratch resistance to withstand day to day wear and tear e.g. car wash, acid rain, bird droppings etc., to ensure longer lasting beautiful look.

Suitable Substrates

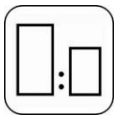
nax Premila 8000 Basecoat
nax E-Cube WB Basecoat

Notes: *Follow recommended flash off and re-coating time of the basecoat.*

Product and Additives

Product	nax Crystal 9905 Mirror Image Clear 2K 2:1	Acrylic Polyol	
Hardener	nax Crystal 905 2K Hardener	Poly-isocyanate resin	
Reducers	nax Premila 20 Medium Thinner	Blend of solvents	20-35°C
	nax Premila 40 Extra Slow Thinner	Blend of solvents	35-45°C

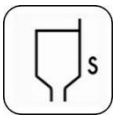
Mixing



2	nax Crystal 9905 Mirror Image Clear 2K 2:1
1	nax Crystal 905 2K Hardener
5%*	nax Premila 20 / 40 Thinners (aka 500/503) (optional)

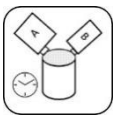
Notes: *Stir after each added component*
**To improve handling 5% of nax Premila Thinner 20 or 40 can be added.*

Viscosity (DIN 4 Cup)



	20°C(70°F)	30°C(86°F)
▸ Standard	14-17 sec	16-17 sec

Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▸ Standard	3 hrs	2 hrs	1½ hrs

Spray gun set-up / application pressure

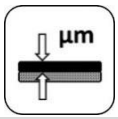
Spray-gun type	Spray-gun type	Nozzle size	Application pressure
▸ LVLP	Gravity	1.3-1.4 mm	1.7-2.2 bar at the spray gun air inlet
▸ HVLP	Gravity	1.3-1.4 mm	(HVLP: max 0.6-0.7 bar at the air cap)

Application

Standard Application
- Apply one medium coat, then allow to flash for 10-15 minutes.
- Apply the 2nd wet coat.

Notes: *Flash-off time depends on ambient temperature, applied layer thickness and airflow.*

Film thickness



▸ All	Using the recommended application technique	40-60 µm

Drying time

	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	Infra-Red
Dust dry	90 min.	45 min.	30 min.	-	
Dry to handle	10 hrs.	5 hrs.	3 hrs.	45 min.	4+8 min.
Dry to polish	10 hrs.	5 hrs.	4 hrs.	2hrs. after cooldown	

Notes:
Indicated drying times are panel temperatures. Oven temperature should be set 10 °C higher.
Allow 10 minutes flash off prior to Infra-Red drying.
The panel must not reach a temperature above 100°C (210°F) while curing.
Following the drying cycle at 60°C (140°F) object temperature, allow product to completely cool down to ambient temperature.
Using fast hardener at high temperatures can decrease the gloss.

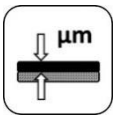
Polishing

Dust and minor imperfections can be polished out after the indicated air-dry times, or after 2 hours cool down time following the full bake at 60°C object temperature. Carefully sand out dust particles and restore the surface according polishing recommendations.

- Carefully de-nib using P1500 or finer with soap and water; blow air & dry the sanded area
- Machine sanding with P3000 is recommended to avoid sanding marks & minimize orange peel effect (use of soft interface pad is recommended at speed ~ 1500 rpm)
- Compound using Fast cut compounding paste with a wool compounding pad and an air or electric buffer at 1400 to 2000 rpm.
- Polish using standard fine polishing paste with a foam polishing pad and an air or electric buffer at 1400 to 2000 rpm (reduce pressure as polish begins to dry and buff to a high gloss).
- Remove any remaining residue using Detailing Cloth.

Notes:
**Recommended 3M™ Finesse-it™ SRC for better results (especially if the polishing process is being carried out after 48 hours).*
Polishing preferably needs to be carried out within 48 hours as longer waiting time will results in increased hardness of the paint film thereby making polishing harder as well.
Polishing can be done mechanically (preferable) or manually.
nax Crystal 9905 Mirror Image Clear is a hard & scratch resistant clear coat and so to get excellent results especially for gloss restoration, polishing needs to be done as per the recommended procedure especially if it done after longer curing time after application of the clear coat.

Coverage



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

- ± 6 m²/liter RTS mixture at 40-60 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.*

Equipment cleaning

Solvent borne guncleaners

Solvent Content

- The VOC content of this product in ready to use form is maximum 747 g/liter

Shelflife

nax Crystal 9905 Mirror Image Clear 2K 2:1		4 years	
nax Crystal 905 2K Hardener		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.07.014. 140917

PROFESSIONAL USE ONLY

Description

Ultra-fast ambient curing clear coat for improved productivity and cost reduction. The prominent feature of this clear coat is its ultra-high productivity cycle with a dry to polish time of less than 30 minutes under ambient cure conditions (25-30 °C). Avoiding the need of a high temperature baking cycle, therefore meeting the requirements of “quick repair” and “energy saving” concepts. If require, an extremely short time bake of 5 minutes at 50 °C is more than sufficient to achieve ultra-fast curing properties. As a premium clear coat, it offers outstanding application properties, it is easy to polish, and has excellent gloss and appearance.

Suitable Substrates

nax Premila 8000 series basecoat
nax E-Cube WB basecoat system

2	nax Premila 9800 HP Velocity Clear 2K 2:1
1	nax Premila 980 HP 2K Hardener

Spray-gun setup:
Gravity fed | 1.3 -1.4 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 coats

25-35 µm /coat

Between coats:
2 - 5 minutes at | 20°C | 70°F

Before 50°C (122°F) baking:
2 - 5 minutes at | 20°C | 70°F

	20°C (70°F)	30°C (70°F)	40°C (70°F)	50°C (122°F)
Dust dry	10 min.	7 min.	5 min.	n/a
Dry to handle	30 min	15 min.	10 min.	5 min.
Dry to polish	60 min.	25 min.	15 min.	after cooldown

nax Premila 9800 HP Velocity Clear 2K 2:1	4 years
nax Premila 980 HP 2K Hardener	2 years

VOC

- The VOC content of this product in ready to use form is maximum 520 g/liter

Use suitable respiratory protection

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

For detailed information read entire TDS

nax Premila 9800 HP Velocity Clear 2K 2:1

Description

Ultra-fast curing clear coat for improved productivity and cost reduction. The salient feature of this clear coat is its ultra-high productivity cycle with a dry to polish time of less than 30 minutes under ambient cure conditions (25-30 °C). Avoiding the need of a high temperature baking cycle, therefore meeting the requirements of “quick repair” and “energy saving” concepts. If require, an extremely short time bake of 5 minutes @50 °C is more than sufficient to achieve ultra-fast curing properties. As a premium clear coat, it offers outstanding application properties, it is easy to polish, and has excellent gloss and appearance.

Suitable Substrates

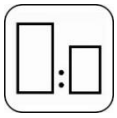
nax Premila 8000 Basecoat
nax E-Cube WB Basecoat

Notes: *Follow recommended flash off and re-coating time of the basecoat.*

Product and Additives

Product	nax Premila 9800 HP Velocity Clear 2K 2:1	Acrylic resin	
Hardener	nax Premila 980 HP 2K Hardener	Poly-isocyanate resin	
Reducers	nax Premila 20 Medium Thinner (aka 500)	Blend of solvents	20-35°C
	nax Premila 40 Extra Slow Thinner (aka 503)	Blend of solvents	35-45°C

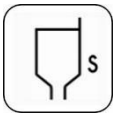
Mixing



2	nax Premila 9800HP Velocity Clear 2K 2:1
1	nax Premila 980 HP 2K Hardener
5%*	nax Premila 20 / 40 Thinners (optional)*

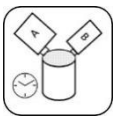
Notes: *Stir after each added component*
**To improve handling 5% of nax Premila Thinner 20 or 40 can be added.*

Viscosity (DIN 4 Cup)



20°C(70°F)	**30°C(86°F)**	**40°C(100°F)**
14-16 sec	13-14 sec	12-13 sec

Pot Life



20°C(70°F)	**30°C(86°F)**	**40°C(100°F)**
2 hours	1 hour	30 min.

Notes: ***<u>For efficient use, the clearcoat should be mixed and applied within 2-3 minutes after mixing to minimize any impact on application due to rise in viscosity.</u>***

Spray gun set-up / application pressure

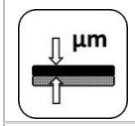
Spray-gun type	Spray-gun type	Nozzle size	Application pressure
▸ LVLP	Gravity	1.3-1.4 mm	1.7-2.2 bar at the spray gun air inlet
▸ HVLP	Gravity	1.3-1.4 mm	(HVLP: max 0.6-0.7 bar at the air cap)

Application

Standard Application
- Apply one medium coat, then allow to flash for 2-5 minutes.
- Apply the 2nd wet coat.

Notes: *Application window: 15°C to 38°C, Relative Humidity – 20% to 85%*
Flash-off time depends on ambient temperature, applied layer thickness and airflow.
Clean spray-gun immediately after application

Film thickness



Using the recommended application technique	50-60 µm

Notes: *Flash-off time depends on ambient temperature, applied layer thickness and airflow.*

Drying time

	20°C(70°F)	30°C(86°F)	40°C(100°F)	50°C(122°F)
Dust dry	10 min.	7 min.	5 min.	n/a
Dry to handle	30 min.	15 min.	10 min.	5 min.
Dry to polish	60 min.	25 min.	15 min.	After cool down

Notes: *Indicated drying times are panel temperatures. Oven temperature should be set 10 °C higher.*
Following the drying cycle at 50°C (122°F) object temperature, allow product to completely cool down to ambient temperature.

Polishing

Dust and minor imperfections can be polished out after the indicated air-dry times, or after cool down time following the full bake at 50°C object temperature. Carefully sand out dust particles and restore the surface according polishing recommendations.

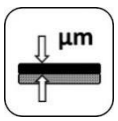
Notes: ***Dirt Removal, Gloss retention and polishing & waxing***
- *De-nib using P1500 or finer with soap and water; blow air & dry the sand area*
- *Machine sanding with P3000 is recommended to avoid sanding marks & minimize orange peel effect (use of soft interface pad is recommended at speed ~ 1500 rpm)*
- *Compound using 3M™ with a wool compounding pad and an air or electric buffer at 1400 to 2000 rpm.*
- *Polish using 3M™ with a foam polishing pad and an air or electric buffer at 1400 to 2000 rpm (reduce pressure as polish begins to dry and buff to a high gloss).*
- *Remove any remaining residue using Detailing Cloth.*

Re-coating

With itself after complete drying cycle (after 24 hours of drying sanding is necessary)

Notes:

Coverage



By using the recommended application, the theoretical material coverage is:
- ± 6 m²/liter RTS mixture at 40-60 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.*

Equipment cleaning

Solvent borne guncleaners

Solvent Content

- The VOC content of this product in ready to use form is maximum 520 g/liter

Shelflife

nax Premila 9800 HP Velocity Clear 2K 2:1	4 years
nax Premila 980 HP 2K Hardener	2 years

Minimum storage temperature:	5°C (41°F)	Maximum storage temperature:	35°C (95°F)

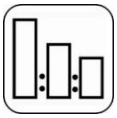
Notes: *Product shelf-life is determined when products are stored unopened at 20°C (70°F). Avoid extreme temperature fluctuation.*

Description

Premium two component hi-solid, high performance acrylic urethane clear. Provides deep gloss/brilliance and protection over different types of basecoats. Ideal clearcoat from spot repair to complete respray, providing excellent chemical resistance and UV protection.

Suitable Substrates

nax Premila 8000 series basecoat
nax E-Cube WB basecoat system

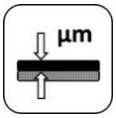


2	nax Premila 9800 Clear 2K Premium Hi-Solid 2:1
1	nax Premila 980 2K Hardeners
20-30%	nax Premila Thinners

Spray-gun setup:
Gravity fed | 1.3-1.4 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

1 ½ - 2 coats



25-35 µm /coat

Between coats:
5 - 10 minutes at | 20°C | 70°F

Before 60°C (140°F) baking:
10-15 minutes at | 20°C | 70°F

	20°C (70°F)	30°C (86°F)	40°C(100°F)	60°C (140°F)	Infra-Red
Dust dry	20-40 min.	10-30 min.	5-20 min.	-	-
Dry to handle	6-12 hrs.	3-6 hrs.	1½-3 hrs.	20-45 min.	4+8 minutes
Dry to polish	8-24 hrs.	4-10 hrs.	3-6 hrs.	1 hr. after cooldown	

nax Premila 9800 Clear 2K Premium Hi-Solid 2:1	4 years
nax Premila 980 2K Hardeners	2 years
nax Premila Thinners	2 years

- The VOC content of this product in ready to use form is maximum 474 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

Premium two component hi-solid, high performance acrylic urethane clear. Provides deep gloss/brilliance and protection over different types of basecoats. Ideal clearcoat from spot repair to complete respray, providing excellent chemical resistance and UV protection.

Suitable Substrates

nax Premila 8000 series basecoat
nax E-Cube WB basecoat system

Notes: *Follow recommended flash off and re-coating time of the basecoat.*

Product and Additives

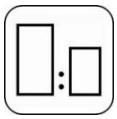
Product	nax Premila 9800 Clear 2K Premium Hi-Solid 2:1	Acrylic Polyol	
Hardeners	nax Premila 980 2K Hardener	Poly-isocyanate resin	20-40°C
	nax Premila 980 2K Slow Hardener	Poly-isocyanate resin	Above 40°C
	nax Premila 980 RP Rapid Hardener	Poly-isocyanate resin	15-25°C
Thinners	nax Premila 10 Fast Thinner (aka 502)	Blend of solvents	5-20°C
	nax Premila 20 Medium Thinner (aka 500)	Blend of solvents	20-35°C
	nax Premila 30 Slow Thinner (aka 501)	Blend of solvents	35-45°C
	nax Premila 40 Extra Slow Thinner (aka 503)	Blend of solvents	35-50°C
Additives	nax Softener		

Flexible Parts

Type of Plastic	Clearcoat	nax Softener
Flexible/Soft	100	5%
Soft	100	10%

Notes: *Hard plastic requires no softener. Stir well after adding the additive*

Mixing



2	nax Premila 9800 Clear 2K Premium Hi-Solid
1	nax Premila 980 2K Hardeners
20-30%	nax Premila Thinners

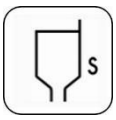
Hardener/Thinner Selection

	15-25°C	20-40°C	≥ 40°C
1-2 panels	RP/10	RP/20	Std/30
3-5 panels	RP/20	Std/20	Slow/30
>5 panels	Std/30	Std/30	Slow/40

Above ratio is for both normal and flexible system

Notes: *Stir after each added component*

Viscosity (DIN 4 Cup)



	20°C(70°F)	30°C(86°F)
▸ Standard	15-17 sec	15-17 sec

Pot Life

	20°C(70°F)	30°C(86°F)	40°C(100°F)
▸ Standard	3 Hrs.	2 Hrs.	1 Hr.
▸ Slow	4 Hrs.	3 Hrs.	2 Hrs.
▸ Rapid	1½ Hrs.	60 Min.	30 Min.

Spray gun set-up / application pressure

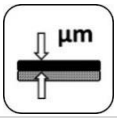
Spray-gun type	Spray-gun type	Nozzle size	Application pressure
▸ LVLP	Gravity	1.3-1.4 mm	1.7-2.2 bar at the spray gun air inlet
▸ HVLP	Gravity	1.3-1.4 mm	(HVLP: max 0.6-0.7 bar at the air cap)

Application

1½ coat	▸	Apply one light coat, then allow to flash for 2-5 minutes.
Application	▸	Apply a wet 2nd coat.
2 coat	▸	Apply one medium coat, then allow to flash for 5-10 minutes.
Application	▸	Apply a wet 2nd coat.

Notes: *Flash-off time depends on ambient temperature, applied layer thickness and airflow.*

Film thickness



Using the recommended application technique	50-70 µm

Drying time

Dust dry	**20°C(70°F)**	**30°C(86°F)**	**40°C(100°F)**	**60°C(140°F)**	**Infra-Red**
▸ Standard	40 min.	30 min.	20 min.	-	n/a
▸ Slow	60 min	45 min	30 min.	-	n/a
▸ Rapid	20 min.	10 min.	5 min.	-	n/a
Dry to handle					
▸ Standard	12 hrs.	6 hrs.	3 hrs.	45 min.	4+8 min.
▸ Slow	16 hrs.	8 hrs.	4 hrs.	40 min.	4+10
▸ Rapid	6 hrs.	3 hrs.	1½ hrs.	20 min.	4+8 min.
Dry to Polish					
▸ Standard	16 hrs.	10 hrs.	6 hrs.	1 hour after cool down	
▸ Slow	24 hrs.	12 hrs.	8 hrs.		
▸ Rapid	8 hrs.	4 hrs.	3 hrs.		

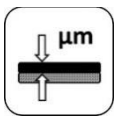
Notes: *Indicated drying times are panel temperatures. Oven temperature should be set 10 °C higher.*
Allow 10 minutes flash off prior to Infra-Red drying.
The panel must not reach a temperature above 100°C (210°F) while curing.
Following the drying cycle at 60°C (140°F) object temperature, allow product to completely cool down to ambient temperature.
Using fast hardener at high temperatures can decrease the gloss.

Polishing

Dust and minor imperfections can be polished out after indicated drying times, or after a one hour cool down time following the full bake at 60°C object temperature or IR drying. Carefully sand out dust particles and restore the surface according polishing recommendations.

Notes:

Coverage



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

▸ ± 8 m²/liter RTS mixture at 50 -70 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.*

Equipment cleaning

Solvent borne guncleaners

Solvent Content

- The VOC content of this product in ready to use form is maximum 474 g/liter

Shelflife

nax Premila 9800 Clear 2K Premium Hi-Solid 2:1		4 years	
nax Premila 980 2K Hardeners		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.07.012. 140917

PROFESSIONAL USE ONLY

Description

High quality extra solid two component acrylic urethane clear. Provides excellent gloss and protection over Solvent and water borne basecoats. Ideal clearcoat from spot repair to complete respray, providing excellent chemical resistance and UV protection.

Suitable Substrates

nax Premila 8000 series basecoat
nax E-Cube WB basecoat system

2	nax Premila 9600 Extra Solid Clear 2K 2:1
1	nax Premila 210 2K Hardeners
0-10%	nax Premila Thinners

Spray-gun setup:
Gravity fed | 1.3-1.4 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 coats

40-60 µm

Between coats:
5 - 10 minutes at | 20°C | 70°F

Before 60°C (140°F) baking:
5 - 10 minutes at | 20°C | 70°F

	20°C (70°F)	30°C (70°F)	40°C (70°F)	60°C (140°F)	Infra-Red
Dust dry	15 min.	10 min.	10 min.	-	n/a
Dry to handle	6-12 hrs.	3-6 hrs.	1½-3 hrs.	20-40 min.	4+8 min.
Dry to polish	6-12 hrs.	3-6 hrs.	1½-3 hrs.	1 hr. after cooldown	

nax Premila 9600 Extra Solid Clear 2K 2:1	4 years
nax Premila 210 2K Hardeners	2 years
nax Premila Thinners	2 years

VOC

- The VOC content of this product in ready to use form is maximum 550 g/liter

Use suitable respiratory protection

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

For detailed information read entire TDS

nax Premila 9600 Extra Solid Clear 2K 2:1

Description

High quality extra solid two component acrylic urethane clear. Provides excellent gloss and protection over solvent and water borne basecoats. Ideal clearcoat from spot repair to complete respray, providing excellent chemical resistance and UV protection.

Suitable Substrates

nax Premila 8000 series basecoat
nax E-Cube WB basecoat system

Notes: *Follow recommended flash off and re-coating time of the basecoat.*

Product and Additives

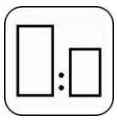
Product	nax Premila 9600 Extra Solid Clear 2K 2:1	Acrylic Polyol	
Hardeners	nax Premila 210 2K Hardener	Poly-isocyanate resin	
	nax Premila 210 RP Hardener Rapid	Poly-isocyanate resin	
	nax Premila 210 2K Slow Hardener	Poly-isocyanate resin	
Thinners	nax Premila 10 Fast Thinner (aka 502)	Blend of solvents	5-20°C
	nax Premila 20 Medium Thinner (aka 500)	Blend of solvents	20-35°C
	nax Premila 30 Slow Thinner (aka 501)	Blend of solvents	35-45°C
	nax Premila 40 Extra Slow Thinner (aka 503)	Blend of solvents	35-50°C
Additives	nax Softener		

Flexible Parts

Type of Plastic	Clearcoat	nax Softener
Flexible/Soft	100	5%
Soft	100	10%

Notes: *Hard plastic requires no softener. For plastic type information check nax Softener TDS (LAR.08.012)*
Stir well after adding the additive

Mixing

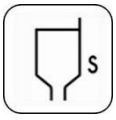


		Hardener/Thinner Selection			
			5-20°C	**20-35°C**	**≥ 35°C**
2	nax Premila 9600 Extra Solid Clear 2K 2:1				
1	nax Premila 210 2K Hardeners	1-2 panels	RP/10	RP/20	Std/30
0-10%	nax Premila Thinners	3-5 panels	RP/20	Std/20	Slow/30
		>5 panels	Std/30	Std/30	Slow/40

Above ratio is for both normal and flexible system

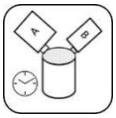
Notes: *Stir after each added component*

Viscosity (DIN 4 Cup)



	20°C(70°F)	**30°C(86°F)**
▸ Standard/Slow/Rapid	17-18 sec	14-17 sec

Pot Life



	20°C(70°F)	**30°C(86°F)**	**40°C(100°F)**
▸ Standard/Slow	2 hrs	1½ hrs	1 hr
▸ Slow	3 hrs	2 min	1½ min
▸ Rapid	1½ hrs	45 min	30 min

Spray gun set-up / application pressure

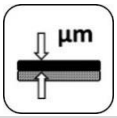
Spray-gun type	Spray-gun type	Nozzle size	Application pressure
▸ LVLP	Gravity	1.3-1.4 mm	1.7-2.2 bar at the spray gun air inlet
▸ HVLP	Gravity	1.3-1.4 mm	(HVLP: max 0.6-0.7 bar at the air cap)

Application

Standard Application
- Apply one medium coat, then allow to flash for 5-10 minutes.
- Apply the 2nd and if required a 3rd wet coats allowing 5-10 minutes between coats.

Notes: *Flash-off time depends on ambient temperature, applied layer thickness and airflow.*

Film thickness



▸ All	Using the recommended application technique	40-60 µm	

Drying time

Dust dry	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	Infra-Red
▸ Standard	10-20 min.	10-20 min.	10 min.	-	n/a
▸ Slow	25-30 min	20-25 min	20 min	-	n/a
▸ Rapid	10 min.	5-10 min.	5 min.	-	n/a
Dry to handle and polish					
▸ Standard	8 hrs.	4 hrs.	2 hrs.	30 min.	4+8 min.
▸ Slow	12 hrs.	6 hrs.	3 hrs.	40 min.	4+10
▸ Rapid	6 hrs.	3 hrs.	1½ hrs.	20 min.	4+8 min.

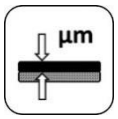
Notes:
Indicated drying times are panel temperatures. Oven temperature should be set 10 °C higher.
Allow 10 minutes flash off prior to Infra-Red drying.
The panel must not reach a temperature above 100°C (210°F) while curing.
Following the drying cycle at 60°C (140°F) object temperature, allow product to completely cool down to ambient temperature.
Using fast hardener at high temperatures can decrease the gloss.

Polishing

Dust and minor imperfections can be polished out after indicated air-dry times, or after a one hour cool down time following the full bake at 60°C object temperature or IR drying. Carefully sand out dust particles and restore the surface according polishing recommendations.

Notes:

Coverage



By using the recommended application, the theoretical material coverage is:
- ±7 m²/liter RTS mixture at 40-60 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.*

Equipment cleaning

Solvent borne guncleaners

Solvent Content

- The VOC content of this product in ready to use form is maximum 550 g/liter

Shelflife

nax Premila 9600 Extra Solid Clear 2K 2:1		4 years	
nax Premila 210 2K Hardeners		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.07.011. 140917

PROFESSIONAL USE ONLY

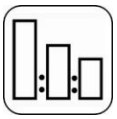
2K TOPCOAT

Description

Two component high solid, acrylic enamel direct gloss topcoat as part of the Premila Master Tint system. Designed to duplicate OEM finishes in solid colours. Provides easy application, fast drying, easy spot repair, excellent hiding power, and high gloss.

Suitable Substrates

Existing finishes with the exception of thermoplastic acrylic finishes.
All nax Pro LV and Premila primers, primer fillers/surfacers.

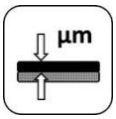


4 nax Premila 7000 2K Solid Topcoat (Ready Colour Mix)
1 nax Premila 410 / 412RP 2K Hardeners
1 nax Premila Thinners

Spray-gun setup:
Gravity fed | 1.3-1.4 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



20-30 µm /coat

Between coats:
5 - 10 minutes at | 20°C | 70°F

Before 60°C (140°F) baking:
5 - 10 Minutes at | 20°C | 70°F

	20°C (70°F)	30°C (70°F)	40°C (70°F)	60°C (140°F)	Infra-Red
Dust dry	12 min.	10 min.	8 min.	-	n/a
Dry to handle	8 hrs.	3 hrs.	3 hrs.	30 minutes	5+10 minutes
Dry to polish	>10 hrs.	>8 hrs.	>6 hrs.	1 hour after cooldown	5+10 minutes

nax Premila Master Tint Solid Toners / 2K Binder	4 years
nax Premila 410 / 412RP 2K Hardeners	2 years
nax Premila Thinners	2 years

▸ The VOC content of this product in ready to use form is maximum 590 g/liter

Use suitable respiratory protection

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

For detailed information read entire TDS

nax Premila 7000 2K Solid Topcoat

Description

Two component high solid, acrylic enamel direct gloss topcoat as part of the Premila Master Tint system. Designed to duplicate OEM finishes in solid colours. Provides easy application n, fast drying, easy spot repair, excellent hiding power, and high gloss.

Suitable Substrates

Existing finishes with the exception of thermoplastic acrylic finishes.
All nax Pro LV and Premila primers, primer fillers/surfacers.

Notes: *Follow recommended flash off and re-coating time of the wet-on-wet primer.*

Product and Additives

Product	nax Premila Master Tint Solid Toners / 2K Binder	Acrylic polyol resin	
Hardener	nax Premila 410 2K Hardener	Poly-isocyanate resin	
	nax Premila 412 RP 2K Hardener	Poly-isocyanate resin	
Thinners	nax Premila 10 Fast Thinner (aka 502)	Blend of solvents	5-20°C
	nax Premila 20 Medium Thinner (aka 500)	Blend of solvents	20-35°C
	nax Premila 30 Slow Thinner (aka 501)	Blend of solvents	35-45°C
	nax Premila 40 Extra Slow Thinner (aka 503)	Blend of solvents	35-50°C
Additives	nax Softener		

Final surface preparation

- Finishing dry sanding steps: P400
- 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: P800
- Initial dry sanding step may be executed with a coarser grit: P320
- Initial wet sanding step may be executed with a coarser grit: P600
- For spot repair, finish the blending area with: P1000

- Prior to SB topcoat application degrease the surface using nax solventborne 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. For detailed surface preparation see TDS*

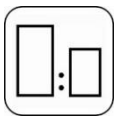
Mixing

Mixing Machine

Stir toners on mixing machine twice a day for 15 minutes and just before formula mixing.

Colour Mix

Must be stirred thoroughly directly after mixing the formula.

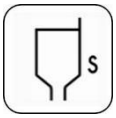


Standard	Flexible	
4	4	nax Premila 7000 colour mix (formula)
1	1	nax Premila 410 / 412RP 2K Hardeners
1	-	nax Premila Thinners
-	0.5	nax Softener

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

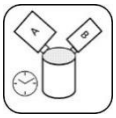
Notes: *Stir after each added component*

Viscosity (DIN 4 Cup)



	20°C(70°F)	30°C(86°F)
▸ Standard	15-22 sec	15-17 sec
▸ Flexible application	20-22 sec	15-17 sec

Pot Life



20°C(70°F)	30°C(86°F)	40°C(100°F)
5 hours	4 hours	2 hours

Spray gun set-up / application pressure

Spray-gun type	Spray-gun type	Nozzle size	Application pressure
▸ LVLP	Gravity	1.3-1.4 mm	1.7-2.2 bar at the spray gun air inlet
▸ HVLP	Gravity	1.3-1.4 mm	(HVLP: max 0.6-0.7 bar at the air cap)

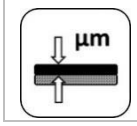
Application

Apply one medium coat, then allow to flash for 5-7 minutes.

Apply the 2nd and if required a 3rd wet coats allowing 5-10 minutes between coats.

Notes: *Flash-off time depends on ambient temperature, applied layer thickness and airflow.*

Film thickness



Using the recommended application technique 40 - 60 µm

Drying time

Dust dry	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	Infra-Red
▸ Standard	10 min.	10 min.	7 min.	n/a	n/a
Dry to handle and polish					
▸ Standard	8 hrs.	1 hr.	1 hr.	30 min.	4+8 min.

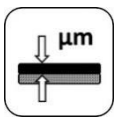
Notes:
Indicated drying times are panel temperatures. Oven temperature should be set 10 °C higher.
Allow 10 minutes flash off prior to Infra-Red drying.
The panel must not reach a temperature above 100°C (210°F) while curing.
Following the drying cycle at 60°C (140°F) object temperature, allow product to completely cool down to ambient temperature.
Using fast hardener at high temperatures can decrease the gloss.

Polishing

Dust and minor imperfections can be polished out after 8 hours air-dry times, or after a one hour cool down time following the full bake at 60°C object temperature. Carefully sand out dust particles and restore the surface according polishing recommendations.

Notes:

Coverage



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

▸ ±10 m²/liter RTS mixture at 40 - 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.*

Equipment cleaning

Solvent borne guncleaners

Solvent Content

- The VOC content of this product in ready to use form is maximum 590 g/liter

Shelflife

nax Premila Solid Toners		4 years	
nax Premila NB 200 2K Binder		4 years	
nax Premila 410 / 412RP 2K Hardeners		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.05.010. 140917

PROFESSIONAL USE ONLY

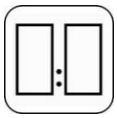
1K BASECOAT

Description

Single component acrylic master tint basecoat system designed to duplicate OEM finishes in solid, and effect colours. Provides easy application, fast drying, easy spot repair. nax Premila 8000 must be re-coated with nax Premium category clearcoats to secure complete system performance.

Suitable Substrates

Existing finishes with the exception of thermoplastic acrylic finishes.
All nax Premila and nax Pro LV primers/surfacers, with the exception of acid containing etch primer.

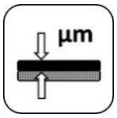


100 nax Premila 8000 Basecoat (Ready Colour Mix)
100 nax Premila Thinners

Spray-gun setup:
Gravity fed | 1.3-1.4 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



20-30 µm Solid colours
15-30 µm Effect colours

Between coats:
5 - 10 minutes at | 20°C | 70°F

Before re-coat:
10-15 minutes at | 20°C | 70°F

Re-coat within:
24 hours at | 20°C | 70°F

Re – coating
With all nax Pro LV and nax Premila clearcoats
With nax Crystal 9905 Mirror Image Clear 2K 2:1

nax Premila 8000 Master Tint Toners / B/C Binder 2-4 years
nax Premila Thinners 2 years

▸ The VOC content of this product in ready to use form is maximum 748 g/liter

Use suitable respiratory protection

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

For detailed information read entire TDS

nax Premila 8000 Basecoat

Description

Single component acrylic basecoat system designed to duplicate OEM finishes in solid, and effect colours. Provides easy application, fast drying, easy spot repair. nax Premila 8000 must be re-coated with nax Premila clearcoats to secure complete system performance.

Suitable Substrates

Existing finishes with the exception of thermoplastic acrylic finishes.
All nax Premila and nax Pro LV primers/surfacers, with the exception of acid containing etch primer.

Notes: *Follow recommended flash off and re-coating time of the wet-on-wet primer / basecoat.*

Product and Additives

Product	nax Premila Master Tint Toners / B/C Binder	Acrylic resins	
Thinners	nax Premila 10 Fast Thinner (aka 502)	Blend of solvents	5-20°C
	nax Premila 20 Medium Thinner (aka 500)	Blend of solvents	20-35°C
	nax Premila 30 Slow Thinner (aka 501)	Blend of solvents	35-45°C
	nax Premila 40 Extra Slow Thinner (aka 503)	Blend of solvents	35-50°C

Final surface preparation

▸ Finishing dry sanding step:	P500
▸ Initial dry sanding step may be executed with a coarser grit:	P320/P400
▸ For spot repair, finish the basecoat blending area with:	P500

▸ Finishing wet sanding steps:	P1000
▸ Initial dry sanding step may be executed with:	P320/P400
▸ Initial wet sanding step may be executed with:	P800
▸ For spot repair, finish the basecoat blending area with:	P1000

- ▸ Prior to SB topcoat application degrease the surface using nax solventborne 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.*
Use guide coat to control sanding.

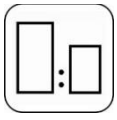
Mixing

Mixing Machine

Stir toners on mixing machine twice a day for 15 minutes and just before formula mixing.

Colour Mix

Must be stirred thoroughly directly after mixing the formula.

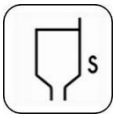


Standard	Low hide	
100	100	nax Premila 8000 colour mix (formula)
100	80	nax Premila Thinners

Thinner selection		
Fast	**Medium**	**Slow**
5-20°C	20-35°C	35-45°C

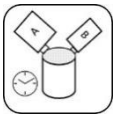
Notes: *To improve: elasticity, recoat properties, stone chip resistance, adhesion properties and total system robustness it is possible to add nax Premila 410 2K Hardener to basecoat. The Hardener is added in the ratio of 5% by volume of the base (colour) mix prior to adding nax Premila Thinners. After adding hardener mix thoroughly and mix with thinners as mentioned above.*

Viscosity (DIN 4 Cup)



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▸ Standard	14-16 sec	13-15 sec	13-15 sec

Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▸ Standard	1 day	1 day	1 day
▸ With 5% hardener	6 hours.	6 hours.	4 hours.

Spray gun set-up / application pressure

Spray-gun type	Spray-gun type	Nozzle size	Application pressure
▸ LVLP	Gravity	1.3-1.4 mm	1.7-2.2 bar at the spray gun air inlet
▸ HVLP	Gravity	1.3-1.4 mm	(HVLP: max 0.6-0.7 bar at the air cap)

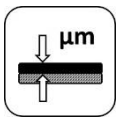
Application

2 coat colours	Number of coats	3 coat pearl colour	Number of coats
▸ Solid	2-3 single coats	▸ Foundation (Solid)	2
▸ Metallic	2 + drop-coat	▸ Foundation (Effect)	2-3
▸ Pearl	2-3 + drop-coat	▸ Mica	2-4

Solid colours	1. Apply 2-3 single coats till opacity achieved, with 5-10 minutes flash off time between coats
Metallic/ Pearl colours	1. Apply a wet coat followed by a medium coat, with 5-10 minutes flash off time between coats. 2. Apply a drop-coat for optimal metallic orientation coat by reducing the pressure to 1.5 bar (20-25psi) at the gun inlet and apply the drop coat with full trigger, increase the distance to 30 cm (12 inches).
Spot Repair	When making spot repairs, use lower application pressure and apply thin coats until reaching opacity. Allow for a 3-5 minutes flash-off time at 20°C between coats. Next, fade out, by extending beyond the edges, using similar application pressure. In case of metallic colours apply a drop coat (metallic orientation coat) when needed by increasing the spray gun distance.

Notes: *Flash-off time depends on ambient temperature, applied layer thickness and airflow.*

Film thickness



Colours		
▸ Solid	Using the recommended application technique	20-25 µm
▸ Effect	Using the recommended application technique	15-25 µm

❖ ***The total dry layer thickness should never exceed 30µm.***

Denibbing

Following a 20 minutes flash off at 20°C (70°F) the basecoat can be de-nibbed for minor defects (e.g. dust) with light pressure using P500 dry sanding or P1000 wet sanding. Prior to the subsequent basecoat application secure a sanding residue free surface.

Taping

Following a 20 minutes flash off at 20°C (70°F) the basecoat can be taped for multi-colour application. Temperature increase in combination with air acceleration helps the ability for masking, then allow the object to cool down to ambient temperature before masking.

Re-coating time

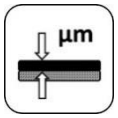
nax Premila 8000 Basecoat System can be re-coated with clearcoat after 10-15 minutes flash off time and within 24 hours.

Re-coating

- All nax Pro LV Clearcoats
- All nax Premila Clearcoats
- nax Crystal 9905 Mirror Image Clear 2K 2:1

Notes:

Coverage



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

- ± 09 m²/liter RTS mixture for Solid colours
- ±10 m²/liter RTS mixture for Effect colours (metallic/pearl)
- ±10 m²/liter RTS mixture for 3 coat pearl colours

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.*

Equipment cleaning

Solvent borne guncleaners

Solvent Content

- The VOC content of this product in ready to use form is maximum 750 g/liter

Shelflife

nax Premila 8000 Basecoat			
a) Pearl / Solid toners and B/C binder		4 years	
b) Metallic toners		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.06.010. 140917

PROFESSIONAL USE ONLY

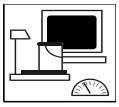
ACRYLIC TOPCOAT

nax Acrylic Binder System

Description

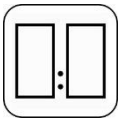
nax Acrylic Binder is a single-component paint system designed to duplicate OEM finishes in both solid and effect colours. Tintable with nax Premila Master Tint toners, it provides an easy application and fast drying repair. For extra finish or protection can be coated with nax range of acrylic clearcoats.

Colour Mixing



nax Premila Master Tint (MT) Toners
nax Acrylic Binder

* Refer to the nax Premila colour formulations and replace nax Premila binders with nax Acrylic Binder in the same ratio.



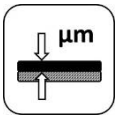
Solid	100	Effect	100	(Colour Mix)
Thinner*	100	Thinner*	130 - 150	

*Thinner nax Acrylic 7320 Thinner

Spray-gun Setup:
Gravity fed | 1.3-1.4 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

3 - 4 coats



30-40 µm Solid colours
20-30 µm Effect colours

Between coats:
3 - 5 minutes at | 25°C | 77°F |

Before re-coat:
10 - 15 minutes at 25°C 77°F

Re-coat within:
24 hours 25°C 77°F

Re-coating:
With nax Acrylic 320 #09 Topcoat Clear

nax Premila Master Tint Toners	2-4 years
nax Acrylic Binder	2 years
nax Acrylic Thinner	1 year

Use suitable respiratory protection

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

For detailed information read entire TDS.

25/10/2019

PROFESSIONAL USE ONLY

nax Acrylic Binder System

Description

nax Acrylic Binder is a single-component paint system designed to duplicate OEM finishes in both solid and effect colours. Tintable with nax Premila Master Tint toners, it provides an easy application and fast drying repair. For extra finish or protection can be coated with nax range of acrylic clearcoats.

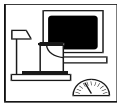
Suitable Substrates

Existing finishes with the exception of thermoplastic acrylic finishes
All nax Premila primers/surfacers, with the exception of acid containing etch primer.

Product and Additives

Product	nax Premila Master Tint Toners	Acrylic resins
	nax Acrylic Binder	Acrylic blend CAB
Reducers	nax Acrylic 7320 Thinner	Blend of solvents

Colour Mixing



nax Premila Master Tint (MT) Toners
nax Acrylic Binder

* Refer to the nax Premila colour formulations and replace nax Premila binders with nax Acrylic Binder in the same ratio.
* nax Premila binders refer to NB100 and NB200.

Surface Preparation

- Prior to primer surfacer sanding, degrease the sanding area using nax Silicone Off degreaser.
- Use clean quality rags or wiping towels, one for wetting and one for drying.
- Apply sufficient degreaser to keep the surface wet.
- Wipe degreaser off before it can evaporate.

Finishing dry sanding steps:	P400/P500
Initial dry sanding step may be executed with a coarser grit:	P320/P400

Finishing wet sanding steps:	P800/P1000
Initial dry sanding step may be executed with a coarser grit:	P320/P400
Initial wet sanding step may be executed with a coarser grit:	P600/P800

- Prior to topcoat application degrease the surface using nax Silicone Off degreaser.
- Use clean quality rags or wiping towels, one for wetting and one for drying.
- Apply sufficient degreaser to keep the surface wet
- 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.*

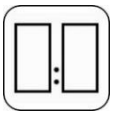
Mixing

Mixing Machine

Stir toners on mixing machine twice a day for 15 minutes and just before formula mixing.

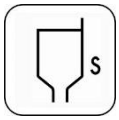
Colour Mix

Must be stirred thoroughly directly after mixing the formula.



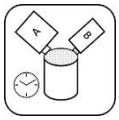
Solid	Effect	
100	100	nax Acrylic Colour Mix
100	130-150	nax Acrylic 7320 Thinner

Viscosity (DIN 4 Cup)



Application	25°C(77°F)
▸ Standard	15-17 sec

Pot Life



Application	25°C(77°F)
▸ Standard	Not applicable

Spray Gun Set-up / Application Pressure

Spray-gun type	Spray-gun type	Nozzle size	Application pressure
▸ LVLP/HVLP	Gravity	1.3-1.4 mm	1.7-2.2 bar at the spray gun air inlet
▸ Conventional	Gravity	1.3-1.5 mm	2.5-3.5 bar at the spray gun air inlet

Application

Colours	Number of coats
▸ Solid	3-4 single coats
▸ Metallic	4-5 + drop-coat
▸ Pearl	4-5 + drop-coat

Solid Colours

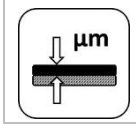
1. Apply 3-4 single coats till opacity is achieved, with 3-5 minutes flash off between coats.

Metallic/ Pearl Colours

1. Apply 3-4 wet coats followed by a medium coat, with 3-5 minutes flash off between coats.
2. Apply a drop-coat for optimal metallic orientation coat by reducing the pressure to 1.5 bar (20-25psi) at the gun inlet and apply the drop coat with full trigger, increase the distance to 30 cm (12 inches).

Notes: *Flash-off time depends on ambient temperature, applied layer thickness and airflow.*

Film Thickness



Colours		
▸ Solid	Using the recommended application technique	30-40 µm
▸ Effect	Using the recommended application technique	20-30 µm

Denibbing

Following a 10-15 minutes flash off at 25°C (77°F) the basecoat can be denibbed for minor defects (e.g. dust) with light pressure using P500 dry sanding or P1000 wet sanding. Prior to the subsequent basecoat application secure a sanding residue free surface.

Taping

Following a 30-45 minutes flash off at 25°C (77°F) the basecoat can be taped for multi-Colour application. Temperature increase in combination with air acceleration helps the ability for masking, then allow the object to cool down to ambient temperature before masking.

Re-coating Time

Can be re-coated with nax acrylic clearcoat after 10-15 minutes flash off time and within 24 hours.

Re-coating

- nax Acrylic 320 #09 Topcoat Clear

Equipment Cleaning

Solvent borne gun cleaners.

Shelf-life

nax Premila MT Pearl/Solid toners		4 years	
nax Premila MT Metallic toners		2 years	
nax Acrylic binder		2 years	
nax Acrylic 7320 Thinner		1 year	
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.*

PROFESSIONAL USE ONLY

PRIMERS

Description

nax PP Primer is the special primer for improved adhesion of the paint on polypropylene (PP) materials such as polypropylene bumper, spoiler etc.

Suitable Substrates

Polypropylene and its blends

Ready to spray
nax PP Primer

Spray-gun setup:
Gravity fed | 1.4-1.5 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

1 - 2 coats

05 - 10 µm / coat

Between coats:
5 - 10 minutes at | 20°C | 70°F

Dry to recoat	20°C (70°F)	30°C (86°F)	40°C (100°F)
	15 min	10 min	5 min

Re – coating
With all nax Premila primer filler and surfacers
With nax Premila 8000 Basecoat and nax Premila 7000 2K Solid Topcoat system

nax PP Primer 2 years

The VOC content of this product in ready to use form is maximum 826 g/liter

Use suitable respiratory protection

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

For detailed information read entire TDS

nax PP Primer

Description

nax PP Primer is the special primer for improved adhesion of the paint on polypropylene (PP) materials such as polypropylene bumper, spoiler etc.

Suitable Substrates

Polypropylene and its blends

Surface preparation

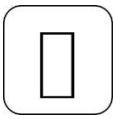
- Prior to any surface preparation, degrease the repair area using nax solventborne degreaser.
- Use clean quality rags or wiping towels, one for wetting and one for drying the surface.
- Apply sufficient degreaser to keep the surface wet and wipe degreaser off before it can evaporate.

- Non-primed new plastic (raw) → Use grey scuff pad with matting paste and warm water
- In case of plastic repair finish surface before priming, with: P320

- Prior to surfacer application on other surfaces, degrease with nax solventborne 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.*

Product preparation

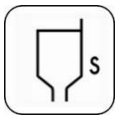


Ready to spray

Lightly agitate can before use.

Unused product can be returned into can

Viscosity (DIN 4 Cup)



20°C(70°F)	30°C(86°F)	40°C (100°F)
10-12 sec	10-12 sec	8-9 sec

Spray gun set-up / application pressure

Spray-gun type	Nozzle size		Application pressure
Gravity	1.2-1.4	mm	Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)
		mm	1.7-2.2 bar at the spray gun air inlet

Application

Number of coats: 1-2

- First coat light to medium.
- Second coat full wet coat.

Re-coating time

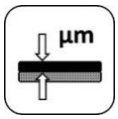
	20°C(70°F)	30°C(86°F)	40°C(100°F)
Dry to recoat	15 minutes	10 minutes	5 minutes

Re-coating

With all nax Premila primer fillers and surfacer
With nax Premila 8000 Basecoat and nax Premila 7000 2K Solid Topcoat system

Notes: *To replicate OEM system and to achieve the highest quality always apply a w-o-w surfacer prior to topcoat.*

Film thickness



1-2 Coats	5-10 µm/coat

Equipment cleaning

Solvent borne guncleaners

Solvent Content

The VOC content of this product in ready to use form is maximum 826 g/liter

Shelflife

nax PP Primer 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.03.011. 140917

PROFESSIONAL USE ONLY

PRIMER SURFACERS

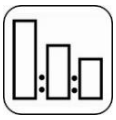
nax 2800HP 2K Velocity Primer

Description

High productive super-fast drying, 2K HS sanding primer filler with excellent application and sanding properties. Due to its super-fast ambient drying, the total preparation time can be reduced to one hour. Provides exceptional enamel hold-out with all Nippon Paint topcoats. Can be sanded after 30 min. drying at 20°C.

Suitable Substrates

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



2 nax 2800HP 2K Velocity Primer
2 nax 580 2K Velocity Reducer
1 nax 280HP 2K Velocity Primer Hardener

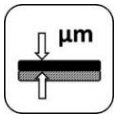
Spray-gun setup:

Gravity fed	1.4 - 1.8	mm	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



20 - 40 µm /coat

Between coats:

1 - 2	minutes at	20°C	70°F								

	20°C (70°F)	30°C (86°F)	40°C (100°F)	50°C (122°F)
Dust dry	6 min.	5 min.	3 min.	n/a
Dry to sand	30 min.	15 min	7 min.	5 min.

Final dry sanding:

P400- P500

Final wet sanding:

P800-P1000

Re – coatable with:

With itself and all nax Premila primers, primer fillers and surfacers

With nax E-Cube WB Basecoat, nax Premila 8000 Basecoat and nax Premila 7000 2K Solid Topcoat

nax 2800HP 2K Velocity Primer	2 years
nax 580 2K Velocity Reducer	1 year
nax 280HP 2K Velocity Primer Hardener	2 years

▸ The VOC content of this product in ready to use form is maximum 640 g/liter

Use suitable respiratory protection

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

For detailed information read entire TDS

nax 2800HP 2K Velocity Primer

Description

High productive super-fast drying, 2K HS sanding primer filler with excellent application and sanding properties. Due to its super-fast ambient drying, the total preparation time can be reduced to one hour. Provides exceptional enamel hold-out with all Nippon Paint topcoats. Can be sanded after 30 min. drying at 20°C.

Suitable Substrates

Existing finishes	Glass reinforced laminates	nax epoxy primers
Steel	nax plastic primers	nax etching primers
OEM Electro-coat (ED)	nax polyester bodyfillers & putties	

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 surface application, such as complete panel

Product and Additives

Product nax 2800HP 2K Velocity Primer
Hardeners nax 280HP 2K Velocity Primer Hardener
Reducers nax 580 2K Velocity Reducer

Surface preparation

- Prior to any surface preparation, degrease the repair area using nax solventborne 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 solventborne 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. For detailed surface preparation see TDS*

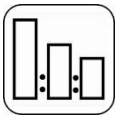
Mixing

Mixing Machine

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

Product Mix

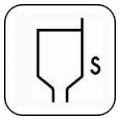
Stir well, after each added component.



Volume	Weight	
2		nax 2800HP 2K Velocity Primer
2		nax 580 2K Velocity Reducer
1		nax 280HP 2K Velocity Primer Hardener

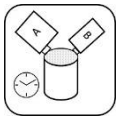
Notes: *Stir after each added component*
Reducer must be added and stirred well before adding the hardener

Viscosity (DIN 4 Cup)



20°C(70°F)	30°C(86°F)	40°C(100°F)
13-16 sec	13-16 sec	13-16 sec

Pot Life



20°C(70°F)	30°C(86°F)	40°C(100°F)
20 min.	15 min.	10 min.

Notes: ***<u>For efficient use, the primer should be mixed and applied within 3-5 minutes after mixing to minimize any impact on application due to rise in viscosity.</u>***

Spray gun set-up / application pressure

Spray-gun type	Nozzle size	Application pressure
Gravity	1.4-1.8 mm	1.7-2.2 bar at the spray gun air inlet (HVLP: max 0.6-0.7 bar at the air cap)

Application

	Number of coats
Depending on desired film build	2-3 coats

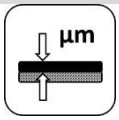
- Apply one medium coat over the sanded repair area, then allow to flash for 1-2 minutes.
- Apply the 2nd and 3rd wet coat within each previous coats allowing 1-2 min. between coats.

Notes: *Allow each coat to flash-off naturally, 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.
*****Clean spray-gun immediately after the application*****

Drying time

	20°C(70°F)	30°C(86°F)	40°C(100°F)	50°C(122°F)
▸ Dust dry	6 min.	5 min.	3 min.	n/a
▸ Dry to sand	30 min.	15 min	7 min.	5 min.

Film thickness



Using the recommended application technique	20-40 µm/coat

Final 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

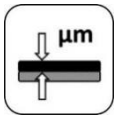
- Prior to SB topcoat application degrease the surface using nax solventborne degreaser.
- Prior to WB basecoat application degrease the surface using nax E-Cube WB Degreaser.
- Use clean quality rags or wiping towels, one for wetting and one for drying.
- Apply sufficient degreaser to keep the surface 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 E-Cube WB Basecoat, nax Premila 8000 Basecoat and nax Premila 7000 2K Solid Topcoat

Coverage



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

- ± 09 m²/liter RTS mixture at 40-50 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.*

Equipment cleaning

Solvent borne guncleaners. **Clean spray-gun immediately after application.**

Solvent Content

- The VOC content of this product in ready to use form is max 640 g/liter

Shelflife

nax 2800HP 2K Velocity Primer		2 years	
nax 580 2K Velocity Reducer		1 year	
nax 280HP 2K Velocity Primer Hardener		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.04.012. 140917
PROFESSIONAL USE ONLY

nax 2600 2K Premium Primer

Description

Premium quality, high-build, multi grey shade, fast drying, two-component sanding primer filler with excellent application and sanding properties. Due to its fast ambient drying, it helps to reduce process time. Provides exceptional enamel hold-out with all Nippon Paint nax basecoats and topcoats. Due to its versatility, it can be used for spot, block and overall repair.

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

Product	nax 2600 2K Premium Primer	Acrylic resin	**Temperature Range**
Hardeners	nax 260 2K Premium Primer Hardener	Poly-isocyanate resin	20-35°C
	nax 260 2K Slow Hardener	Poly-isocyanate resin	Above 35°C
Thinners	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
Additives	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
- 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.*

Grey Shades (volume / weight gr)

Shades	Impression	Name	White (S1)	Grey (S4)	Black (S7)
S1		White	100 / 153	-	-
S2		Extra Light Grey	90 / 138	-	10 / 14
S3		Light Grey	70 / 107	-	30 / 42
S4		Medium Grey	50 / 77	*	50 / 71
S5		Dark Grey	30 / 46	-	70 / 99
S6		Extra Dark Grey	10 / 15	-	90 / 127
S7		Black	-	-	100 / 141

Notes: *Stir well after adding the tones together.*
**nax 2600 2K Premium Primer Grey (S4) is similar to shade mixed S4 and therefore can be used as a standalone quick grey solution.*
Shades can be pre-mixed into a 1 litre steer lid can and placed on the mixing machine (see table at the end of the TDS).

Tinting

nax 2600 2K Premium Primer 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.

nax 2600 2K Premium Primer

Flexible Parts

Type of Plastic	Flexible	Soft	
nax 2600 2K Premium Primer	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.

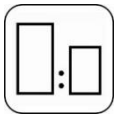
Mixing

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 2600 2K Premium Primers
1	1	nax 260 2K Hardeners
1	2	nax Premila 10/20/30/40 Thinners

Hardener/Thinner Selection			
	5-20°C	**20-35°C**	**≥ 35°C**
1-2 panels/spot	Std/10	Std/20	Slow/30
3-5 panels	Std/20	Std/20	Slow/30
>5 panels	Std/30	Slow/20	Slow/30

Notes: *Stir after each added component.*

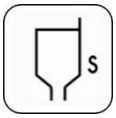
Mixing (by weight) High Build

RFU (ml)	nax 2600 2K Premium Primer (gr)							nax 260 2K Hardeners (gr)	nax Premila Thinners (gr)
	S1	**S2**	**S3**	**S4**	**S5**	**S6**	**S7**		
100	103	102	100	98	97	95	94	16	15
150	154	153	150	148	145	142	141	24	22
200	205	204	200	197	193	190	188	32	29
250	257	255	250	246	242	237	235	40	37
300	308	305	300	295	290	285	282	48	44
400	411	407	400	393	386	379	376	64	59
500	513	509	500	492	483	474	470	80	73
700	719	713	700	688	676	664	658	112	103

Mixing (by weight) Medium Build

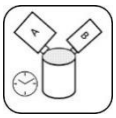
RFU (ml)	nax 2600 2K Premium Primer (gr)							nax 260 2K Hardeners (gr)	nax Premila Thinners (gr)
	S1	**S2**	**S3**	**S4**	**S5**	**S6**	**S7**		
100	88	87	86	84	83	81	81	14	25
150	132	131	129	126	124	122	121	21	38
200	176	175	172	169	166	163	161	27	50
250	220	218	214	211	207	203	201	34	63
300	264	262	257	253	248	244	242	41	75
400	352	349	343	337	331	325	322	55	101
500	440	436	429	421	414	406	403	69	126
700	616	611	600	590	580	569	564	96	176

Viscosity (DIN 4 Cup)



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▸ High Build	17-23 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	40 min.	30 min.	20 min.
▸ Medium build	1½ hrs.	60 min.	30 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	Depending on desired film build	2-3 coats

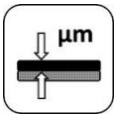
- ▸ Apply one medium coat over the sanded repair area, then allow to flash for 5-7 minutes.
- ▸ Apply the 2nd and 3rd wet coat within each previous coats allowing 5-7 min. between coats.

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 (Standard)	2 hrs.	1½ hrs.	1½ hrs.	30 min.	4+8 min.
▸ Dry to sand (Slow)	3 hrs.	2½ hrs.	2 hrs.	30 min.	4+8 min.

Film Thickness



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

nax 2600 2K Premium Primer

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.
- ▸ Prior to WB basecoat application degrease the surface using nax E-Cube WB Silicon Off.
- ▸ 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.

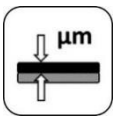
Notes: *Respect 100 grit maximum jump in dry sanding steps and 200 grit maximum jump in wet sanding steps.*

Re-coating

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

Notes:

Coverage



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

8-12	m²/litre RTS mixture at	30-60µm
86-129	ft²/litre RTS mixture at	30-60µm

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.*

Equipment Cleaning

Solvent borne gun cleaners.

Solvent Content

- ▸ The VOC content of this product in ready to use form is max 636 g/liter

Shelf-life

nax 2600 2K Premium Primers		2 years	
nax 260 2K Hardeners		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.*

Grey Shades pre-mix table by weight for 900ml in volume

Shades	Impression	Name	White (S1)	Black (S7)
S2		Extra Light Grey	1239	127
S3		Light Grey	964	381
S4		Medium Grey	689	635
S5		Dark Grey	413	888
S6		Extra Dark Grey	138	1142

LAR.04.011. 140917

PROFESSIONAL USE ONLY

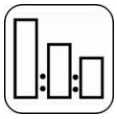
nax 2400 Urethane Primer Grey

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	

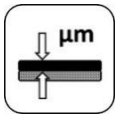


4 nax 2400 Urethane Primer Grey
1 nax 240 Urethane Primer Hardener
1-2 nax Premila Thinners

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 µm /coat (4:1:1)
30-40 µm /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
2 hours	1½ hours	1½ hours	30 minutes	4+8 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.

nax 2400 Urethane Primer Grey

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

Product	nax 2400 Urethane Primer Grey	Acrylic resins	**Temperature Range**
Hardeners	nax 240 Urethane Primer Hardener	Poly-isocyanate resin	
Thinners	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
Additives	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.

nax 2400 Urethane Primer Grey

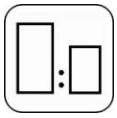
Mixing

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

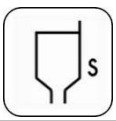
Thinner Selection			
	Fast	**Medium**	**Slow**
	5-20°C	20-35°C	35-45°C
1-2 panels/spot	Fast	Medium	Slow
3-5 panels	Medium	medium	Slow
>5 panels	Slow	Slow	Slow

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

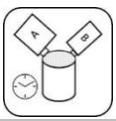
Mixing (by weight)	**Medium Build (4 : 1 : 2)**		
RFU (ml)	nax 2400 Urethane Primer Grey (gr)	Nax 240 Urethane Primer Hardener (gr)	nax Premila Thinners (gr)
100	86	13	25
150	129	20	38
200	171	27	50
250	214	34	63
300	257	40	75
400	343	54	101
500	429	67	126
700	600	94	176
1000	857	134	251

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.

nax 2400 Urethane Primer Grey

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

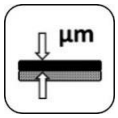
- ▸ Apply one medium coat over the sanded repair area, then allow to flash for 5-7 minutes
- ▸ Apply the 2nd and 3rd wet coat within each previous coats allowing 5-7 min. between coats.

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

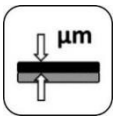
	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	IR DRYING
▸ Dust dry	10 min.	5 min.	5 min.	-	n/a
▸ Dry to sand	2 hrs.	1½ hrs.	1½ hrs.	30 min.	n/a
▸ Flexible use	3 hrs.	2 hrs.	2 hrs.	40 min.	4+8 min.

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 m²/litre RTS mixture at 30-60 µm

75-108 ft²/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

PROFESSIONAL USE ONLY

nax Acrylic No.11 (131) Primer Surfacer Grey

Description

Single component acrylic primer surfacer designed to feel minor scratches, and surface imperfections in the auto refinishing industry. Dries fast. Provides easy sanding and optimal enamel holdout under any Nippon Paint nax topcoat. Can also be used in industrial steel work.

Suitable Substrates

Existing finishes	Glass reinforced laminates	nax PP Primer
Steel	nax polyester bodyfillers & putties	nax 1200 Etch Primer
OEM Electro-coat		nax epoxy primers

1 nax Acrylic No.11 (131) Primer Surfacer Grey
1 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

20-30 µm /coat

Between coats:
5 - 10 minutes at | 20°C | 70°F

Dry to sand	20°C (70°F)	30°C (70°F)	40°C (70°F)	50°C (122°F)	Infra-Red
	45 min.	30 min.	15 min.	10 min.	4+8 min.

Final dry sanding:
P400- P500

Final wet sanding:
P800-P1000

Re – coating
With itself and all nax Premila primers, fillers and surfacers
With nax Premila 8000 Basecoat and nax Premila 7000 2K Solid Topcoat system

nax Acrylic No.11 (131) Primer Surfacer Grey	2 years
nax Premila Thinners	2 years

VOC

- The VOC content of this product in ready to use form is maximum 736 g/liter

Use suitable respiratory protection

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

For detailed information read entire TDS

nax Acrylic No.11 (131) Primer Surfacer Grey

Description

Single component acrylic primer surfacer designed to feel minor scratches, and surface imperfections in the auto refinishing industry. Dries fast. Provides easy sanding and optimal enamel holdout under any nax topcoat. Can also be used in industrial steel work.

Suitable Substrates

Existing finishes	OEM Electro-coat (ED)	nax PP Primer
Steel	Glass reinforced laminates	nax polyester bodyfillers & putties
		nax Epoxy Primer
		nax 1200 Etch Primer

Notes: *In the following cases the use etch primer is advised:*

a. When the system is required to meet the highest quality standard

b. Repairs that requires an extensive primer surface application, such as complete panel

Product and Additives

Product	Nax Acrylic No.11 Acrylic Primer Surfacer Grey	Acrylic resin	**Temperature range**
Thinners	nax Premila 10 Fast Thinner (aka 502)	Blend of solvents	5-20°C
	nax Premila 20 Medium Thinner (aka 500)	Blend of solvents	20-35°C
	nax Premila 30 Slow Thinner (aka 501)	Blend of solvents	35-45°C
	nax Premila 40 Extra Slow Thinner (aka 503)	Blend of solvents	35-50°C

Surface preparation

- Prior to any surface preparation, degrease the repair area using nax solventborne 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
▸ OEM electro (ED) coated parts:	P320

- Prior to primer surfacer application degrease the application area using nax solventborne 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. For detailed surface preparation see TDS*

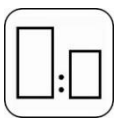
Mixing

Mixing Machine

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

Product Mix

Stir well, after each added component.

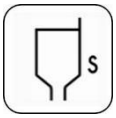


HB	MB	
1	1	nax Acrylic No.11 Acrylic Primer Surfacer Grey
0.8	1	nax Premila Thinners

	Thinner Selection		
	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

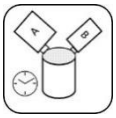
Notes: *Stir after each added component*

Viscosity (DIN 4 Cup)



20°C(70°F)
20-23 sec
23-26 sec

Pot Life



After mixed it can be used for one week.

Spray gun set-up / application pressure

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

Application

Depending on desired film build	Number of coats
	2-3 coats

- Apply one medium coat over the sanded repair area, then allow to flash for 5-10 minutes.
- Apply the 2nd and 3rd wet coat within each previous coats allowing 5-10 min. between coats.

Notes:

Allow each coat to flash-off naturally, 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)	50°C(122°F)	IR DRYING
▸ Dust dry	10 min.	5 min.	3 min.	3 min.	
▸ Dry to sand	45 min.	30 min.	15 min.	10 min.	4+8 min.

Final Surface preparation

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

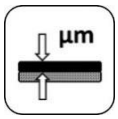
- Finishing wet sanding steps: P800/P1000
- Initial dry sanding step may be executed with a coarser grit: P320
- Initial wet sanding step may be executed with a coarser grit: P600/P800
- For spot repair, finish the blending area with: P1000

- Prior to topcoat application degrease the surface using nax solventborne 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.

Film thickness

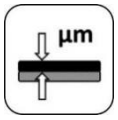


Using the recommended application technique	20-30 µm/coat

Re-coating

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

Coverage



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

- ± 07 m²/liter RTS mixture at 30µm

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.*

Equipment cleaning

Solvent borne guncleaners

Solvent Content

- The VOC content of this product in ready to use form is max 736 g/liter (lb/gallon)

Shelflife

nax Acrylic No.11 Acrylic Primer Surfacer Grey	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.04.013. 150917

PROFESSIONAL USE ONLY

ANCILLARIES

nax Softener

Description

nax Softener is a special liquid for mixing up with high grade urethane paint to give the flexibility to the paint, clear or primers for application on flexible materials such as bumper, spoiler etc.

Compatible with:

nax Premila primer surfacers, clearcoats and 2K topcoats

Additive Ratio:

Plastic type	A component	Softener
Flexible/Soft	100	5%
Soft	100	10%

Notes: ***For detailed information on nax Softener mixing ratio check primer surfacer and clearcoat TDS.***
Hard plastic requires no softener. Stir well after adding the additive
Softener must be added prior to hardener.

nax Softener		1 Year	
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.*

Use suitable respiratory protection

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

	Coding	Material	Flexibility
1	UP-GFK	Glass fibre reinforced polyester	HARD
2	PUR-hard	Polyurethane	
3	PE	Polyethylene	
4	PP and PP/EPM	Polypropylene	
5	ABS	Acrylonitryl Butadiene Styrene	
6	EPDM	Ethylene Propylene Diene	
7	ASA	Acrylonitryl Styrene Acryl	FLEXIBILE
8	A/EPDM/S	Acrylonitryl Ethylene Styrene	
9	PUR-soft	Polyurethane	SOFT

LAR.08.012. 140917

PROFESSIONAL USE ONLY

OTHER

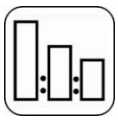
nax Matt Clear

Description

nax Matt Clear is a premium modified acrylic urethane two component clearcoat which provides a uniform soft matt finish with excellent scratch resistance and self-healing properties. It is designed to have an outstanding durability and chemical resistance. Clear shows excellent transparency thereby preserving the metallic affect.

Suitable Substrates

nax Premila 8000 series basecoat
nax E-Cube WB basecoat system

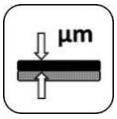


2	nax Matt Clear
1	nax Premila 210 2K Hardener
0-10%	nax Premila Thinners

Spray-gun Setup:
Gravity fed | 1.3-1.4 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 coats



40-60 µm

Between coats:
5 - 10 minutes at | 20°C | 70°F

Before 60°C (140°F) baking:
5 - 10 minutes at | 20°C | 70°F

	20°C (70°F)	30°C (70°F)	40°C (70°F)	60°C (140°F)	Infra-Red
Dust dry	55 min.	40 min.	35 min.	-	
Dry to handle	8 hrs.	8 hrs.	6 hrs.	30-40 min.	4+8 min.

nax Matt Clear	2 years
nax Premila 210 2K Hardeners	2 years
nax Premila Thinners	2 years

▸ The VOC content of this product in ready to use form is maximum 590 g/liter

Use suitable respiratory protection

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

For detailed information read entire TDS

nax Matt Clear

Description

nax Matt Clear is a premium modified acrylic urethane two component clearcoat which provides a uniform soft matt finish with excellent scratch resistance and self-healing properties. It is designed to have an outstanding durability and chemical resistance. Clear shows excellent transparency thereby preserving the metallic affect.

Suitable Substrates

nax Premila 8000 series basecoat
nax E-Cube WB basecoat system

Notes: *Follow recommended flash off and re-coating time of the basecoat.*

Compatible Clearcoats

nax Premila 9600 Extra Solid Clear 2K 2:1

Notes: *Follow recommended flash off and re-coating time of the basecoat.*

Product and Additives

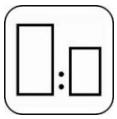
Product	nax Matt Clear	Modified Acrylic Polyol	
Hardener	nax Premila 210 2K Hardener	Poly-isocyanate resin	
Reducers	nax Premila 10 Fast Thinner	Blend of solvents	5-20°C
	nax Premila 20 Medium Thinner	Blend of solvents	20-35°C
	nax Premila 30 Slow Thinner	Blend of solvents	35-45°C
	nax Premila 40 Extra Slow Thinner	Blend of solvents	35-50°C

Matting Levels

Satin	Semi-gloss	
100	100	nax Matt Clear
10	20	nax Premila 9600 Extra Solid Clear 2K 2:1

Notes: *Stir well after adding the components.*

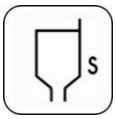
Mixing



Standard		Thinner Selection			
			5-20°C	**20-35°C**	**35-45°C**
2	nax Matt Clear or mixes	1-2 panels	Fast	Medium	Slow
1	nax Premila 210 2K Hardener	3-5 panels	Medium	Medium	Slow
0-10%	nax Premila Thinners	>5 panels	Slow	Slow	Slow

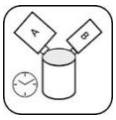
Notes: *Stir after each added component.*
nax Matt Clear is very flexible clear and hence does not require softener.

Viscosity (DIN 4 Cup)



	20°C(70°F)	**30°C(86°F)**
▸ Standard	17-18 sec	14-17 sec

Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▸ Standard	2 hrs.	1½ hrs.	1 hr.

Spray Gun Set-up / Application Pressure

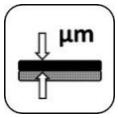
Spray-gun type	Spray-gun type	Nozzle size	Application pressure
▸ LVLP	Gravity	1.3-1.4 mm	1.7-2.2 bar at the spray gun air inlet
▸ HVLP	Gravity	1.3-1.4 mm	(HVLP: max 0.6-0.7 bar at the air cap)

Application

Standard Application
- ▸ Apply one medium coat, then allow to flash for 5-10 minutes.
- ▸ Apply the 2nd wet coat.

Notes: *Flash-off time depends on ambient temperature, applied layer thickness and airflow. Application should be done in dust free condition.*

Film Thickness



▸ All	Using the recommended application technique	40-60 µm

Drying Time

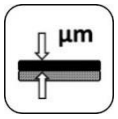
Dust dry	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	Infra-Red
▸ Standard	55 min.	45 min.	35 min.	-	n/a
Dry to handle					
▸ Standard	7 hrs.	5 hrs.	4 hrs.	30 min.	4+8 min.

Notes:
Indicated drying times are panel temperatures. Oven temperature should be set 10 °C higher.
Allow 10 minutes flash off prior to Infra-Red drying.
The panel must not reach a temperature above 100°C (210°F) while curing.
Following the drying cycle at 60°C (140°F) object temperature, allow product to completely cool down to ambient temperature.

Polishing

Polishing is not recommended for this product. Polishing will make the product glossy.

Coverage



By using the recommended application, the theoretical material coverage is:
- ▸ 8 m²/liter RTS mixture at 50 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.*

Equipment Cleaning

Solvent-borne gun cleaners.

Solvent Content

- The VOC content of this product in ready to use form is maximum 590 g/liter

Shelf-life

nax Matt Clear		2 years	
nax Premila 210 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.07.016. 180918

PROFESSIONAL USE ONLY

Mazda 46 Machine Grey

nax Premila 8000 Basecoat System

Description

nax Premila 8000 Basecoat to repair Mazda 46G Machine Gray, is a three-stage system. Consisting of three separately applied layers replicating the OEM special plating effect colour.

1. Foundation coat – Covering coat for opacity.
2. Effect coat – Transparent coat for the plating effect.
3. Clearcoat

Product and Additives

Product	nax Premila 8000 Basecoat System	Basecoat System (Ready Colour Mix)
	nax Multi 009 Cosmo Silver	Special effect toner
Hardener	nax Premila 410 2K Hardener	Hardener for the basecoat
Thinners	nax Premila 20 Medium Thinner (aka 500)	Thinner (20-35°C)
	nax Premila 30 Slow Thinner (aka 501)	Thinner (35-45°C)
	nax Premila 40 Extra Slow Thinner (aka 503)	Thinner (40-50°C)

Plating

Plating is a spray application technique where an over diluted (effect pigment containing) colour is applied in numerous very thin layers over a previously applied and usually darker foundation colour. This application technique creates a mirror like reflection finish varying from a light to darker polished surface like effect.

Colour check

To identify the correct shade to match the colour on the vehicle a number of colour spray-out samples needs to be sprayed.
The colour change depends on the number of coats applied of the effect coat.
The operator can determine the right colour match by using these colour samples.

Spray out samples creation

Spray out sample process:

1. Place 4 spray-out panel side by side (first number the panels on the back from 1 to 4)
2. Apply the foundation colour without mist-coat, until opacity is achieved on the 4 spray-out panels, flash off between coats.
3. Next apply one single coat of the effect colour to all 4 panels, then flash off till touch dry.
4. Remove one panel and apply the second coat and the remaining (3) panel, then flash off till touch dry.
5. Continue this application method till the last panel resulting in spray-outs panels ranging with 1-4 coats of the effect coat.
6. Allow a 15 minutes flash-off time at 20°C prior to clearcoat application.
7. Apply clearcoat according to TDS recommendation.

Notes:

- *For optimum flash-off, dry the panels for several minutes in oven or during a drying cycle in the spray booth*
- *Personal application differences make it recommendable that each painter creates own spray-outs.*
- *To obtain an accurate colour match, spray the panels same as the vehicle, i.e. place all spray-outs on one larger panel and spray complete panel for each coat.*
- *Avoid spraying panels individually.*

Spray out samples

Foundation coat | 1 Effect coat | 2 Effect coat | 3 Effect coat | 4 Effect coat

Mazda 46 Machine Grey

nax Premila 8000 Basecoat System

Final surface preparation

▸ Finishing dry sanding step:	P500
▸ Initial dry sanding step may be executed with a coarser grit:	P320/P400
▸ For spot repair, finish the blending area with:	P600

▸ Finishing wet sanding steps:	P1000
▸ Initial dry sanding step may be executed with:	P320/P400
▸ Initial wet sanding step may be executed with:	P800
▸ For spot repair, finish the blending area with:	P1200

- ▸ Prior to SB topcoat application degrease the surface using nax solventborne 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.*
Use guide coat to control sanding.

Mixing (by weight)

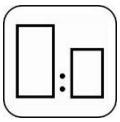
▸ **Toner Use**

Stir toners on mixing machine twice a day for 15 minutes and just before formula mixing.

▸ **Colour Mix**

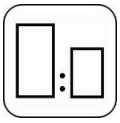
Must be stirred thoroughly directly after mixing the formula.

Foundation Coat



Mix 1	Mix 2	
100	100	nax Premila 8000 (mixed formula) incl. 10% hardener*
80	100	nax Premila Thinners

Effect Coat

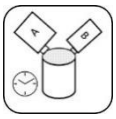


100		nax Premila 8000 (mixed formula) incl. 10% hardener*
400		nax Premila Thinners

Notes: Important

1. **Add nax Premila 410 2K Hardener to both mixes in a ratio of 10% by volume of the base (colour) mix prior to adding nax Premila 500 thinners. After adding hardener mix thoroughly and mix with thinners as mentioned above.*
2. *Use slower thinners for easier application*
3. *Only mix colours prior to application*
4. *Mix 2 is used for blending*

Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▸ Standard	1 day	1 day	1 day
▸ With 10% hardener	6 hours.	4 hours.	3 hours.

Spray gun set-up / application pressure

	Product Flow	Nozzle size	Application pressure
Foundation coat	3 – 3.5 turn	1.3-1.4 mm	1.7-1.8 bar at the spray gun air inlet
Effect coat	1.5 – 2 turn	1.3-1.4 mm	1.7-1.8 bar at the spray gun air inlet

Panel application (edge to edge)

Foundation Coat

1. Apply 1 to 2 wet coat followed by a medium coat, as per nax Premila 8000 Basecoat System TDS
    a. Allow 5-10 minutes flash off time between coats
2. Flash off foundation coat for 15 minutes prior to Effect Coat

Effect Coat

1. Apply thin closed coats with large, ±30 cm gun distance to surface
    a. Apply according to colour check with sprayout samples
2. Flash off till touch dry between coats
3. Repeat till the right colour achieved (check with sprayout cards)
4. Flash finish colour for at least 15 minutes prior to clearcoat application

Notes: *The Effect Coat application should show a matt appearance at the time of the application, gloss indicates heavy application which negatively effects colour result.*

Blend

Blend is a process consisting of light layer application of the new colour into the existing finish to create an invisible repair paint finish.

Planning the blending area

Foundation coat:

Calculating the maximum size for the foundation coat blending:

1. Deduct ±15 cm from the farthest edge of the blending panel.
2. Divide the distance from this line till the edge of the primer surfacer by 3, then take 2/3rd of this distance.
3. This mark should be the farthest edge of the foundation colour blending.

Effect coat:

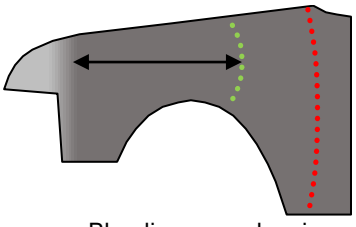
1. The blending area of the effect colour is only slightly overpassing the edge of the foundation fadeout.
2. Use the available area and do not keep the colour blend unnecessary small.

Notes:

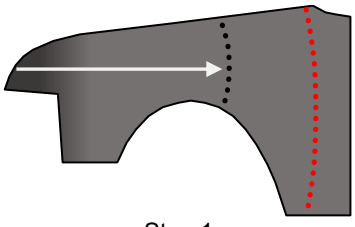
Foundation coat application

1. Apply one light coat of Mix 2. within the fade out area
2. Apply coats of Mix 1, covering the primer surfacer area with blending within the fade out area
3. Flash off between coats for 5-10 minutes
4. Apply one orientation coat over the fadeout area with a lower pressure and enlarged gun distance to surface
5. Flash off for 5-10 minutes prior to Effect Coat application

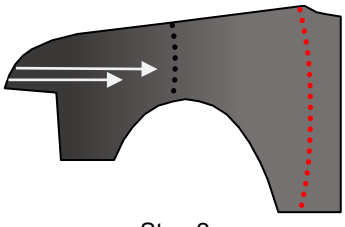
Notes: *Blend the foundation coat in such a way that a smooth transition is created from foundation colour to the existing colour on the vehicle before proceeding with the application of the effect colour.*
Applying the foundation coat from out-side-in, helps to easily achieve the right shade to match the existing colour on the vehicle.



Blending area planning



Step 1



Step 2

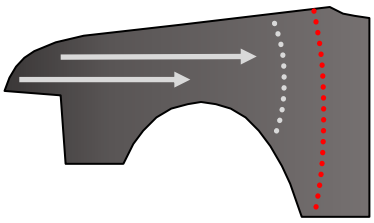
Mazda 46 Machine Grey

nax Premila 8000 Basecoat System

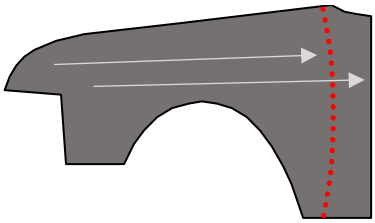
Effect colour (plating)

1. Apply light coats using the Effect Coat mix, starting over the repair area and extend outward with each subsequent coat, or start at the farthest edge of foundation coat blending and move inward with each subsequent coat. Number of coats depends on the colour check against the spray-out sample selection. Apply the indicated number of layers of the effect colour until an even colour appearance is achieved.
2. Flash off till touch dry between coats.
3. Flash finish colour for at least 15 minutes prior to clearcoat application.

Notes: *Alternate the application with each layer of the effect colour, do not overlap in the same area.*
Application of the effect colour must be sprayed similar as on the spray-out samples, ensuring matching colour effect.
Applying the effect coat from out-side-in, helps to easily achieve the right shade to match the existing colour on the vehicle.



Effect Coat Application



Clearcoat Application

Film thickness

Colours		
▸ Foundation	Using the recommended application technique	15-20 µm
▸ Effect	Using the recommended application technique	5-10 µm

Clearcoat application

1. Apply the first coat over the total fadeout area, then after the followed recommended flash off time apply the second coat over the complete panel.
2. Use clearcoat according to relevant clearcoat TDS recommendation.

Re-coating

- All nax Pro LV Clearcoats
- All nax Premila Clearcoats
- nax Crystal 9905 Mirror Image Clear 2K 2:1

Equipment cleaning

Solvent borne guncleaners

Shelflife

nax Premila 8000 Basecoat		
a) Pearl / Solid toners and B/C binder		4 years
b) Metallic toners		2 years
c) Multi toner		1 year
nax Premila Thinners		2 years
nax Premila 410 2K Hardener		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.*

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PROFESSIONAL USE ONLY

Mazda 46V Soul Red Crystal

nax Premila 8000 Basecoat System

Description

nax Premila 8000 Basecoat to repair Mazda 46V Soul Red Crystal, is a three-stage system. Consisting of three separately applied layers replication the OEM special (Candy Red) effect colour.

1. Foundation coat - red metallic colour.
2. Effect coat - transparent (candy) colour coat.
3. Clearcoat

Product and Additives

Product	nax Premila 8000 Basecoat System	Basecoat System (Ready Colour Mix)
	nax Multi 597 Nano Red	Special effect toner
	nax Multi 601 Sunset Red	Special effect toner
	nax Multi 650 Nano Black	Special effect toner
Adjusting Clear	nax Multi 283 SR Adjusting Clear	Transparency enhancer
Hardener	nax Premila 410 2K Hardener	Hardener for the basecoat
Thinners	nax Premila 20 Medium Thinner (aka 500)	Thinner (20-35°C)
	nax Premila 30 Slow Thinner (aka 501)	Thinner (35-45°C)
	nax Premila 40 Extra Slow Thinner (aka 503)	Thinner (40-50°C)

Colour check

To identify the correct shade to match the colour on the vehicle a number of colour spray-out samples needs to be sprayed.
The colour change depends on the number of coats applied of the effect coat.
The operator can determine the right colour match by using these colour samples.

Spray out samples creation

Spray out sample process:

1. Place 5 spray-out panel side by side (first number the panels on the back from 1 to 4)
2. Apply the foundation colour until opacity is achieved on the 4 spray-out panels, then flash off till matt.
3. Next apply one single coat of the effect colour to all panels, then flash off till touch dry.
4. Remove one panel and apply the second coat and the remaining (3) panel, then flash off till touch dry.
5. Continue this application method till the last panel resulting in spray-outs panels ranging with 1-4 coats of the effect coat.
6. Allow a 15 minutes flash-off time at 20°C prior to clearcoat application.
7. Apply clearcoat according to TDS recommendation.

Notes:

- *For optimum flash-off, dry the panels for several minutes in oven or during a drying cycle in the spray booth*
- *Personal application differences makes it recommendable that each painter creates own spray-outs.*
- *To obtain an accurate colour match, spray the panels same as the vehicle, i.e. place all spray-outs on one larger panel and spray complete panel for each coat.*
- *Avoid spraying panels individually.*

Spray out samples


Foundation coat


1 Effect coat


2 Effect coat


3 Effect coat


4 Effect coat

Mazda 46V Soul Red Crystal

nax Premila 8000 Basecoat System

Final surface preparation

▸ Finishing dry sanding step:	P500
▸ Initial dry sanding step may be executed with a coarser grit:	P320/P400
▸ For spot repair, finish the blending area with:	P600

▸ Finishing wet sanding steps:	P1000
▸ Initial dry sanding step may be executed with:	P320/P400
▸ Initial wet sanding step may be executed with:	P800
▸ For spot repair, finish the blending area with:	P1200

- ▸ Prior to SB topcoat application degrease the surface using nax solventborne 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:

1. *Respect 100 grit maximum jump in dry sanding steps and 200 grit maximum jump in wet sanding steps.*
2. *Use guide coat to control sanding.*

Mixing (by weight)

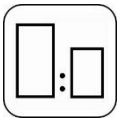
▸ **Toner Use**

Stir toners on mixing machine twice a day for 15 minutes and just before formula mixing.

▸ **Colour Mix**

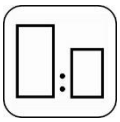
Must be stirred thoroughly directly after mixing the formula.

Foundation Coat (red metallic)



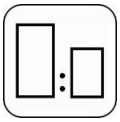
Mix 1	Mix 2	
100	100	nax Premila 8000 (mixed formula)*
100	130	nax Premila Thinners

Effect Coat (Transparent red)



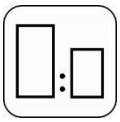
100	Transparent Red (mixed formula)
70	nax Premila Thinners

Underclear Coat (Transparent)



100	nax 283 SR Adjusting Clear
70	nax Premila Thinners

Effect Coat Blend Mix

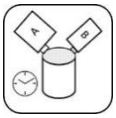


100	Transparent Red RTS formula
30	nax 283 SR Adjusting Clear RTS formula

Notes:

1. *Add nax Premila 410 2K Hardener to both mixes in a ratio of 10% by volume of the base (colour) mix prior to adding nax Premila 500 thinners. After adding hardener mix thoroughly and mix with thinners as mentioned above.*
2. *Only mix colours prior to application*

Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▸ Standard	1 day	1 day	1 day
▸ With 10% hardener	6 hours.	4 hours.	3 hours.

Spray gun set-up / application pressure

	Nozzle size		Application pressure
Foundation coat	1.2-1.3	mm	1.2-1.5 bar at the spray gun air inlet
Effect coat	1.2-1.3	mm	1.5 bar at the spray gun air inlet

Panel application (edge to edge)

Foundation Coat (Mix 1)

1. Apply a wet coat followed by a medium coat, with 5-10 minutes flash off time between coats.
2. Flash off for 5 – 10 minutes.
3. Apply a drop-coat for optimal metallic orientation coat by reducing the pressure to 1.3 bar at the gun inlet and apply the drop coat with full trigger and increased gun distance (±30 cm).
4. Flash off for 5 – 10 minutes*.

Effect Coat

1. Apply light closed coats according to colour check with sprayout samples
2. Flash off till touch dry between coats
3. Repeat till the right colour achieved
4. Flash surface well prior to clearcoat application*

Notes: **For best performance, bake panel at 60°C for 5 minutes, then cool down to ambient temperature prior to effect coat & clearcoat.*

Blend

Blend is a process consisting of light layer application of the new colour into the existing finish to create an invisible repair paint finish.
Due to this special technique a complete panel application (block) is not always required, especially in a case of spot repair.

Planning the blending area

Foundation coat:

Calculating the maximum size for the foundation coat blending:

1. Deduct ±15 cm from the farthest edge of the blending panel.
2. Divide the distance from this line till the edge of the primer surfacer by 3, then take 2/3rd of this distance.
3. This mark should be the farthest edge of the foundation colour blending.

Effect coat:

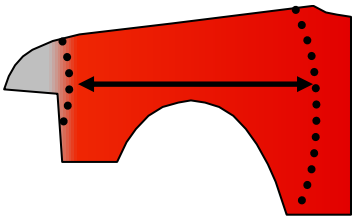
1. The blending area of the effect colour is only slightly overpassing the edge of the foundation fadeout.
2. Use the available area and do not keep the colour blend unnecessary small.

Notes: *Applying the effect coat from out-side-in, helps to easily achieve the right shade to match the existing colour on the vehicle.*

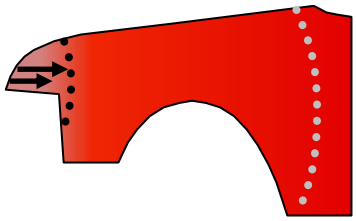
Foundation colour application

5. Apply one coat of underclear in to the fade out area, staying ±10 cm away from the edge of the panel.
6. Flash off till touch dry.
7. Apply light coats in the primer area till opacity achieved using Mix 1. Extending each proceeding coat passing the previous coat.
8. Flash off till touch dry.
9. Apply drop-coat for optimal metallic orientation into the blend area using Mix 2. Reduce pressure to 1.2 bar at the gun inlet and apply the drop coat with full trigger and increased distance to surface. Apply 1-2 thin coat, gradually fading out, facilitating a more uniform blending of the foundation colour from the repair area to the existing colour.
10. Flash off till touch dry.

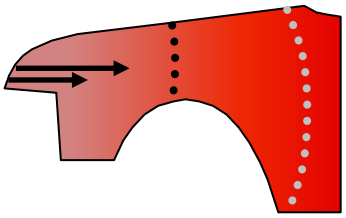
Notes: *For best performance, bake panel at 60°C for 5 minutes, then cool down to ambient temperature prior to effect colour.*



Step 1



Step 3

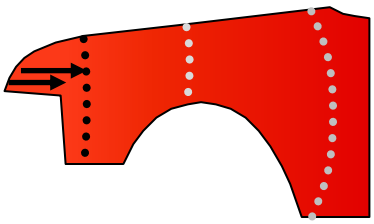


Step 5

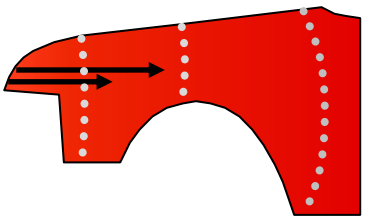
Effect colour (transparent)

1. Apply light coats starting over the repair area and extend outward with each subsequent coat dependent on the spray-out sample selection. Apply the indicated number of layers of the effect colour until an even colour appearance is achieved.
2. Flash off till touch dry between coats.
3. Apply light coats into the blend area using Effect Coat Blend Mix gradually fading out, facilitating a more uniform blending of the effect colour into existing colour.
4. Flash surface well prior to clearcoat application*

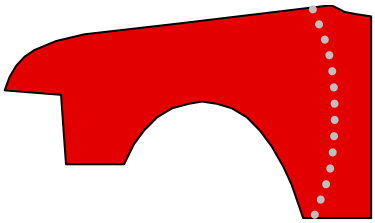
Notes:
Alternate the application with each layer of the effect colour, do not overlap in the same area.
Application of the effect colour must be sprayed similar as on the spray-out samples, ensuring matching layer thickness and colour effect.
Applying the effect coat from out-side-in, helps to easily achieve the right shade to match the existing colour on the vehicle.
**For best performance, bake panel at 60°C for 5 minutes, then cool down to ambient temperature prior to clearcoat.*



Step 1



Step 3



Clearcoat Application

Film thickness

Colours

▸	Foundation	Using the recommended application technique	15-20 µm
▸	Effect	Using the recommended application technique	10-20 µm

Clearcoat application

1. Apply the first coat over the total fadeout area, then after the followed recommended flash off time apply the second coat over the complete panel.
2. Use clearcoat according to relevant clearcoat TDS recommendation.