

nax PROLV Nax PROLV Technical Data Sheets

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CLEARCOATS







VOC compliant high solid clearcoat providing deep gloss with excellent flow and through hardening. Has a long open time allowing a user-friendly application of all job sizes. With its very short dry to polishing time (15 min 60°C) is an ideal production clearcoat of daily use from spot repair to complete re-spray. Provides high chemical resistance & UV protection.

Suitable Substrates

 Nax Premila 8000 series base coat (solvent-borne)
 Nax E³ WB basecoat (water-borne)

 2
 nax Pro LV7600 VHS Performance Clear

 1
 nax Pro LV760 Hardeners

 Spray-gun setup:
 Application Pressure:

 Gravity fed
 1.2-1.3 mm

 1.7-2.2 bar
 28-30 psi



Dust dry Dry to handle Dry to polish	20°C (70°F) 20 min 7 hrs 7 hrs 7 hrs	30°C (86°F) 10 min 3 hrs 3 hrs	40°C (100°F) 7 min 1 hrs 1 hrs	60°C (140°F) n/a 15 min 15 min	Infra-Red n/a 4+8 min 4+8 min
nax Pro LV760	0 VHS Performa	ance Clear	2 years		

2004/42/IIb(d)(420)415

The EU limit value for this product (product category: IIB.d) in ready to use form is max420g/literThe VOC content of this product in ready to use form is maximum415



VOC

Use suitable respiratory protection

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

For detailed information read entire TDS





VOC compliant high solid clearcoat providing deep gloss with excellent flow and through hardening. Has a long open time allowing a user-friendly application of all job sizes. With its very short dry to polishing time (15 min 60°C) is an ideal production clearcoat of daily use from spot repair to complete re-spray. Provides high chemical resistance & UV protection.

Suitable Substrates nax Premila 8000 series base coat (solvent-borne) nax E³ WB basecoat (water-borne) Notes: Follow recommended flash off and re-coating time of the basecoat. Product and Additives Product nax Pro LV7600 VHS Clear

Hardeners	nax Pro LV760 Hardener Fast	15-20°C
	nax Pro LV760 Hardener Medium	20-35°C
Additives	nax LV5101 Topcoat Blending Thinner Spray	
	nax Topcoat Blending Thinner	
	nax Pro LV4200 Flexible Additive	

Basic Raw Materials

nax Pro LV7600 VHS Performance Clear nax Pro LV760 Hardeners Acrylic resins Poly-isocyanate resin

Mixing

			Hardener Se	election	
2	nax Pro LV7600 VHS Performance Clear		15-20°C	20-25°C	25-35°C
1	nax Pro LV760 Hardeners	1-2 panels/spot	Fast	Medium	Medium
		3-5 panels	Fast*	Medium	Medium
		>5 panels	Medium*	Medium*	Medium*

Notes:

Stir after each added component *Add 5% nax Pro LV5000 Thinner Slow

Viscosity (DIN 4 Cup)

	20°C (70°F) 30	0°C (86°F)	40°C (100°F)
c	15-17 sec 14-	-15 sec	13-14 sec

Pot Life

	20°C (70	°F) 30°C (86°F) 40°C (100°F)
	30 N	1in 20 min	15 min
©Ū			

Spray gun set-up / application pressure

Spray-gun type	Spray-gun type	Nozzle size	Application pressure
► LVLP	Gravity	1.2-1.3 mm	1.7-2.2 bar at the spray gun air inlet
► HVLP	Gravity	1.2-1.3 mm	(HVLP: max 0.6-0.7 bar at the air cap)





Application

1 ½ coat Application Apply one light coat, then allow to flash for 3-5 minutes. Apply the 2nd flowing coat.

Notes:

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

Film thickness

1				
	_∬ μm	1 ¹ / ₂ coat application	Using the recommended application technique	45-60 µm
	L.			
l	U)			

Drying time

	Dust d	ry	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	Infra-Red
	•	Medium Hardener	25 min.	12 min	7 min	n/a	n/a
$\langle \cdot \rangle$	•	Fast Hardener	20 min.	10 min	7 min	n/a	n/a
5 7	Dry to	handle and polish					
	•	Medium Hardener	7 hours	3 hours	1 hour	15 min.	4+8 min.
	•	Fast Hardener	7 hours	3 hours	1 hour	15 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



Following the recommended ambient drying or after cool down following the full bake at 60°C object temperature, carefully sand out dust particles and restore the surface according polishing recommendations.

Coverage

Notes:

By using the recommended application, the theoretical material coverage is: m²/liter RTS mixture at 50 µm ±10

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

\square	2004/42/IIb(d)(420)415		
VOC	The EU limit value for this product (product category: IIB.d) in ready to use form is max	420	g/liter
	The VOC content of this product in ready to use form is maximum	415	g/liter



nax Pro LV7600 VHS Performance Clear



Shelflife

0					
\frown	nax Pro LV7600 VHS Performance	Clear	2 years		
	nax Pro LV7600 Hardeners		1 year		
	Minimum storage temperature:	5°C (41°F)	Maximum storage temperature:	35°C (95°F)	
Notes:	Product shelf-life is determined when products	s are stored unopened at	20°C (70°F).Avoid extreme temperature fluctuati	on.	

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nax Pro LV7400 HS Clear is a two component high solid 1 ½ coat clearcoat with an increased scratch resistance. Designed to suit all repair sizes from spot repair to a complete respray. Provides high gloss, extra hardness, exceptional flow, and good protection against weathering.

Suitable Substrates

nax Premila 8000 series base coat (solvent-borne)

nax E³ WB basecoat (water-borne)

	2 nax Pro LV7400 HS Cle	ear	
	1 nax Pro LV740 Hardene	ers	
	0-10% nax Pro LV5000 Thinne	ers	
	Sprav-gun setup:	Application Press	ure:
	Gravity fed $12-14$ mm	$17_2 2$ har	28-30 psi At sprav-gun air inlet
The second secon			20-30 psi At spray-gun an inici
	1 ¹ / ₂ coats w/o thinner	45-60	µm 1½ coat
	2 - 3coats with thinner	50-60	µm 2 coats
7		60-75	µm 3 coats
(),),)	Between coats:	Before 60°C (140)°F) baking:
(1(1(3 - 5 minutes at 20°C 70°F	3 - 5 minutes at	20°C 70°F
	Drying 20°C (70°F) 30)°C (86°F) 40°C (100°F)	60°C (140°F) Infra-Red
$(\)$	Dust dry 20-30 min 10	0-20 min 5-10 min	n/a n/a
	Dry to handle 6-12 hours 3	-6 hours 1.5-3 hours	20-40 min 4+8 min
	Dry to polish 6-12 hours 3	-6 hours 1.5-3 hours	2hrs after cool down 4+8 min
()	nax Pro LV7400 HS Clear	2 years	
	nax Pro LV740 Hardener	1 vear	
	nax Pro I V5000 Thinners	2 vears	
		2 youro	
	2004/42/IIb(e)(840)545	duct catagory: IIR a) in ready to u	iso form is may 840 a/liter
VOC	 The VOC content of this product in read 	dy to use form is maximum	545
	Use suitable respiratory protection	n	
)[->-]			
	Nippon Paint Automotive Refinishes rec	commends the use of fresh ai	r supply respirator.

For detailed information read entire TDS





nax Pro LV7400 HS Clear is a two component high solid 1 ½ coat clearcoat with an increased scratch resistance. Designed to suit all repair sizes from spot repair to a complete respray. Provides high gloss, extra hardness, exceptional flow, and good protection against weathering.

Suitable Substrates

nax Premila 8000 series base coat (solvent-borne)

nax E³ WB basecoat (water-borne)

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

Product and Additives

Product	nax Pro LV7400 HS Clear
Hardener	nax Pro LV740 Hardener Fast
	nax Pro LV740 Hardener Medium
	nax Pro LV740 Hardener Slow
Solvents	nax Pro LV5000 Thinner Fast
	nax Pro LV5000 Thinner Medium
	nax Pro LV5000 Thinner Slow
Additives	nax Pro LV5101 Topcoat Blending Thinner Spray
	nax Topcoat Blending Thinner
	nax Pro LV4000 Accelerator
	nax Pro LV4200 Flexible Additive

Basic Raw Materials

nax Pro LV7400 HS Clear nax Pro LV740 Hardener nax Pro LV5000 Thinners

30-40°C 15-20°C (1-2 panel) 20-25°C (3-5 panel) 30-40°C (>5 panel)

15-20°C 20-25°C

Acrylic resins Poly-isocyanate resin Blend of solvents

Mixing

		H	ardener/Thinner	selection	
2	nax Pro LV7400 HS Clear	Surface	15-20°C	20-25°C	25-35°C
1	nax Pro LV740 Hardener	1-2 panels/spot	Fast/Fast	Med./Fast	Med./Med.
0-10%	nax Pro LV5000 Thinners	3-5 panels	Fast/Fast	Med./Med.	Med./Slow
		>5 panels	Fast/Med	Med./Slow	Slow/Slow

Notes:

Stir after each added component

Viscosity (DIN 4 Cup)

		20°C(70°F)	30°C(86°F)	40°C (100°F)
	 W/o Thinner 	17-19 sec	16-18 sec	15-17 sec
()s	 With Thinner 	15-17 sec	14-16 sec	13-15 sec

Pot Life

$\wedge \wedge$		20°C(70°F)	30°C(86°F)	40°C(100°F)
1	 Slow / Medium Hardener 	2 hours	1.5 hours	1 hours
\odot	 Fast Hardener 	30 Min	25 min	20 min





Spray gun set-up / application pressure

Spray-g	gun type	Spray-gun type	Nozzle	size	Application pressure
•	LVLP	Gravity	1.2-1.4	mm	1.7-2.2 bar at the spray gun air inlet
•	HVLP	Gravity	1.2-1.4	mm	(HVLP: max 0.6-0.7 bar at the air cap)

Application

1 1/2 coat Application

2-3 coat Application



Apply one light coat, then allow to flash for 1-3 minutes. Apply the 2nd flowing coat.

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

Notes:

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

Drying time

Dust dry	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	Infra-Red
 Slow Hardener 	30 min.	20 min.	10 min.	n/a	
 Medium Hardener 	25 min.	15 min.	7 min.	n/a	n/a
 Fast Hardener 	20 min.	10 min.	5 min.	n/a	
Dry to handle and polish					
 Slow Hardener 	12 hours	6 hours	3 hours	40 min.	1 Q min
 Medium Hardener 	8 hours	4 hours	2 hours	30 min.	4+8 min.
 Fast Hardener 	6 hours	3 hours	1.5 hours	20 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



Following the recommended ambient drying or after the 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.

Notes:

Film thickness

_∬ μm	1 ½ coats application	Using the recommended application technique	45-60 µm
	2 coats application	Using the recommended application technique	50-60 µm
	3 coats application	Using the recommended application technique	60-75 μm

Coverage

By using the recommended application, the theoretical material coverage is: m²/liter RTS mixture at ±8 50 µm

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

Equipment cleaning

Solvent borne guncleaners





Solvent Content

\frown	2004/42/IIb(e)(840)545		
VOC	The EU limit value for this product (product category: IIB.e) in ready to use form is max	840	g/liter
	The VOC content of this product in ready to use form is maximum	545	g/liter

Shelflife



Notes:

	nax Pro LV7400 HS Clear		2 years	
	nax Pro LV740 Hardeners		1 year	
	nax Pro LV5000 Thinners		2 years	
)	Minimum storage temperature:	5°C (41°F)	Maximum storage temperature:	35°C (95°F)

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

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nax Pro LV7200 X'press Clear is a two component fast curing clearcoat with an increased scratch resistance. Provides a fast curing, high gloss, good protection against weathering. Recommended for fast repairs in combination with water or solvent borne basecoat.

Suitable Substrates

nax Premila 8000 series base coat (solvent-borne)

nax E³ WB basecoat (water-borne)

	2	nax Pro LV7200 X'press Clear
$ \Pi_{\Box} $	1	nax Pro LV720 Hardener
	10-20%	nax Pro LV5000 Thinners



	Spray-gun setup:		Application Pr	essure:	
≥1	Gravity fed 1.2-1.3 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 th	ne air cap
	2 coats		40)-50 µm 2 coats	
\frown	Potwoon costo:		Poforo 60°C /		
(),),)	Delween coals.	I		140°F) Daking.	I
	3 - 5 minutes at 20°C 70)°F	3 - 5 minute	s at 20°C 70°F	
(\frown)	Drying 20°C (70°F)	30°C (86°F)	40°C (100°F)	60°C (140°F)	Infra-Red
(\checkmark)	Dust dry 15 min	10 min	5 min	n/a	n/a
$\left(\right)$	Dry to handle 8 hours	4 hours	3 hours	20 min	5+10 min
	Dry to polish 8 hours	4 hours	3 hours	1hr after cool down	5+10 min
\bigcirc	nax Pro LV7200 X'press Clear		2 vears		
\sim	nev Pro I V/720 Herdener		1 yoor		
			гусаг		
	nax Pro LV5000 Thinners		2 years		
\bigcap	2004/42/IIb(e)(840)620				
VOC	 The EU limit value for this product 	(product catego	ory: IIB.e) in ready to	o use form is max	840 g/liter
	 The VOC content of this product in 	ready to use fo	orm is maximum		620
	Use suitable respiratory prote	ction			



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

For detailed information read entire TDS





nax Pro LV7200 X'press Clear is a two component fast curing clearcoat with an increased scratch resistance. Provides a fast curing, high gloss, good protection against weathering. Recommended for fast repairs in combination with water or solvent borne basecoat.

Suitable S	Suitable Substrates				
nax Premila	8000 series base coat (solvent-borne)	nax E³ WB basecoat (water-borne)			
Notes:	Follow recommended flash off and re-coating time of the baseco	at.			
Product a	nd Additives				
Product Hardener Reducers Additives	nax Pro LV7200 X'press Clear nax Pro LV720 Hardener nax Pro LV5000 Thinner Fast nax Pro LV5000 Thinner Medium nax Pro LV5000 Thinner Slow nax Pro LV5101 Topcoat Blending Thinner Spray nax Topcoat Blending Thinner nax Pro LV 4000 Accelerator nax Pro LV 4200 Flexible Additive	15-35°C 15-20°C 20-25°C 30-40°C			

Basic Raw Materials

nax Pro LV7200 Xpress Clear	
nax Pro LV720 Hardener	
nax Pro LV5000 Thinners	

HVLP

Acrylic resins Poly-isocyanate resin Blend of solvents

Mixing

				Thinner selec	tion	
	2	nax Pro LV7200 Xpress Clearcoat	Job size	15-20°C	20-25°C	25-35°C
	1	nax Pro LV720 Hardener	1-2 panels/spot	Fast	Medium	Slow
	10-20%	nax Pro LV 5000 Thinners	3 panels	Fast/Med.	Med./Slow	Slow
Notes:	Stir after e	ach added component				

Viscosity (DIN 4 Cup)

	20°C (70°F)	30°C ((86°F)	40°C (100°F)
	17-18	sec	14-17	sec	13-14	sec
l s						

$(\land$		20°C (70°E)	30°C (96°E)
Pot I	Life		

	$\langle \rangle \wedge$	20 0	• (/UF)	30 0	(00 F)	40 0	
3	VIC	30	Min	20	min	15	min
1	\odot						

1.2-1.4

mm

Spray gur	n set-up / applicatio	n pressure		
	Spray-gun type	Spray-gun type	Nozzle size	Application pressure
	► LVLP	Gravity	1.2-1.4 mm	1.7-2.2 bar at the spray gun air inlet
		<u> </u>		

Gravity

10°C (400°E)

(HVLP: max 0.6-0.7 bar at the air cap)





Application



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

Notes:

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

Film thickness

_Π μm	2 coats application	Using the recommended application technique	40-50 µm
<u>۸</u>	3 coats application	Using the recommended application technique	60-75 µm

Drying time

	ZU C(70°F)	30 C(86°F)	40°C(100°F)	60°C(140°F)	intra-Red
ust dry	15 min.	10 min	5 min	n/a	n/a
ry to handle and polish	8 hours	4 hours	2 hour	20 min.	4+8 min
	ust dry ry to handle and polish	ust dry 15 min. ry to handle and polish 8 hours	ust dry15 min.10 minry to handle and polish8 hours4 hours	ust dry15 min.10 min5 minry to handle and polish8 hours4 hours2 hour	ust dry15 min.10 min5 minn/ary to handle and polish8 hours4 hours2 hour20 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



Following the recommended ambient drying or after the 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: ▶ ±7.5 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.
—	t alaan han

Equipment cleaning

Solvent borne guncleaners





Solvent Content

\bigcap	2004/42/IIb(e)(840)620		
VOC	The EU limit value for this product (product category: IIB.e) in ready to use form is max	840	g/liter
	The VOC content of this product in ready to use form is maximum	620	g/liter

Shelflife

חר

Notes:

nax Pro LV7200 X'press Clear		2 years	
nax Pro LV720 Hardener		1 year	
nax Pro LV5000 Thinners		2 years	
Minimum storage temperature:	5°C (41°F)	Maximum storage temperature:	35°C (95°F)

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

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PRIMERS







nax Pro LV3000 Wash Primer CF Two-pack chromate free, fast drying anti-corrosive primer for pretreatment for light metals and alloys.

Used to provide optimal corrosion protection and adhesion to the subsequently applied coatings. The product ensures excellent adhesion to various substrate and very high anti corrosion resistance.

Suitable	Substrates		
Steel Existing finit	Galvanized Steel		Aluminum
Externing min		·	
	 nax Pro LV3000 Wash Primer 0 nax Pro LV300 Activator 	CF	
	Spray-gun setup: Gravity fed 1.3-1.5 mm	Application Pre 1.7-2.2 bar HVLP max 0.6-0.7	ssure: 28-30 psi At spray-gun air inlet bar (8-10 psi) at the air cap
	1-2 coat	↓ μm 1	5-10 μm /coat
	Potwoon coata:		
<u>)</u> †)†)	5 - 10 minutes at 20°C 70°F		
	Dry to re-coat	20°C (70°E)	30°C (86°E) 40°C (100°E)
		10-15 min	5-10 min 3-5 min
	Re – coatable with:		
	With all nax Pro LV and Premila primer fillers a	and surfacers	
	With nax Premila 2K topcoat systems		
	nax Pro I V3000 Wash Primer CF	2 vears	
	nax Pro LV200 Activator	2 years	
		2 years	
\bigcap	2004/42/IIB(c)(780)780		
voc	 The EU limit value for this product (product cat The VOC content of this product in ready to us 	egory: IIB.c) in ready t e form is maximum	o use form is max 780 g/liter 780
	Use suitable respiratory protection		
	Nippon Paint Automotive Refinishes recomme	ends the use of fresh	air supply respirator.
	Read complete TDS for detailed product information		





Two-pack Low VOC chromate free, fast drying anti-corrosive primer for pre-treatment for light metals and alloys. Used to provide optimal corrosion protection and adhesion to the subsequently applied coatings. The product ensures excellent adhesion to various substrate and very high anti corrosion resistance.

Suitable Su	ıbstrates				
Steel Existing finisl	nes	Galvanized Steel Polyester laminates		Aluminum nax polyester bodyfille	ers & putties
Product an	d Additives				
Product Hardeners	nax Pro LV3000 Wash Prim nax Pro LV300 Activator	er CF			
Surface pre	eparation				
	 Prior to any surface Use clean quality ra Apply sufficient deg 	preparation, degrease the rep gs or wiping towels, one for w reaser to keep the surface we	pair area using etting and one t and wipe deg	nax solvent borne deg for drying. reaser off before it car	reaser. n evaporate
	 Removal of existing 	finish and initial sanding of po	olvester bodyfil	ler/putty	P120
	 Feather edge before 	e polyester/putty and finish, sa	inding for com	plete panel priming	P220
	 Feather edge and fi 	nal step for primer/surfacer fo	r spot repairs,	(ED) coated parts	P320
	 Abrasive blasted ste 	el			SA 2.5 - 3.0
Notes:	 Prior to wash prime Use clean quality ra Apply sufficient deg 	r application degrease the are gs or wiping towels, one for w reaser to keep the surface we	a using nax so etting and one t and wipe deg	lvent borne degreaser, for drying the surface reaser off before it car	n evaporate
Mississ as		y canaling clope.			
	Mixing Machine For best performance, stir perf	rimer on mixing ninutes	F Stir well, a	Product Mix after each added comp	onent.
	Volume Weight 1 100 nax Pro LV 1 80 nax Pro LV	3000 Wash Primer CF 300 Activator			
Notes:	Stir after each added component				
Viscosity (I	DIN 4 Cup)				
∏s =			20°C (70 18-20 s	30°C (86°F) sec 16-18 sec	
Notes:					
Pot Life					
$(\land \land)$		20	° C (70°F)	30°C (86°F)	40°C (100°F)

 20°C (70°F)
 30°C (86°F)
 40°C (100°F)

 48 hours
 36 hours
 24 hours

 Notes:
 Passed the pot life, primer loses its etching property.
 Passed the pot life, primer loses its etching property.





Spray gun set-up / application pressure

►

Gravity



Nozzle size

Spray-gun type **Application pressure** 1.3-1.5 mm Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)

Notes:

Application

	Depending on desired film build	1-2 coats	
	 Apply two medium coat with 5-10 minutes flash off betw 	een coats on the sanded repair area	1
Notes:	Allow each coat to flash-off naturally, do not force-dry by air support Flash-off time depends on ambient temperature, applied layer thickness and airflow		

vient temperature, applie Recommended application condition: 15-35 °C and 20-80% relative humidity

Re-coating time

			20°C(70°F)	30°C(86°F)	40°C(100°F)
(-~-)	►	At 15µm	15 min	10 min	5 min
	•	Recoat within 7 days			
Votes:					

Film thickness

_Π μm	•	Conventional application	Using the recommended application technique	5-10 µm/coat

Notes:

Re-coatable

With all nax Pro LV and Premila primer fillers and surfacers With Premila 2K topcoat systems

Notes:

Coverage



Notes:

By using the recommended application, the theoretical material coverage is: m²/liter RTS mixture at ± 11 10µm

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 nitrocellulose solvents



nax Pro LV3000 Wash Primer CF



Solvent Content

	2004/42/IIB(c)(780)780		
/OC	The EU limit value for this product (product category: IIB.c) in ready to use form is max	780	g/liter
	The VOC content of this product in ready to use form is maximum	780	g/liter

Shelflife

\frown	nax Pro LV3000 Wash Primer CF		2 years	
	nax Pro LV300 Activator		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°0	C (70°F).Avoid extreme temperature fluctuation	

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One-pack chromate free, fast drying anti-corrosive etching primer for pre-treatment for light metals and alloys. Used to provide optimal corrosion protection and adhesion to the subsequently applied coatings. Can be also sprayedwith airless application.

Suitable Su	ubstrates		
Steel Existing finishe	Galvanized Steel Polyester laminates	, 1	Aluminum nax polyester bodyfillers& putties
	5 naxPro LV1600 Wash Primer 1K 3 nax Pro LV5000 Thinners	CF	
Sp Gr	pray-gun setup: ravity fed 1.3-1.5 mm	Application Pres 1.7-2.2 bar HVLP max 0.6-0.7	SSURE: 28-30 psi At spray-gun air inlet bar (8-10 psi) at the air cap
1-	-3 coat	10-20	0 μm /coat
Alternative Sector Se	etween coats - 10 minutes at 20°C 70°F		
Dr na na na	ry to recoat ax Pro LV5000 Fast Thinner ax Pro LV5000 Medium Thinner ax Pro LV5000 Slow Thinner	20°C (70°F) 10-15 min 20-30 min	30°C (86°F) 40°C (100°F) 10-15 min 5-10 min 20-30 min 10-15 min
Re Wi Wi	e – coatable with: ith all nax Pro LV and Premilaprimer fillers ar ith naxPremila2K topcoat systems	nd surfacers	
	ax Pro LV1600 Wash Primer 1K CF ax Pro LV5000 Thinners	1 year 2 years	
V O C 20	004/42/IIB(c)(780)695 The EU limit value for this product (product cate The VOC content of this product in ready to use	egory: IIB.c) in ready to form is maximum	use form is max 780 g/liter 695
	Jse suitable respiratory protection Jippon Paint Automotive Refinishes recomme or detailed information read entire TDS	ends the use of fresh	air supply respirator.





One-pack chromate free, fast drying anti-corrosive etching primer for pre-treatment for light metals and alloys. Used to provide optimal corrosion protection and adhesion to the subsequently applied coatings.

Suitable Su	ubstrates			
Steel Existing finis	hes	Galvanized Steel Polyester laminates	Aluminum nax polyester bodyfille	ers& putties
Product an	d Additives			
Product Hardeners	naxPro LV1600 1K Wash P naxPro LV5000 Thinners	rimer 1K CF		
Surface pr	eparation			
	Prior to any surface Use clean quality ra Apply sufficient deg	preparation, degrease the repa gs or wiping towels, one for we reaser to keep the surface wet	air area using nax solvent borne deg tting and one for drying. andwipe degreaser off before it can	greaser. I evaporate
	Removal of existing	finish and initial sanding of pol	yester bodyfiller/putty	P120
	Feather edge before	e polyester/putty and finish, sar	iding for complete panel priming	P220
	Feather edge and fi	nal step for primer/surfacer for	spot repairs, (ED) coated parts	P320
	Abrasive blasted ste	el		SA 2.5 - 3.0
	Prior to wash prime Use clean quality ra Apply sufficient deg	rapplication degrease the area lgs or wiping towels, one for we reaser to keep the surface weta	using nax solvent borne degreaser. tting and one for drying the surface and wipe degreaser off before it can	evaporate
Notes:	Respect 100 grit maximum jump in d	ry sanding steps.		

Mixing



Mixing Machine

machine twice a day for 15 minutes

For best performance, stir primer on mixing



Product Mix

Stir well, after each added component.

(_	- 22
	10.5
	1.1

Volume Weight

5	naxPro LV 1600 Wash Primer 1K CF
1.5-3	nax LV 5000/Fast/Medium/Slow Thinners

Thinner selection Fast Medium Slow			

Notes:

Stir after each added component

Viscosity (DIN 4 Cup)

		20°C (70°F)
	5:3	22-25 sec
()s	5:1.5	44-48 sec
nr) —		

Notes:

Pot Life

$(\land \land)$		20°C (70°F)	30°C (86°F)	40°C (100°F)
44	5:3(conventionalapplication)	24 hours	24 hours	18 hours
@	5:1.5 (airless application)	24 hours	24 hours	18 hours

Notes:

Passed the potlife, primer loses its etching property.





Spray gun set-up / application pressure

	Spray-gun type	Nozzle size	Application pressure
	Gravity	1.4-1.6 mm	Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)
₽	Airless	0.28-0.33 mm	100-120 bar at the spray gun air inlet

Notes:

Application

	5:3 (conventional application)	Depending on desired film build	2-3 coats	
	5:1.5 (airless application)	Depending on desired film build	1 coats	
	Apply two medium coat with 5-10 minutes flash off between coats on the sanded repair area			

Notes:

Allow each coat to flash-off naturally, do not force-dry by air support Flash-off time depends on ambient temperature, applied layer thickness and airflow.

Recommended application condition: 15-35 °C and 20-80% relative humidity

Re-coating time

	20°C (70°F)	30°C (86°F)	40°C (100°F)
Conventional application	20 min	15 min	10 min
Airless application	30 min	20 min	15 min
Recoat within 48 hours			
	Conventional application Airless application Recoat within 48 hours	20°C (70°F)Conventional application20 minAirless application30 minRecoat within 48 hours	20°C (70°F)30°C (86°F)Conventional application20 min15 minAirless application30 min20 minRecoat within 48 hours20 min15 min

Notes:

Film thickness

<u></u> Ωµm	Conventional application	Using the recommended application technique	10-20 µm/coat
Cî	Airless application	Using the recommended application technique	40-60 µm/coat

Notes:

Final sanding

8			-	1
	4		1	
		Γ.	-	

After 30 minutes drying etch primer can scuffed prior to primer surfacer application Dry scuffing: P400

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2	ΥЛ
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After scuffing degrease the surface using naxsolventborne degreaser. Use clean quality rags or wiping towels, one for wetting and one for drying. Apply sufficient degreaser to keep the surface wetand wipe degreaser off before it can evaporate

Notes:

Re-coating

-	5
74	
	PA.
	,

With all nax Pro LV and Premila primerfillers and surfacers WithPremila 2K topcoat systems

To replicate OEM system and to achieve the highest quality always apply a primer surfacer prior to topcoat.

Coverage

By us

Notes:



ing the recomm	ended application, the theoretic	al material coverage is:
20 μm	± 10m²/liter RTS mixture at	Spraying Gravity Gun
50 µm	± 04m²/liter RTS mixture at	Airless Spraying

50 µm ± 04m²/liter RTS mixture at



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 nitrocellulose solvents

Solvent Content

VOC

2004/42/IIB(c)(780)695

The EU limit value for this product (product category: IIB.c) in ready to use form is max 780 g/liter g/liter The VOC content of this product in ready to use form is maximum 695

Shelflife

	nax Pro LV1600 Wash Primer 1K CF		2 years	
	nax Pro LV5000 Thinners		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.			

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nax Plastic Primer 1K is a single component ready to use plastic adhesion promoter designed to support the adhesion of primers/surfacers and 2K topcoats to common plastic parts found in automotive refinishes including Polypropylene and its blends. It also adheres various metal substrates.

Suitable	Substrates				
Polypropylene and its blends		Polyester and epoxy laminates Steel, stainless, galvanized, aluminum		zed, aluminum	
	Ready to spray				
	Spray-gun setup: Gravity fed 1.2-1.4	mm	Application Pres 1.7 - 2.2 bar HVLP max 0.6-0.7 bar (8	SURE: 28-30 psi 3-10 psi) at the air ca	At spray-gun air inlet p
	1 - 2 coats		05 - 2 Ο - 2	10 µm /coa	it
<u>}</u>	Between coats: 5 - 10 minutes at 2	20°C 70°F			
	Dry to recoat		20°C (70°F) 15 min	30°C (86°F) 10 min	40°C (100°F) 5 min
	Re – coating With all nax Pro LV and F With all nax Premila 2K to	Premila primer fillers opcoat systems	and surfacers		
	nax Plastic Primer 1K		2 years		
Voc	2004/42/IIB(e)(840)840 ► The EU limit value for the VOC content of this	his product (product ca s product in ready to us	tegory: IIB.e) in ready to se form is maximum	o use form is max	g/liter 840 840
	Use suitable respirat	ory protection Refinishes recomme	ends the use of fresh	air supply respire	ator.





nax Plastic Primer 1K is a single component ready to use plastic adhesion promoter designed to support the adhesion of primers/surfacers and 2K topcoats to common plastic parts found in automotive refinishes including Polypropylene and its blends. It also adheres various metal substrates.

Suitable S	Substrates		
Polypropylene and its blends		Polyester and epoxy laminates	Steel, stainless, galvanized and aluminum
Notes:	For best adhesion on metal substra	tes always use etch or epoxy primer.	
Surface p	reparation		
	 Prior to any surfact Use clean quality r Apply sufficient det Wipe degreaser of 	e preparation, Remove oily contamina ags or wiping towels, one for wetting a greaser to keep the surface wet. f before it can evaporate.	tion using nax Pro LV100 universal degreaser. and one for drying the surface.
	 Non primed new p 	lastic (raw) \rightarrow Use grey scuff pad with	matting paste and warm water
	 In case of plastic re 	epair finish surface before priming, wit	th: P320
	 Prior to surfacer at Prior to surfacer at Use clean quality r Apply sufficient de 	oplication on plastic, degrease the are oplication on other surfaces, degrease ags or wiping towels, one for wetting a greaser to keep the surface wet and w	a using nax Pro LV300 Anti-Static Degreaser with nax Pro LV100 Universal Degreaser and one for drying the surface vipe degreaser off before it can evaporate
Notes:	Respect 100 grit maximum jump in	dry sanding steps.	
Product p	roporation		
Froduct p			
	Ready to spray	Lightly ag	itate 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)
5	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

Apply two medium wet coats over the sanded repair area, with 5-10 minutes flash off between coats





Re-coating time

	20°C (70°F)	30°C (86°F)	40°C (100°F)
(-~-)	15 minutes	10 minutes	5 minutes

Re-coating



With all nax Pro LV and Premila primer fillers and surfacers With all nax Premila 2 K topcoat systems

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

Film thickness

ſŢμm	1-2 Coats	5-10 μm/coat
Ť		

Equipment cleaning

Solvent borne guncleaners

Solvent Content



2004/42/IIB(e)(840)840

The EU limit value for this product (product category: IIB.b) in ready to use form is max 840 g/liter The VOC content of this product in ready to use form is maximum 840 g/liter

Shelflife nax Plastic Primer 1K 2 years Minimum storage temperature: 5°C (41°F) Maximum storage temperature: 35°C (95°F)

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

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nax Pro LV1001 Plastic Primer 1K Aerosol is a single component ready to use aerosol plastic adhesion promoter designed to support the adhesion of primers/surfacers and 2K topcoats to common plastic parts found in automotive refinishes including Polypropylene and its blends. It also adheres various metal substrates.

Suitable Substrates

Plastics incl. polypropylene and its blends	Polyester and epoxy laminates	Steel, stainless, galvanized, aluminum

	Ready to spray		Only requires a shak	e before use
	1 - 2 coats	μm	5 - 10 μn	n / coat
	Between coats: 5 - 10 minutes at 20°C 70°F			
	Dry to recoat	20°C (70°F 10 min	F) 30°C (86°F) 7 min	40°C (100°F) 5 min
	Re – coatable with: With all nax Pro LV and Premila primer fillers With naxPremila2K topcoat systems	and surafcers		
	nax Pro LV1001 Plastic Primer 1k Aerosol	2 years		
voc	2004/42/IIB(e)(840)710 The EU limit value for this product (product ca The VOC content of this product in ready to u	itegory: IIB.e) in se form is maxim	ready to use form is max num	840 710 g/liter
	Use suitable respiratory protection Nippon Paint Automotive Refinishes recomme	ends the use of	fresh air supply respirate	Dr.

For detailed information read entire TDS





nax Pro LV1001 Plastic Primer 1K Aerosol is a single component ready to use aerosol plastic adhesion promoter designed to support the adhesion of primers/surfacers and 2K topcoats to common plastic parts found in automotive refinishes including Polypropylene and its blends. It also adheres various metal substrates.



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. Apply sufficient degreaser to keep the surface wet andwipe degreaser off before it can evaporate



Finishing dry sanding steps	P320-400
For Steel, galvanized steel aluminum	P320-400
For plastic, abrade using warm water, matting paste with grey scuffing pad	

Prior to surfacerapplication on plastic, degrease the area using nax Pro LV300 Anti-Static Degreaser

Apply sufficient degreaser to keep the surface wet and wipe degreaser off before it can evaporate

Prior to surfacerapplication on other surfaces, degrease with nax solvent borne degreaser. Use clean quality rags or wiping towels, one for wetting and one for drying the surface.



Notes:

Respect 100 grit maximum jump in dry sanding steps.

Product Preparation



Ready to spray



Shake thoroughly before use Shake for several minutes after the mixing ball has loosened

Application



Number of coats: 1-2

Apply two medium wet coats over the sanded repair area, with 5-10 minutes flash off between coats

Re-coating time

(\Box)	20°C (70°F)	30°C (86°F)	40°C (100°F)
(-~-)	10 minutes	7 minutes	5 minutes

Re-coating



With all nax Pro LV and Premila primer fillers and surafcers WithnaxPremilatopcoat systems

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





Film thickness

\bigcirc		
_] μm	1-2 Coats	5-10 μm/coat

Equipment cleaning



After use invert aerosol and spray for 5 second to clean nozzle.

Solvent Content

v	n	C
v	0	C

2004/42/IIB(e)(840)710

The EU limit value for this product (product category: IIB.e) in ready to use form is max	840	g/liter
The VOC content of this product in ready to use form is maximum	710	g/liter

Shelflife				
(\frown)	nax Pro LV 1001 Plastic Primer 1K	Aerosol	2 years	
	Minimum storage temperature:	5°C (41°F)	Maximum storage temperature:	35°C (95°F)
Notes:	Product shelf-life is determined when product	s are stored unopened at	20°C (70°F). Avoid extreme temperature fluctuati	ion.

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nax Pro LV1100 Spot Sealer Aerosol is a versatile direct to metal epoxy based aerosol primer.Designed for covering exposed bare metal after sanding the primer surfacer prior to application of WB basecoat. Due to its anti-corrosion properties, it can also be used as primer and spot primer for small repairs. Can be used as wet on wet or sanding.

Suitable Substrates						
Existing finishes Steel Stainless Steel	OEM Electro-coat (ED) Galvanized Steel Aluminum	Polyester lamina nax polyester bo	tes dyfillers& putties			
Ready to spray		Only requires a sl	nake before use			
2 – 3 coats		μm 15 - 20	µm / coat			
Between coats: 5 - 10 minutes at	20°C 70°F					
Dry to recoat Dry to sand	2(1	0°C (70°F) 30°C (86°F) 0-15 min 5-7 min 20 min 15 min	40°C (100°F) 3-5 min 10 min			
Re – coatable wit With all nax Pro LV a Withnax E ³ WB and F	h: nd Premilaprimer fillers/surfac Premilatopcoat systems	ers and polyesters bodyfillers	/putties			
nax Pro LV1100 Spo	t Sealer Aerosol 5 yea	ars				
VOC VOC VOC VOC VOC VOC VOC VOC VOC VOC	80 nis product (product category: IIB. s product in ready to use form is n	e) in ready to use form is max naximum	840 g/liter 680			
Use suitable respined Nippon Paint Automo	ratory protection tive Refinishes recommends th	ne use of fresh air supply rest	pirator.			

For detailed information read entire TDS





nax Pro LV1100 Spot Sealer Aerosol is a versatile direct to metal epoxy based aerosol primer. Designed for covering exposed bare metal after sanding the primer surfacer prior to application of WB basecoat. Due to its anticorrosion properties, it can also be used as primer and spot primer for small repairs. Can be used as wet-on-wet or sanding.

Suitable Substrates		
Existing finishes Steel Stainless Steel	OEM Electro-coat (ED) Galvanized Steel, Aluminum	Polyester laminates

Product

nax LV 1100 Spot Sealer Aerosol

Epoxy resin

15-20 µm/coat

Surface preparation

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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. Apply sufficient degreaser to keep the surface wet andwipe degreaser off before it can evaporate



Removal of existing finish and initial sanding of polyester bodyfiller/puttyP120Feather edge before bodyfiller/putty and final sanding for complete panel primingP220Feather edge and final step before spraying primer/surfacer for spot repairsP320Steel, galvanized steel, stainless steelP220Polyester laminates, Aluminum and ED coated panelP320Prior to spot sealer 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 andwipe degreaser off before it can evaporate

Notes:

Respect 100 grit maximum jump in dry sanding steps.

Product preparation



Application



Number of coats: 1-2

Apply evenwet coats over the required areas, with 5-10 minutes flash off between coats

Film thickness



W-o-W / Sanding Using the recommended application technique

Drying time

	20°C (70°F)	30°C (86°F)	40°C (100°F)
Dry to recoat	10-15 min.	5-7 min.	3-5 min.
Dry to sand	20 min	15 min	10 min





Final sanding

Finishing dry sanding steps in case as spot primer:	P400-P500
Initial dry sanding step may be executed with a coarser:	P320
As a isolator for WB basecoat it can be lightly scuffed (not required) with	P500
Prior to SB application degrease the surface using nax solvent borne degreaser Prior to WB application degrease the surface using naxE ³ WB Silicone 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 befor	e it can evaporate

Notes:

Respect 100 grit maximum jump in dry sanding steps

Re-coating



With all naxPro / Pro LV and Premilaprimer surfacers and polyesters bodyfillers/putties With all nax E³ WB and Premilatopcoat systems

Notes:

Equipment cleaning



After use invert aerosol and spray for 5 second to clean nozzle.

Solvent Content

	V	0	С
L		-	-

2004/42/IIB(e)(840)680

The EU limit value for this product (product category: IIB.e) in ready to use form is max	840	g/liter
The VOC content of this product in ready to use form is maximum	680	g/liter

Shelflife

Onennie				
\square	naxPro LV1100 Spot Sealer Aerosol		5 years	
\frown				
	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.

OAR.03.011. 300517 **Professional Use Only**

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PRIMER SURFACERS







Productive VOC compliant grey shade two-pack Extra High Built (XHB), High Built (HB) and Wet-on-Wet (WOW) surfacer, with excellent application and sanding properties. Helps to reduce process time and provides good enamel hold-out with automotive topcoats. WOW can be applied on sound OEM e-coat.

Suitable Substrates Existing finishes Steel and Electro-coat (ED) Glass reinforced laminates nax Pro LV and nax etch primers, plastic primers, epoxy primers and polyester bodyfillers & putties Image: Compary Pro LV/3601/04/07 VHS Primer Surfacer

	1 nax Pro LV360 Hardener 0.6-1.2 nax Pro LV5000 Thinners	
	Spray-gun setup: Gravity fed 1.3-1.8 mm	Application pressure:1.7-2.2bar28-30psiAt spray-gun air inletHVLP max 0.6-0.7 bar (8-10 psi) at the air cap
	1 coat for WOW 2 - 3 coats for HB 1 - 2 coats for XHB	25-35 μm /coat 50-60 μm /coat 60-80 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
	Dry to recoat (WOW) 30 min. Dry to sand (XHB & HB) 3 hours	30°C (86°F) 40°C (100°F) 60°C (140°F) Infra-Red 20 min. 10 min. 30 min. 4+8 min.
	Final dry sanding: P400-P500	Final wet sanding: P800-P1000
	Re-coating: With nax E-Cube WB Basecoat, nax Premila	8000 Basecoat and nax Premila 7000 2K Topcoat
	nax Pro LV3601/04/07 VHS Primer Surfacer nax Pro LV360 Hardener nax Pro LV5000 Thinners	2 years 1 year 2 years
Voc	 2004/42/IIB(c)(540)539 The EU limit value for this product [product ca The VOC content of this product in ready to us 	tegory: IIB(c)] in ready to use form is maximum 540 se form is maximum 539 g/liter
	Use suitable respiratory protection Nippon Paint Automotive Refinishes recomm	ends the use of fresh air supply respirator.





Productive VOC compliant grey shade two-pack Extra High Built (XHB), High Built (HB) and Wet-on-Wet (WOW) surfacer, with excellent application and sanding properties. Helps to reduce process time and provides good enamel hold-out with automotive topcoats. WOW can be applied on sound OEM e-coat.

Suitable Substrates

Existing finishes Steel and Electro-coat (ED) Glass reinforced laminates nax Pro LV and nax etch primers, plastic primers, epoxy primers and polyester bodyfillers & putties

Product an	d Additives		
Products	nax Pro LV3601 VHS Primer Surfacer (White) nax Pro LV3604 VHS Primer Surfacer (Grey)	Acrylic resin Acrylic resin	
Hardeners Solvents	nax Pro LV3607 VHS Primer Suffacer (Black) nax Pro LV360 Hardener nax Pro LV5000 Thinner Fast nax Pro LV5000 Thinner Medium	Acrylic resin Poly-isocyanate resin Blend of Solvent Blend of Solvent	15- 40°C 15-20°C 20-25°C
Additives	nax Pro LV5000 Thinner Slow nax Pro LV4100 Anti-Silicone nax Pro LV4200 Flexible Additive	Blend of Solvent	25-35°C

Surface preparation

	> >	Prior to any surface preparation remove oily contamination using nax solvent-borne deg 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	greaser. 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: DEGREASE ONLY.	
-	►	Prior to primer surfacer application degrease the surface using nax solvent-borne degre	easer.
ΠI	►	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

Gray Shade Mix (3601 : 3607)

Shade	Impression	Tone	3601	3604*	3607
S1		White	100	-	-
S2		Extra Light Gray	90	-	10
S3*		Light Gray	70	*	30
S4		Medium Gray	50	-	50
S5		Dark Gray	30	-	70
S6		Extra Dark Gray	90	-	10
S7		Black	-	-	100

Notes:

Stir well after adding the different tones together

*nax Pro LV3604 VHS Primer Surfacer is similar to shade S3 and can be used as a standalone quick gray solution.





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.

\frown	ХНВ	НВ	wow			Thinner Sel	ection	
$(\square _)$	3	3	3	nax Pro LV3601/04/07 VHS Primer Surfacer		15-20°C	20-25°C	25-35°C
	1	1	1	nax Pro LV360 Hardener	1-2 panels/spot	Fast	Medium	Slow
	0.6	0.9	1.2	nax Pro LV5000 Thinners	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)
1.	► XHB	30-45 sec.
JS	► HB	24-28 sec.
	► WOW	19-23 sec.

Notes:

Pot Life

$(\land \land)$		20°C (70°F)	30°C (86°F)	40°C (100°F)
120	► XHB & HB	60 min.	40 min.	20 min.
\odot	► WOW	90 min.	60 min.	30 min.

Notes:

Spray gun set-up / application pressure

			Spray-gun type	Nozzle size	Application pressure
	►	XHB & HB	Gravity	1.6-1.8 mm	Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)
× A	►	WOW	Gravity	1.3-1.4 mm	Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)

Application

►	XHB & HB	Depending on required film build	2-3 coats
•	WOW		1 coat
Sanding	Apply one m	edium coat over the sanded repair area, then a	allow to flash for 5-10 minutes.
	Where a full	panel application is required apply 2-3 coats of	over the total panel.
Wet on Wet	Apply one flo	owing coat on the panel.	

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.

Film thickness

	►	ХНВ	Using the recommended application technique	60-80 µm/coat
<u></u> μm	►	HB	Using the recommended application technique	50-60 µm/coat
	►	WOW	Using the recommended application technique	25-35 µm/coat





Drying time

Drying ti	lie					
(\Box)		20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	IR
$\langle \cdot \rangle$	Dust drv	5-10 min.	5-7 min.	3-5 min.	n/a	n/a
()	Dry to recoat with topcoat (WOW)	15-20 min.	10 min.	5 min.	n/a	n/a
-	Dry to sand (HB &XHB)	3 hours	2 hours	1 hour	30 min.	4+8 min.
Notes:	Recoat wet-on-wet application within 3 hours. After Allow 10 minutes flash off prior to Infra-Red drying. Following the drying cycle at 60°C (140°F) object temp	r 3 hours of drying the perature, allow produc	e primer must be s ct to completely co	anded prior to proc ol down to ambien	ceeding applicatio t temperature.	ns.
Finishing	surface preparation					
	Finishing dry sanding steps: 2K T	opcoat / Baseco	pat:		P4(00/P500
	Initial dry sanding step may be ex	ecuted with a co	harser arit:		P33	20
	For spot repair, finish the blendin	a area with:	Jaroor grit.		D5(10
		g alea with.			1.00	
\frown	Einishing wet sanding steps: 2K	Foncoat / Baseco	nat.		P8(0/P1000
	Initial dry sanding steps. 21	vecuted with a co	Darser arit		P33	20
0	Initial wet sanding step may be explanation in the sanding step may be explanation.	vecuted with a co	oarser grit. 2K	Topcoat / Bas	ecoat: P6(
	For spot repair, finish the blendin	a area with:	oarser ynt. zit	Topcoat / Das		00/1 000
		y area with.			1 10	000
	 Prior to SB topcoat application de 	egrease the surfa	ace using nax	solvent-borne	degreaser.	
	 Prior to WB basecoat application 	degrease the su	Irface using na	ax E-Cube WB	Silicone Off.	
	 Use clean quality rags or wiping t 	owels, one for w	etting and one	e for drying.		
	 Apply sufficient degreaser to keep 	p the surface we	t and wipe de	greaser off bef	ore it can eva	oorate.
Notes:	Respect 100 grit maximum jump in dry sanding steps	and 200 grit maximul	m jump in wet sand	aing steps.		
Re-coatir						
	With nax E-Cube WB Basecoat, nax Prem	nila 8000 Baseco	pat and nax Pr	emila 7000 2K	Topcoat (dire	ect gloss)
Notes:	Avoid applying polyester bodyfiller on top of the prime	er surfacer				
notes.						
Coverage)					
↓ μm	By using the recommended application, th ±8 m²/liter RTS mixture at ±13 m²/liter RTS mixture at	e theoretical ma 50µm XHB & 30µm WOW	terial coverage HB	e is:		
Notes:	The practical material usage depends on many facto application circumstances.	ors i.e. shape of the o	object, roughness	of the surface, ap	plication techniqu	es, pressure and
Fauinme	nt Cleaning					
Equipine						
	Solvent-borne gun cleaners					

Solvent Content

VOC

2004/42/IIB(c)(540)539

The EU limit value for this product [product category: IIB(c)] in ready to use form is maximum540g/literThe VOC content of this product in ready to use form is maximum539g/liter



Notes:

nax Pro LV 3601/04/07 VHS Primer Surfacer



Shelf-life					
	nax Pro LV3601/04/07 VHS Primer Surfacer		2 years		
	nax Pro LV360 Hardener		1 year		
	nax Pro LV5000 Thinners		2 years		
	Minimum storage temperature:	5°C (41°F)	Maximum storage temperature:	35°C (95°F)	

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

OAR.04.011. 140917 PROFESSIONAL USE ONLY

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nax Pro LV3200 Epoxy Primer Surfacer is a two component quick drying epoxy primer. It provides excellent adhesion to multiple metal substrates. Excellent moisture and chemical resistance. Can be used as wet on wet or sanding.

Suitable	Substrates					
Existing finis Steel, Stain	shes less Steel	Electro-coat (ED) Galvanized Steel,	Aluminum	Polyester lar nax polyeste	ninates r bodyfillers & ρι	ıtties
	1 nax Pro LV320 1 nax Pro LV320	0 Epoxy Primer Hardener	-			
	Spray-gun setup: Gravity fed 1.2-1.4	mm	Application I 1.7 - 2.2 ba HVLP max 0.6-0	Pressure: ar │ 28-30 psi 0.7 bar (8-10 psi) at	At spray-c	gun air inlet
	1 coat wet on wet 2 - 3 coats sanding		μm	20-30 µm	/ coat	
	Between coats: 5 - 10 minutes at 20	0°C 70°F	10 - 15 mir	nutes at 20°	C 70°F	
	Dry to re-coat Dry to sand	20°C (70°F) 15-30 min. 3 hours	30°C (86°F) 10-20 min. 2 hours	40°C (100°F) 5-10 min. 1.5 hours	60°C (140°F) N/A 45 min.	Infra-Red n/a 4+8 min
	Final dry sanding: P400- P500		Fi P8	inal wet sandir 800-P1000	ıg:	
	Re – coatable with: With all nax Pro / Pro LV With nax E ³ WB and Pre	' and Premila surfa mila topcoat syste	ice preparation p ms	products		
	nax Pro LV3200 Epoxy p nax Pro LV320 Hardene	primer r	2 years 2 years			
Voc	2004/42/IIB(c)(540)537 ► The EU limit value for t ► The VOC content of th	this product (product is product in ready to	category: IIB.c) in use form is maxir	n ready to use form mum	is max 540 537) g/liter
	Use suitable respirat	tory protection				
	Nippon Paint Automotive	Refinishes recom	mends the use o	of fresh air supply	respirator.	

Read complete TDS for detailed product information





nax Pro LV3200 Epoxy Primer Surfacer is a two component quick drying epoxy primer. It provides excellent adhesion to multiple metal substrates. Excellent moisture and chemical resistance. Can be used as wet on wet or sanding.

Suitable S	Substrates (Surfacers)						
Existing fini Steel, Stain	Existing finishesOEM Electro-coat (ED)Polyester laminatesSteel, Stainless SteelGalvanized Steel, Aluminumnax polyester bodyfillers & polyester bodyfillers						
Product a	Product and Additives						
Product Hardener	nax Pro LV 3200 Epoxy Pri nax Pro LV 320 Epoxy Haro	mer Surfacer dener	Temperature ran 10-40°C	ge			
Basic Rav	v Materials						
	nax Pro LV3200 Epoxy Prir nax Pro LV320 Epoxy Hard	ner Surfacer lener					
Surface p	reparation						
	 Prior to any surface Use clean quality ratio Apply sufficient degradaments 	e preparation remove oily contam ags or wiping towels, one for wet greaser to keep the surface wet a	ination using nax solventborne de ing and one for drying. nd wipe degreaser off before it ca	greaser. n evaporate			
	 Removal of existing 	g finish and initial sanding of poly	ester bodyfiller/putty	P120			
The second secon	 Feather edge befor 	e polyester/putty and finish, sand	ling for complete panel priming	P220			
	 Feather edge and f 	inal step for primer/surfacer for s	pot repairs, (ED) coated parts	P320			
	 Abrasive blasted st 	eel		SA 2.5 - 3.0			
	 Prior to epoxy primer 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 o	dry sanding steps.					
Mixing							
	Mixing Machine For best performance, stir p machine twice a day for 15	primer on mixing minutes	Product Mix Stir well, after each added comp	ponent.			
	Volume Weight <u>1</u> <u>100</u> nax Pro LV <u>1</u> <u>52</u> nax Pro LV	/3200 Epoxy Primer Surfacer /320 Epoxy Hardener					
Notes:	Stir after each added component						
Viscosity	(DIN 4 Cup)						
			20°C (70°F) 30°C (86°F)				
			14-15 sec 16-18 sec				
$ \langle \rangle \rangle^{s}$							

Notes:





Pot Life 20°C (70°F) 40°C (100°F) 30°C (86°F) 6 hours 4 hours 2 hours Notes:

Spray gun set-up / application pressure

		Spray-gun type	Nozzle size	Application pressure
>1	•	Gravity (HVLP, LVLP)	1.2-1.4 mm	Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)

Notes:

Application

			Number of coats
•	Sanding	Depending on required film build	2-3 coats
→	Wet on Wet		1 coat
Sanding	Apply one n Apply the 2 ^r Where a ful	nedium coat over the sanded repair area, then and and 3 rd wet coat within each previous coats a panel application is required apply 2-3 coats o	allow to flash for 5-10 minutes Illowing 5-10 min between coats. over the total panel.
Wet on Wet	Apply one fl	owing coat over the panel	
: Allow each coat Apply product a	to flash-off naturally bove 15°C and belo	v until the surface is completely matt, Do not force-dry by air w 80%RH.	support
Proper flash off	helps achieving higl	her film build.	
Flash-off time d	epends on ambient	temperature, applied layer thickness and airflow.	
For maximum b	uild use large fluid ti	p and lower the application pressure.	

Drying time

\bigcirc		20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	IR
(\checkmark)	Dry to recoat with bodyfiller	30 min.	20 min	10 min	n/a	n/a
5 7	Dry to recoat with Surfacer or topcoat	15 min.	10 min.	5 min.	n/a	n/a
	Dry to sand	3 hours	2 hours	1.5 hour	45 min.	4+8 min.
Notes:	Recoat within 12 hour. After 12 hours of drying the prime Allow 10 minutes flash off prior to Infra-Red drying.	er must be abraded	prior to proceedin	g applications.		

Film thickness

ų,	
Ŷ	

Using the recommended application technique 20-30 µm/coat

Notes:

To obtain the best corrosion protection over bare steel, the recommended minimum DFT is 80 μ m.

Final sanding

In case	as sanding application nax Pro LV3200 Epoxy PS can be sanded as follows:	
•	Finishing dry sanding steps in case of surfacer application:	P320
•	Finishing dry sanding steps in case of topcoat application:	P400-P500
> > >	Prior to SB topcoat application degrease the surface using nax solventborne Prior to WB basecoat application degrease the surface using nax E ³ WB Silic 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 be	degreaser. cone Off. fore it can evaporate



Respect 100 grit maximum jump in dry sanding steps





Re-coating



With all nax Pro / Pro LV and Premila surface preparation products (incl. polyester bodyfillers/putty) With nax E³ WB basecoat and Premila topcoat systems

Coverage

Notes:



By using the recommended application, the theoretical material coverage is: ± 13 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 or nitrocellulose solvents

Solvent Content

	2004/42/IIB(c)(540)537		
VOC	The EU limit value for this product (product category: IIB.c) in ready to use form is max	540	g/liter
	The VOC content of this product in ready to use form is maximum	537	g/liter

Shelflife				
\frown	nax Pro LV3200 Epoxy primer		2 years	
	nax Pro LV320 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.

OAR.04.010. 300517

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BODY FILLERS







Description nax Pro Multifunctional Lightweight Bodyfiller is a 2 component fast drying polyester bodyfiller. Designed to fill and finish dents and surface irregularities in automotive collision repair. Variable hardener ratio to adopt application time or temperature. Provides excellent application, easy sanding an over knifing. Gives excellent adhesion to multiple substrates. **Suitable Substrates** Steel, galvanized steel, aluminum OEM Electro-coat (sanded) nax epoxy primers **Existing finishes** Plastics (except pure PP, PE) Polyester laminates nax Pro Multifunctional Lightweight Bodyfiller 100 2-3 nax Hardener For Polyester 1 - 3 coats (without sanding between coats) 5 mm (max) after sanding _∏ μm 3 – 6 min. application time at 20°C Between coats: Before IR drying: minutes at 20°C 70°F 20°C 70°F minutes at 5 10 Dry to sand 30°C (86°F) 40°C (100°F) 20°C (70°F) Infra-Red 20-30 min 15-20 min 10- 15 min 4+6 minutes Dry sanding by block Dry sanding by machine P120- P220 P120 - P220 Re – coating After sanding it can be finished with a finer polyester, nax Pro bodyfiller/putty or nax Spot Filler With all nax Pro LV and Premilla primers, fillers and surfacers nax Pro Multifunctional Lightweight Bodyfiller 1 year nax Hardener For Polyester 1 1/2 years 2004/42/IIB(b)(250)90 250 The EU limit value for this product (product category: IIB.b) in ready to use form is max g/liter VOC 90 The VOC content of this product in ready to use form is maximum Use suitable respiratory protection Nippon Paint Automotive Refinishes recommends the use of fresh air supply respirator. For detailed information read entire TDS





nax Pro Multifunctional Lightweight Bodyfiller is a 2 component fast drying polyester bodyfiller. Designed to fill and finish dents and surface irregularities in automotive collision repair. Variable hardener ratio to adopt application time or temperature. Provides excellent application, easy sanding an over knifing. Gives excellent adhesion to multiple substrates.

Suitable Substrates		
Steel, galvanized steel, aluminum Polyester laminates	OEM Electro-coat (sanded) Existing finish	nax epoxy primers Plastic (except pure PP, PE)

Product and Additives

Product	nax Pro Multifunction Lightweight Bodyfiller
Hardener	nax Hardener for Polyester

unsaturated polyester resin peroxide

Initial surface preparation

* * *	Prior to any surface preparation, degrease the repair area using nax Pro LV100 Univer Use clean quality rags or wiping towels, one for wetting and one for drying the surface. Apply sufficient degreaser to keep the surface wet. Wipe degreaser off before it can evaporate.	rsal Degreaser.
►	Remove of existing finish till bare substrate	P120
►	Feather edge before polyester body filler / putty application	P220
►	In case of single large repair area initial sanding prior to P120 can be performed with	P80
► ►	Prior to polyester bodyfiller application degrease the area using nax solvent borne deg Use clean quality rags or wiping towels, one for wetting and one for drying the surface.	reaser.

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 best performance mix up newly opened

Mixing



Product Mix ►

can and keep lid closed after use



Mix By Weight ► Adding to low or to high amount of hardener will

negatively affect product performance

\square +	Mixing ratio	Product
	100	nax Pro Multifunctional Lightweight Bodyfiller
	2-3	nax Hardener for Polyester

Pot Life

$(\land \land)$		20°C(70°F)	30°C(86°F)	40°C(100°F)
1	▶ 2%	5-6 min.	4-6 min.	3-4 min.
A	▶ 3%	3-4 min.	3-4 min.	2-3 min.

Application



Maximum number of applied coats	1-3
Maximum DFT after sanding	5mm
Apply as smooth as possible and scrape away the edges	

Notes:

Only apply polyester bodyfiller/putty over properly sanded and degreased bare metal.

Repair system requiring the highest quality and corrosion protection bodyfiller/putty should be applied on epoxy primer Polyester bodyfiller/putty must not be applied over acid containing primer (etch primer)





Drying time

		20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	Infra Red
•	Dry to sand	20-30 min	15-20 min	10-15 min	10 min	4+6 min

Final Sanding

e	 Initial block (dry) sanding of polyester bodyfiller/putty Final block (dry) sanding of polyester bodyfiller/putty 	P120 P220
	 Final machine (dry) sanding of polyester bodyfiller/putty Feather edge and final sanding step before spraying primer/surfacer Additional sanding step for spot repairs and soft coatings 	P220 P320 P400
	 Prior to primer surfacer application degrease the area using nax solvent born 	e 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.

Use guide coat between sanding steps. Do not wet-sand polyester bodyfiller/putty or use waterborne cleaner as it is very porous and will absorb and retain water.

Re-coating



After sanding it can be finished with a finer polyester nax Pro bodyfiller/putty or nax Spot Filler With all nax Pro LV and Premilla primers, fillers and surfacers

Equipment cleaning

Solvent borne gun cleaners or nitrocellulose thinners

Solvent Content

voc

2004/42/IIB(b)(250)90

The EU limit value for this product (product category: IIB.b) in ready to use form is max250g/literThe VOC content of this product in ready to use form is maximum90g/liter

Shelflife

	nax Pro Multifunctional Lightweight Boo	dyfiller	1 year	
	nax Hardener for Polyester		1 ½ 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	C (70°F).Avoid extreme temperature fluctuation	п.

Page 46





nax Pro LV 2000 Light Filling Putty is 2K multi substrate polyester putty designed to fill dents and surface irregularities in collision repair. Variable hardener ratio to adopt application time or temperature. Provides easy application from small to large repair areas and easy workability and sanding for the user. Suitable for common metal substrates used on passenger cars.

Suitable S	Substrates				
Steel, alumi Polyester la	inum and galvanized minates	OEM Electro-coat (san Existing finishes	nded)	nax epoxy primers Plastics (except pure	PP, PE)
	100nax Pro LV22-3%nax Harden	2000 Light Filling put er for Polyester	ty		
	 1 – 3 coats (without san 5-8 minutes application t 	iding between coats) ime at 20°C	μm	5 mm (max) a	fter sanding
$(\mathbf{x},\mathbf{y},\mathbf{y},\mathbf{y},\mathbf{y},\mathbf{y},\mathbf{y},\mathbf{y},y$	Between coats: 10 minutes at	20°C 70°F	Before IR 5 mi	drying: nutes at 20°C 70°	F
	Dry to sand 20°C 25-30	(70°F) 30°C (86°F) min 20-25 min	40°C (10 15-20 m	10°F) nin	Infra-Red 4+6 minutes
	Dry sanding by block P120- P220	Κ.		Dry sanding by mac P120 – P220	hine
	Re coating: With itself or a finer polye With all nax Pro LV and I	ester nax Pro bodyfiller/p Premilla primers, fillers a	outty or nax Sp and surfacers	oot Filler	
	nax Pro LV2000 Light Fil nax Hardener for Polyest	ling putty ter	1 year 1 ½ years		
voc	2004/42/IIB(b)(250)90 ► The EU limit value for t ► The VOC content of this	his product (product categ s product in ready to use f	ory: IIB.b) in rea orm is maximun	ady to use form is max n	250 g/liter 90
	Use suitable respirat Nippon Paint Automotive	ory protection Refinishes recommend	ls the use of fr	esh air supply respirato	r.





nax Pro LV2000 Light Filling Putty is 2K multi substrate polyester putty designed to fill dents and surface irregularities in collision repair. Variable hardener ratio to adopt application time or temperature. Provides easy application from small to large repair areas and easy workability and sanding for the user. Suitable for common metal substrates used on passenger cars.

Suitable Substrates		
Steel, galvanized steel, aluminum	OEM Electro-coat (sanded)	nax epoxy primers
Polyester laminates	Existing finish	Plastic (except pure PP, PE)

Product and Additives

Product	nax Pro LV2000 Light Filling Putty
Hardeners	nax Hardener for Polyester

unsaturated polyester resin peroxide

Initial Surface preparation

> > >	Prior to any surface preparation, degrease the repair area using nax Pro LV100 Univer Use clean quality rags or wiping towels, one for wetting and one for drying the surface. Apply sufficient degreaser to keep the surface wet. Wipe degreaser off before it can evaporate.	sal Degreaser.
►	Remove of existing finish till bare substrate	P120
•	Feather edge before polyester body filler / putty application	P220
•	In case of single large repair area initial sanding prior to P120 can be performed with	P80
* * *	Prior to polyester bodyfiller application degrease the area using nax solvent borne degr 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	reaser. n evaporate

Notes:

Respect 100 grit maximum jump in dry sanding steps.

Mixing



Product Mix

For best performance mix up newly opened can and keep lid closed after use



Mix By Weight

►

Adding to low or to high amount of hardener will negatively affect product performance

\square +	Mixing ratio	Product
	100	nax Pro LV2000 Light Filling Putty
	2-3	nax Hardener for Polyester

Pot Life

$(\land \land)$			20°C(7	′0°F)	30°(C(86°F)	40°C	(100°F)
1	•	2% Hardener	6-8 r	nin	5-6	min	3-4	min
\bigcirc	•	3% Hardener	5-6 r	nin	4-5	min	2-3	min
(\bigcirc)								

Notes:



nax Pro LV2000 Light Filling Putty



Application

(
	\square	
1	~	1
	16	N.

Maximum number of applied coats without sanding	3
The recommended maximum DFT after sanding	5mm
Apply as smooth as possible and scrape away the edges	

Notes:

Only apply polyester bodyfiller/putty over properly sanded and degreased bare metal. Repair system requiring the highest quality and corrosion protection bodyfiller/putty should be applied on epoxy primer Polyester bodyfiller/putty must not be applied over acid containing primer (etch primer)

Drying time

		20°C(70°F)	30°C(86°F)	40°C(100°F)	Infra Red
(\checkmark)	Dry to sand	25-30 min	20-25 min	15-20 min	4+6 min

Final Sanding

•	Initial block (dry) sanding of polyester bodyfiller/putty Final block (dry) sanding of polyester bodyfiller/putty	P120 P220
•	Final machine (dry) sanding of polyester bodyfiller/putty	P220
►	Feather edge and final sanding step before spraying primer/surfacer	P320
►	Additional sanding step for spot repairs and soft coatings	P400



►

►

Prior to primer surfacer application degrease the 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. Use guide coat between sanding steps.

Do not wet-sand polyester bodyfiller/putty or use waterborne cleaner as it is very porous and will absorb and retain water.

Re-coating



VOC

With itself and after sanding, with a finer polyester nax Pro bodyfiller/putty or nax Spot Filler With all nax Pro LV and Premilla primers, fillers and surfacers

Equipment cleaning

Solvent borne gun cleaners or nitrocellulose thinners

Solvent Content

1

2004/42/IIB	(b)	(250)90
	/	<u> </u>	/

The EU limit value for this product (product category: IIB.b) in ready to use form is max	250	g/liter
The VOC content of this product in ready to use form is maximum	90	g/liter



nax Pro LV2000 Light Filling Putty



Shelflife

	nax Pro LV2000 Light Filling Putty		1 year	
	nax Hardener for Polyester		1 ½ years	
	Minimum storage temperature:	5°C (41°F)	Maximum storage temperature:	35°C (95°F)
Notes:	Product shelf-life is determined when products a	are stored unopened at	20°C (70°F). Avoid extreme temperature fluctuati	on.

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nax Spot Filler (1K Acrylic) is a finishing knifing putty, designed to fill small scratches and pinholes those occurring in polyester bodyfillers/putties, primer surfacers and existing finishes.



For detailed information read entire TDS





nax Spot Filler (1K Acrylic) is a finishing knifing putty, designed to fill small scratches and pinholes those occurring in polyester bodyfillers/putties, primer surfacers and existing finishes.

Suitable Substrates						
Polyester bodyfiller / putty Primer surfacers		Existing finishes (incl. TPA)	Polyester laminates			
Notes:	Do not apply it on any metal substrates In case of pinholes in the polyester bodyfiller/putty, for best result apply nax Spot Filler before the primer surfacer application.		e the primer surfacer application.			

Surface preparation

►



►	Polyester bodyfiller / putty	P220
►	Polyester laminates / existing finishes	P320-P400



Notes:

• Prior to nax Spot Filler application degrease the 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

Respect 100 grit maximum jump in dry sanding steps.

Application

Notes:

Maximum number of applied coats1-3Maximum DFT after sanding30-50 μm/layerApply it with a knifing technique and as smooth as possible30-50 μm/layer

Do not apply directly on any metal substrate.

Drying time

Final Sanding

	•	When applied on bodyfiller When applied on polyester laminates / existing finishes	P320-P400 P320-P400 P400 P500
	> >	When applied on bodyfiller	n/a
e	•	Before topcoat in case of small pinholes	P800/P1000
	> >	Prior to primer surfacer application degrease the area using nax solvent Use clean quality rags or wiping towels, one for wetting and one for dryi Apply sufficient degreaser to keep the surface wet and wipe degreaser	t borne degreaser. ng the surface. off before it can evaporate



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

Do not wet-sand polyester bodyfiller/putty or use waterborne cleaner as it is very porous and will absorb and retain water.





Re-coating



With all nax Pro LV and Premilla primers, fillers and surfacers With nax E³ WB and nax Premilla topcoat systems

Equipment cleaning

Solvent borne gun cleaners nitrocellulose thinners

Solvent Content



2004/42/IIB(b)(250)430

The EU limit value for this product (product category: IIB.b) in ready to use form is max 250 g/liter The VOC content of this product in ready to use form is maximum 90 g/liter

Notes:

Not complaint with the requirements of Directive 2004/42/CE.

Shelflife



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CLEANERS & DEGREASERS







Degreaser with antistatic properties designed especially for plastic parts to minimize the static charge caused by friction from the cleaning cloth during degreasing. It easily removes grease, silicon, dirt, and oil and it can also be used for cleaning bare metal, primer surfacers or existing finishes.

Suitable Substrates

All type of plasticsExisting finishes, except TPA like finishesPrimers and surfacersSteel, aluminum, galvanized steel (GI), stainless steeland Electro deposition coat (ED)Environment of the surfacers

Application Method 1 Wipe degreaser off with clean dry cloth before it can evaporate Wet surface usingclean wet cloth Notes: In case of heavy contamination surface should be degreased twice, with a clean wet and wipe-off cloth each time. Let surface flash off for 5-10 minutes before proceeding application to allow residual degreaser to evaporate from surface. Or Application Method 2 Wipe degreaser off with clean dry cloth before it can evaporate Apply with spray atomizer In case of heavy contamination surface should be degreased twice, with a clean wipe-off cloth each time. Notes: Let surface flash off for 5-10 minutes before proceeding application to allow residual degreaser to evaporate from surface. Product storage Minimum storage temperature: 5°C (41°F) Maximum storage temperature: 35°C (95°F) Shelf life: 2 years /20°C Notes: Product shelf-life is determined when products are stored unopened at 20°C (70°F). Avoid extreme temperature fluctuation and direct exposure to sunlight. Solvent Content 2004/42/IIB(a)(850)847 850 The EU limit value for this product (product category: IIB.a) in ready to use form is max voc 847 The VOC content of this product in ready to use form is maximum g/liter Health & Safety Use suitable personal protection equipment

Always degrease in a well ventilated area.

Wear solvent resistant gloves, safety eyewear, and proper respiratory protection.

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Polyester bodyfillers & putties

Primers and surfacers

Description

nax Pro LV100 Universal Degreaser is an excellent multi use degreaser designed to efficiently clean all types of substrates found in automotive refinishes. It easily removes heavy contamination of grease, silicon, dirt, and oil. Efficient first step degreaser of the surface preparation process.

Suitable Substrates

Existing finishes, except TPA like finishes OEM Electro-coat (ED) Steel, aluminum, galvanized steel (GI) and stainless steel

Application Method 1 Wipe degreaser off with clean dry cloth before it can evaporate Wet surface with new wet cloth In case of heavy contamination surface should be degreased twice, with a clean wet and wipe-off cloth each time. Notes: Let surface flash off for 5-10 minutes before proceeding application to allow residual degreaser to evaporate from surface. Or **Application Method 2** Wipe degreaser off with clean dry cloth before it can evaporate Apply with spray atomizer Notes: In case of heavy contamination surface should be degreased twice, with a clean wipe-off cloth each time. For optimum surface cleaning nax Pro LV100 Universal Degreaser should be proceeded by nax E³ WB Degreaser as an after wipe. This will reassure the removal of all the residual contaminations from the surface. Let surface flash off for 5-10 minutes before proceeding application to allow residual degreaser to evaporate from surface **Product storage** Minimum storage temperature: 5°C (41°F) Maximum storage temperature: 35°C (95°F) Shelf life: 24 months/20°C Notes: Product shelf-life is determined when products are stored unopened at 20°C (70°F). Avoid extreme temperature fluctuation and direct exposure to sunlight. Solvent Content

voc

2004/42/IIB(a)(850)780

The EU limit value for this product (product category: IIB.a) in ready to use form is max The VOC content of this product in ready to use form is maximum

Health & Safety



Use suitable personal protection equipment

- Always degrease in a well ventilated area.
- Wear solvent resistant gloves, safety eyewear, and proper respiratory protection.

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850

780

g/liter



ANCILLARIES







Nax Pro LV 4200 flexible Additive Gives flexibility to the paint to suit application on flexible surfaces. Mainly used in paint application on plastic parts. Canbe use also elasticise paint coatings on the metal eliminates exposed to stone chipping

Suitable Substrates							
Primer Surfa	acer Topcoats	Clea	Clearcoats				
	Ready to use						
	Flexible Additive use mixture of the Topcoats including Hardener and Thinner 10 – 30% maximum Example : 1Litter Mixture of Topcoats with Hardener and Thinner add 10% Flexible Additive 100ml						
	Spray-gun setup:	Application Press	sure:				
	Gravity fed 1.2-1.4 mm	1.7-2.2 bar 2	8-30 psi At spray-gun air inlet				
(HVLP max 0.6-0.7 bar(8-1	l0 psi) at the air cap				
	Application With : Primer Surfacer Clearcoats, and Topcoats	μm	Primer Surfacer Clearcoats, Topcoats				
Health & Safety Use suitable personal protection equipment • Always spray in Spraybooth • Wear spray overall, solvent resistant gloves, and fresh air supply respiratory protection.							
Equipmen	t cleaning						
	Solvent borne guncleaners						
Product storage							
Minimum storage 5°C (41°F) temperature:		Maximum storage temperature:	40°C (100°F)				
Notes: Product shelf-life is determined when products are stored unopened at 20°C (70°F). Avoid extreme temperature fluctuation.							
Shelf life	Nax Pro LV4200 Anti-Silicone	24 months					





nax Pro LV4100 Anti-Silicone added to paint prevents the formation of craters (fish eyes/pinholes) in case the surface is contaminated with silicone or by greasing.

Suitable	Products	
Pro LV Clea	rcoats Pro LV Topcoats	
	Anti-Silicone is added to the mixture of the RTS Pro	LV clearcoats/topcoats in the amount of 2-4%
	Example: To 1Lt RTS of Clearcoat with Hardener a	nd Thinner, add 20ml (2%) Anti-Silicone
	nax Pro I V/4100 Anti-Silicone does not affect produ	uct drying
	nav Pro I V/1100 Anti-Silicone does not affect produ	ict spray viscosity, but may reduce paint flow at
ι s	application.	or spray viscosity, but may reduce paint now at
O	nax Pro LV4100 Anti-Silicone does not affect pot lif	e.
	Use suitable respiratory protection	
	Ninnon Paint Automotive Refinishes recommends	he use of fresh air supply respirator
	nax Pro LV4100 Anti-Silicone	2 years
$(\Box\Box\Box)$ -	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 2	0°C (70°E) Avoid extreme temperature fluctuation

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

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Nax Topcoat Blending Thinner is a special blend of solvents to support the melting of the refinishing 2K Acrylic topcoat and clearcoat into the existing finish to provide a smooth fadeout zone



Ready to use

20°C(70°F) 11-12 sec. S

Method 1 : apply a thin layer of the fade-out thinner immediately after applying each coating of the clearcoat or topcoat Method 2 : apply a thin layer of the blending thinner immediately after applying last coating of the clearcoat or topcoat



Spray-gun setup: Gravity 1.2-1.3 mm fed

Application Pressure: 1.2-1.5 bar 28-30 psi

At spray-gun air inlet



1 x 2 coat 1-2 medium coat HVLP max 0.6-0.7 bar(8-10 psi) at the air cap Between coats: 3 - 5 at



Use suitable personal protection equipment Always Spray in a well ventilated area and Spray Booth.

Wear solvent resistant gloves, safety eyewear, and proper respiratory protection.



Nax Topcoat Blending Thinner

24 months

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naxProLV 4000 Acceleratorreduces the drying and curing time of two-component acrylic and polyurethane products. It is specially recommended for low temperature and high air humidity applications.

Suitable Products						
2K Clearcoa	ts 2K Topcoats					
	Acceleratoris added to the mixture of the RTS 2K topcoats/clearcoatsin the amount of 1 – 1.5% Example: 1liter mixture of RTS topcoatadd 1% (10ml)accelerator.					
	Accelerator reduces the two-component Product drying					
(, s	Accelerator Does not affect product spray viscosity					
	nax LV4000 Accelerator reduces pot life: Hence add directly before application					
	Use suitable respiratory protection					
	Nippon Paint Automotive Refinishes recommends the use of fresh air supply respirator.					
\frown	nax Pro LV4000 Accelerator 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.					

OAR.08.010. 300517

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OTHER







nax Pro LV1201 Matt Black Aerosol is single component fast drying thermoplastic acrylic aerosol matt black with smooth finish. Designed for easy application on window frames, sills, bottom of bumpers, inside wheel arches or underneath of the chassis.

Suitable	Substrates						
Existing finishes		Epoxy primers	Primer surfacer				
	Ready to spray			Only requires a s	hake t	pefore	use
	2 – 3 even coats		μm	15 - 20	μm	/ coa	t
	Between coats: 5 - 10 minutes at 2	20°C 70°F					
	Dry to handle		20°C (70 50-60 m	°F) 30°C (86°F) in 30-40 min		40°C 20-30	(100°F)) min
	Re – coating: With all nax clearcoat						
	Nax Pro LV1201 Matt Bl	ack Aerosol	2 Years				
Voc	2004/42/IIB(e)(840)715 The EU limit value for this p The VOC content of this pr	product (product catego oduct in ready to use for	ry: IIB.e) in rea m is maximum	dy to use form is max	877	340 715	g/liter
	Use suitable respirat	tory protection	ends the use o	of fresh air supply resp	birator.		

For detailed information read entire TDS





Description						
nax Pro LV	1201 Matt Black Aerosol is single component fast drying the	ermoplastic acrylic aerosol matt black.				
Suitable S	ubstrates					
Existing finis	h Epoxy primers	Primer surfacers				
Product						
Product	Nax Pro LV1201 Matt Black Aerosol (Acrylic)	Acrylic resin				
Final surfa	ce preparation					
	 Finishing dry sanding step Initial dry sanding step may be executed with a coarser 	P500 grit: P320/P400				
	 Finishing wet sanding steps: Initial dry sanding step may be executed with: Initial wet sanding step may be executed with: 	P1000 P320/P400 P800				
	 Prior to matt black 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 to grit maximum jump in dry sanding steps and 200 grit maximum j. Use guide coat to control sanding. 	ump in wet sanding steps.				
Product pr	reparation					
	Ready to spray	Shake thoroughly before use Shake for several minutes after the mixing ball has loosened				
Applicatio	n					



Distance to surface: 12 – 18 cm

Apply even wet coats over the required areas, with 5-10 minutes flash off between coats



Number of coats: 2-3

Apply even wet coats over the required areas, with 5-10 minutes flash off between coats

Film thickness



Using the recommended application technique

10 – 15 µm/coat





Drying time

\mathbf{i}			20°C (70°F)	30°C (86°F)	40°C (100°F)
1	►	Dry to handle	50-60 min	30-40 min	20-30 min
7	►	Dry to recoat	30-40 min	10-20 min	5-15 min

Re-coatable



All nax clearcoats

Equipment cleaning



After use invert aerosol and spray for 5 second to clean nozzle.

Solvent Content

voc	 2004/42/IIb(e)(840)715 The EU limit value for The VOC content of th 	840 715	g/liter				
Product s	torage						
Minimum st temperature	orage e:	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.						
Shelflife							
	Nax Pro LV1201 Matt E	Black Aerosol	2 years				

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