NIPPON PAINT

nax PRO LV

nax PRO LV

Technical Data Sheets

P: 1800 810 114 | nipponpaintautomotive.com.au

Contents

CLEARCOATS

Description

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:

Gravity fed | 1.2-1.3 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 coats

45-60 µm 1 ½ coat

Between coats:

3 - 5 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 (86°F)	40°C (100°F)	60°C (140°F)	Infra-Red
Dust dry	20 min	10 min	7 min	n/a	n/a
Dry to handle	7 hrs	3 hrs	1 hrs	15 min	4+8 min
Dry to polish	7 hrs	3 hrs	1 hrs	15 min	4+8 min

nax Pro LV7600 VHS Performance Clear	2 years
nax Pro LV760 Hardeners	1 year

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

- 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

Use suitable respiratory protection

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

For detailed information read entire TDS

Description

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.*

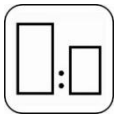
Product and Additives

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	Acrylic resins
nax Pro LV760 Hardeners	Poly-isocyanate resin

Mixing



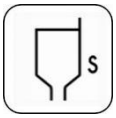
2	nax Pro LV7600 VHS Performance Clear
1	nax Pro LV760 Hardeners

Hardener Selection

	15-20°C	20-25°C	25-35°C
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°C (86°F)	40°C (100°F)
15-17 sec	14-15 sec	13-14 sec

Pot Life

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

Spray gun set-up / application pressure

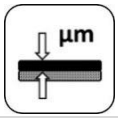
Spray-gun type	Spray-gun type	Nozzle size	Application pressure
▸ LVLP	Gravity	1.2-1.3 mm	1.7-2.2 bar at the spray gun air inlet
▸ HVLP	Gravity	1.2-1.3 mm	(HVLP: max 0.6-0.7 bar at the air cap)

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 ½ coat application	Using the recommended application technique	45-60 µm

Drying time

Dust dry	**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
▸ Fast Hardener	20 min.	10 min	7 min	n/a	n/a
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.

Notes:

Coverage

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

▸ ±10 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 guncleaners

Solvent Content

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

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

Shelflife

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 are stored unopened at 20°C (70°F).Avoid extreme temperature fluctuation.*

OAR.07.012. 300517

Professional use only

Description

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 Clear
1	nax Pro LV740 Hardeners
0-10%	nax Pro LV5000 Thinners

Spray-gun setup:

Gravity fed | 1.2-1.4 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 coats w/o thinner

2 - 3coats with thinner

45-60	µm	1 ½ coat
50-60	µm	2 coats
60-75	µm	3 coats

Between coats:

3 - 5 minutes at | 20°C | 70°F

Before 60°C (140°F) baking:

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	10-20 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 year
nax Pro LV5000 Thinners	2 years

VOC

2004/42/IIb(e)(840)545

- 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

Use suitable respiratory protection

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

For detailed information read entire TDS

Description

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.*

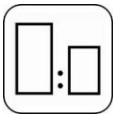
Product and Additives

Product	nax Pro LV7400 HS Clear	
Hardener	nax Pro LV740 Hardener Fast	15-20°C
	nax Pro LV740 Hardener Medium	20-25°C
	nax Pro LV740 Hardener Slow	30-40°C
Solvents	nax Pro LV5000 Thinner Fast	15-20°C (1-2 panel)
	nax Pro LV5000 Thinner Medium	20-25°C (3-5 panel)
	nax Pro LV5000 Thinner Slow	30-40°C (>5 panel)
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	Acrylic resins
nax Pro LV740 Hardener	Poly-isocyanate resin
nax Pro LV5000 Thinners	Blend of solvents

Mixing

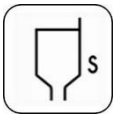


2	nax Pro LV7400 HS Clear
1	nax Pro LV740 Hardener
0-10%	nax Pro LV5000 Thinners

Hardener/Thinner selection			
Surface	**15-20°C**	**20-25°C**	**25-35°C**
1-2 panels/spot	Fast/Fast	Med./Fast	Med./Med.
3-5 panels	Fast/Fast	Med./Med.	Med./Slow
>5 panels	Fast/Med	Med./Slow	Slow/Slow

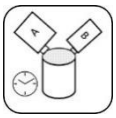
Notes: *Stir after each added component*

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
▸ With Thinner	15-17 sec	14-16 sec	13-15 sec

Pot Life



	20°C(70°F)	**30°C(86°F)**	**40°C(100°F)**
▸ Slow / Medium Hardener	2 hours	1.5 hours	1 hours
▸ Fast Hardener	30 Min	25 min	20 min

Spray gun set-up / application 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
▸ HVLP	Gravity	1.2-1.4 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 1-3 minutes. Apply the 2nd flowing coat.
2-3 coat 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.*

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	n/a
▸ Medium Hardener	25 min.	15 min.	7 min.	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.	4+8 min.
▸ Medium Hardener	8 hours	4 hours	2 hours	30 min.	
▸ Fast Hardener	6 hours	3 hours	1.5 hours	20 min.	

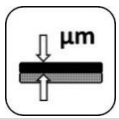
Notes:
Indicated drying times are panel temperatures. Oven temperature should be set 10 °C higher.
Allow 10 minutes flash off prior to Infra-Red drying.
The panel must not reach a temperature above 100°C (210°F) while curing.
Following the drying cycle at 60°C (140°F) object temperature, allow product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



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:

▸ ±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 guncleaners

Solvent Content

2004/42/IIb(e)(840)545

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

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)

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

OAR.07.011. 300517

Professional use only

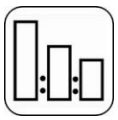
Description

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
1	nax Pro LV720 Hardener
10-20%	nax Pro LV5000 Thinners

Spray-gun setup:

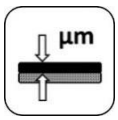
Gravity fed | 1.2-1.3 mm

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



40-50 µm 2 coats

Between coats:

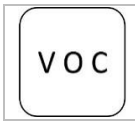
3 - 5 minutes at | 20°C | 70°F

Before 60°C (140°F) baking:

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	15 min	10 min	5 min	n/a	n/a
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

nax Pro LV7200 X'press Clear	2 years
nax Pro LV720 Hardener	1 year
nax Pro LV5000 Thinners	2 years



2004/42/IIb(e)(840)620

- 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

Use suitable respiratory protection

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

For detailed information read entire TDS

Description

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)

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

Product and Additives

Product	nax Pro LV7200 X'press Clear	
Hardener	nax Pro LV720 Hardener	15-35°C
Reducers	nax Pro LV5000 Thinner Fast	15-20°C
	nax Pro LV5000 Thinner Medium	20-25°C
	nax Pro LV5000 Thinner Slow	30-40°C
	nax Pro LV5101 Topcoat Blending Thinner Spray	
	nax Topcoat Blending Thinner	
Additives	nax Pro LV 4000 Accelerator	
	nax Pro LV 4200 Flexible Additive	

Basic Raw Materials

nax Pro LV7200 Xpress Clear	Acrylic resins
nax Pro LV720 Hardener	Poly-isocyanate resin
nax Pro LV5000 Thinners	Blend of solvents

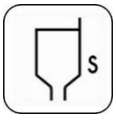
Mixing

2	nax Pro LV7200 Xpress Clearcoat
1	nax Pro LV720 Hardener
10-20%	nax Pro LV 5000 Thinners

Thinner selection			
Job size	**15-20°C**	**20-25°C**	**25-35°C**
1-2 panels/spot	Fast	Medium	Slow
3 panels	Fast/Med.	Med./Slow	Slow

Notes: *Stir after each 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

Pot Life

20°C (70°F)	**30°C** (86°F)	**40°C** (100°F)
30 Min	20 min	15 min

Spray gun set-up / application pressure

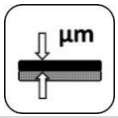
Spray-gun type	Spray-gun type	Nozzle size	Application pressure
▸ LVLP	Gravity	1.2-1.4 mm	1.7-2.2 bar at the spray gun air inlet
▸ HVLP	Gravity	1.2-1.4 mm	(HVLP: max 0.6-0.7 bar at the air cap)

Application

Standard Application
- Apply one medium coat, then allow to flash for 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



2 coats application	Using the recommended application technique	40-50 µm
3 coats application	Using the recommended application technique	60-75 µm

Drying time

	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	Infra-Red
Dust dry	15 min.	10 min	5 min	n/a	n/a
Dry to handle and polish	8 hours	4 hours	2 hour	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

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.*

Equipment cleaning

Solvent borne guncleaners

Solvent Content

2004/42/IIb(e)(840)620

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

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)

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

OAR.07.010. 300517

Professional use only

PRIMERS

Description

nax Pro LV3000 Wash Primer CF Two-pack 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 Substrates

Steel	Galvanized Steel	Aluminum
Existing finishes	Polyester laminates	nax polyester bodyfillers & putties

1 nax Pro LV3000 Wash Primer CF

1 nax Pro LV300 Activator

Spray-gun setup:
Gravity fed | 1.3-1.5 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 coat

5-10 µm /coat

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

Dry to re-coat

20°C (70°F)	30°C (86°F)	40°C (100°F)
10-15 min	5-10 min	3-5 min

Re – coatable with:
With all nax Pro LV and Premila primer fillers and surfacers
With nax Premila 2K topcoat systems

nax Pro LV3000 Wash Primer CF	2 years
nax Pro LV300 Activator	2 years

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

▸ 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	

Use suitable respiratory protection

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

Read complete TDS for detailed product information

Description

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 Substrates

Steel	Galvanized Steel	Aluminum
Existing finishes	Polyester laminates	nax polyester bodyfillers & putties

Product and Additives

Product nax Pro LV3000 Wash Primer CF
Hardeners nax Pro LV300 Activator

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 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 for primer/surfacer for spot repairs, (ED) coated parts	P320
Abrasive blasted steel	SA 2.5 - 3.0

- Prior to wash primer 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.*

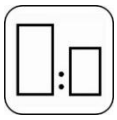
Mixing

Mixing Machine

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

Product Mix

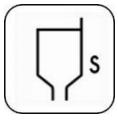
Stir well, after each added component.



Volume	Weight	
1	100	nax Pro LV3000 Wash Primer CF
1	80	nax Pro LV300 Activator

Notes: *Stir after each added component*

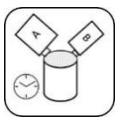
Viscosity (DIN 4 Cup)



20°C (70°F)	30°C (86°F)
18-20 sec	16-18 sec

Notes:

Pot Life



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.*

Spray gun set-up / application pressure

	Spray-gun type	Nozzle size	Application pressure
▸	Gravity	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 between coats on the sanded repair area	

Notes:

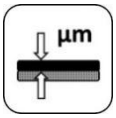
Allow each coat to flash-off naturally, do not force-dry by air support
Flash-off time depends on ambient temperature, applied layer thickness and airflow.
Recommended application condition: 15-35 °C and 20-80% relative humidity

Re-coating time

		20°C(70°F)	30°C(86°F)	40°C(100°F)
▸	At 15µm	15 min	10 min	5 min
▸	Recoat within 7 days			

Notes:

Film thickness



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

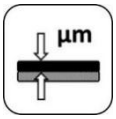
Notes:

Re-coatable

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

Notes:

Coverage



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

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 nitrocellulose solvents

Solvent Content

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

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

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°C (70°F).Avoid extreme temperature fluctuation.*

OAR.03.013. 300517

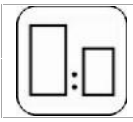
Professional Use Only

Description

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 Substrates

Steel	Galvanized Steel	Aluminum
Existing finishes	Polyester laminates	nax polyester bodyfillers& putties



5 naxPro LV1600 Wash Primer 1K CF

3 nax Pro LV5000 Thinners

Spray-gun setup:

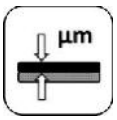
Gravity fed | 1.3-1.5 mm

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

1-3 coat



10-20 µm / coat

Between coats

5 - 10 minutes at | 20°C | 70°F

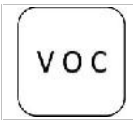
Dry to recoat	20°C (70°F)	30°C (86°F)	40°C (100°F)
nax Pro LV5000 Fast Thinner	10-15 min	-	-
nax Pro LV5000 Medium Thinner	20-30 min	10-15 min	5-10 min
nax Pro LV5000 Slow Thinner	-	20-30 min	10-15 min

Re – coatable with:

With all nax Pro LV and Premilaprimer fillers and surfacers

With naxPremila2K topcoat systems

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



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
- The VOC content of this product in ready to use form is maximum 695

Use suitable respiratory protection

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

For detailed information read entire TDS

Description

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 Substrates

Steel	Galvanized Steel	Aluminum
Existing finishes	Polyester laminates	nax polyester bodyfillers& putties

Product and Additives

Product naxPro LV1600 1K Wash Primer 1K CF
Hardeners naxPro LV5000 Thinners

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

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 for primer/surfacer for spot repairs, (ED) coated parts	P320
Abrasive blasted steel	SA 2.5 - 3.0

- Prior to wash primerapplication 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 wetand wipe degreaser off before it can evaporate

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

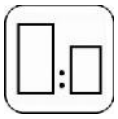
Mixing

Mixing Machine

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

Product Mix

Stir well, after each added component.

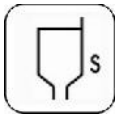


Volume	Weight	
5		naxPro LV 1600 Wash Primer 1K CF
1.5-3		nax LV 5000/Fast/Medium/Slow Thinners

Thinner selection		
Fast	**Medium**	**Slow**
15-18°C	23-25°C	>25°C

Notes: *Stir after each added component*

Viscosity (DIN 4 Cup)



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

Notes:

Pot Life

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

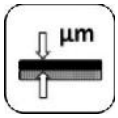
Notes: *Allow each coat to flash-off naturally, do not force-dry by air support*
Flash-off time depends on ambient temperature, applied layer thickness and airflow.
Recommended application condition: 15-35 °C and 20-80% relative humidity

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			

Notes:

Film thickness



▸	Conventional application	Using the recommended application technique	10-20 µm/coat
▸	Airless application	Using the recommended application technique	40-60 µm/coat

Notes:

Final sanding

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

▸ 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

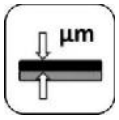
Notes:

Re-coating

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

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

Coverage



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

20 µm	± 10m²/liter RTS mixture at	Spraying Gravity Gun
50 µm	± 04m²/liter RTS mixture at	Airless Spraying

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 nitrocellulose solvents

Solvent Content

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
The VOC content of this product in ready to use form is maximum	695	g/liter

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.*

OAR.03.012. 300517

Professional Use Only

Description

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

Ready to spray

Spray-gun setup:

Gravity fed	1.2-1.4	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 - 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 Pro LV and Premila primer fillers and surfacers

With all nax Premila 2K topcoat systems

nax Plastic Primer 1K — 2 years

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

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

Use suitable respiratory protection

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

For detailed information read entire TDS

Description

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 and aluminum

Notes: *For best adhesion on metal substrates always use etch or epoxy primer.*

Surface preparation

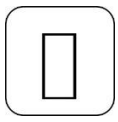
- Prior to any surface preparation, Remove oily contamination using nax Pro LV100 universal degreaser.
- Use clean quality rags or wiping towels, one for wetting and one for drying the surface.
- Apply sufficient degreaser to keep the surface wet.
- Wipe degreaser off before it can evaporate.

- 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 plastic, degrease the area using nax Pro LV300 Anti-Static Degreaser
- Prior to surfacer application on other surfaces, degrease with nax Pro LV100 Universal 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

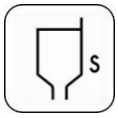


Ready to spray

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

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

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

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)

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

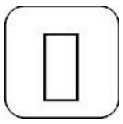
OAR.03.010. 300517
Professional Use Only

Description

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

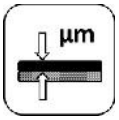
Plastics incl. polypropylene and its blends | Polyester and epoxy laminates | Steel, stainless, galvanized, aluminum



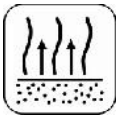
Ready to spray

Only requires a shake before use

1 - 2 coats



5 - 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)
10 min	7 min	5 min

Re – coatable with:

With all nax Pro LV and Premila primer fillers and surafcers

With naxPremila2K topcoat systems

nax Pro LV1001 Plastic Primer 1k Aerosol 2 years

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
- The VOC content of this product in ready to use form is maximum 710

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

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

Surface preparation

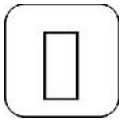
- Prior to any surface preparation, degrease the repair area using nax solvent borne degreaser.
- Use clean quality rags or wiping towels, one for wetting and one for drying.
- Apply sufficient degreaser to keep the surface wet andwipe degreaser off before it can evaporate

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
- 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.
- 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

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

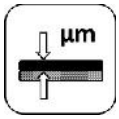
20°C (70°F)	30°C (86°F)	40°C (100°F)
10 minutes	7 minutes	5 minutes

Re-coating

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

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

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

Solvent Content

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

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 products are stored unopened at 20°C (70°F).Avoid extreme temperature fluctuation.*

OAR.03.010. 300517

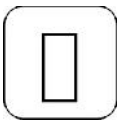
Professional Use Only

Description

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

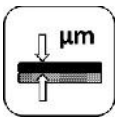
Existing finishes	OEM Electro-coat (ED)	Polyester laminates
Steel	Galvanized Steel	nax polyester bodyfillers& putties
Stainless Steel	Aluminum	



Ready to spray

Only requires a shake before use

2 – 3 coats



15 - 20 µm / coat

Between coats:

5 - 10 minutes at | 20°C | 70°F

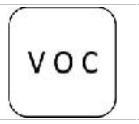
	20°C (70°F)	30°C (86°F)	40°C (100°F)
Dry to recoat	10-15 min	5-7 min	3-5 min
Dry to sand	20 min	15 min	10 min

Re – coatable with:

With all nax Pro LV and Premilaprimer fillers/surfacers and polyesters bodyfillers/putties

Withnax E³ WB and Premilatopcoat systems

nax Pro LV1100 Spot Sealer Aerosol 5 years



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	

Use suitable respiratory protection

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

For detailed information read entire TDS

Description

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	OEM Electro-coat (ED)	Polyester laminates
Steel, Stainless Steel	Galvanized Steel, Aluminum	nax polyester bodyfillers& putties

Product

nax LV 1100 Spot Sealer Aerosol	Epoxy resin

Surface preparation

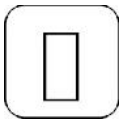
- Prior to any surface preparation, degrease the repair area using nax solvent borne degreaser.
- Use clean quality rags or wiping towels, one for wetting and one for drying.
- Apply sufficient degreaser to keep the surface wet andwipe degreaser off before it can evaporate

Removal of existing finish and initial sanding of polyester bodyfiller/putty	P120
Feather edge before bodyfiller/putty and final sanding for complete panel priming	P220
Feather edge and final step before spraying primer/surfacer for spot repairs	P320
Steel, galvanized steel, stainless steel	P220
Polyester laminates, Aluminum and ED coated panel	P320

- Prior 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



Ready to spray

Shake thoroughly before use

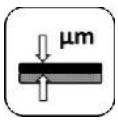
Shake for several minutes after the mixing ball has loosened

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	15-20 µm/coat

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

In case as a sanding application naxSpot Sealer can be sanded as follows:

▸ 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 naxE³ 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 before 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

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

naxPro LV1100 Spot Sealer Aerosol	5 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.03.011. 300517
Professional Use Only

PRIMER SURFACERS

Description

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

3	nax Pro LV3601/04/07 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:

1.7-2.2 bar | 28-30 psi | At spray-gun air inlet

HVLP max 0.6-0.7 bar (8-10 psi) at the air cap

1 coat for WOW	25-35 µm /coat
2 - 3 coats for HB	50-60 µm /coat
1 - 2 coats for XHB	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

	20°C (70°F)	30°C (86°F)	40°C (100°F)	60°C (140°F)	Infra-Red
Dry to recoat (WOW)	30 min.	20 min.	10 min.		
Dry to sand (XHB & HB)	3 hours	2½ hours	1½ hours	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	2 years
nax Pro LV360 Hardener	1 year
nax Pro LV5000 Thinners	2 years

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

- The EU limit value for this product [product category: IIB(c)] in ready to use form is maximum 540 g/liter
- The VOC content of this product in ready to use form is maximum 539 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

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 and Additives

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

Surface preparation

- Prior to any surface preparation remove oily contamination 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.

▸ 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 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*

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.*

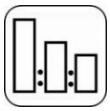
Mixing

Mixing Machine

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

Product Mix

Stir well, after each added component.

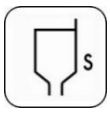


XHB	HB	WOW	
3	3	3	nax Pro LV3601/04/07 VHS Primer Surfacer
1	1	1	nax Pro LV360 Hardener
0.6	0.9	1.2	nax Pro LV5000 Thinners

Thinner Selection			
	15-20°C	20-25°C	25-35°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)
▸ XHB	30-45 sec.
▸ HB	24-28 sec.
▸ WOW	19-23 sec.

Notes:

Pot Life

	20°C (70°F)	30°C (86°F)	40°C (100°F)
▸ XHB & HB	60 min.	40 min.	20 min.
▸ 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)
▸ WOW	Gravity	1.3-1.4 mm	Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)

Application

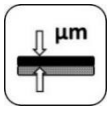
		Number of coats
▸ XHB & HB	Depending on required film build	2-3 coats
▸ WOW		1 coat

Sanding	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.
	Where a full panel application is required apply 2-3 coats over the total panel.
Wet on Wet	Apply one flowing coat on the panel.

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.

Film thickness



▸ XHB	Using the recommended application technique	60-80 µm/coat
▸ HB	Using the recommended application technique	50-60 µm/coat
▸ WOW	Using the recommended application technique	25-35 µm/coat

Drying time

	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	IR
Dust dry	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 3 hours of drying the primer must be sanded prior to proceeding applications.*
Allow 10 minutes flash off prior to Infra-Red drying.
Following the drying cycle at 60°C (140°F) object temperature, allow product to completely cool down to ambient temperature.

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 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 before it can evaporate.

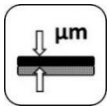
Notes: *Respect 100 grit maximum jump in dry sanding steps and 200 grit maximum jump in wet sanding steps.*

Re-coating

With nax E-Cube WB Basecoat, nax Premila 8000 Basecoat and nax Premila 7000 2K Topcoat (direct gloss)

Notes: *Avoid applying polyester bodyfiller on top of the primer surfacer.*

Coverage



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

±8	m²/liter RTS mixture at	50µm	XHB & HB
±13	m²/liter RTS mixture at	30µm	WOW

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

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

The EU limit value for this product [product category: IIB(c)] in ready to use form is maximum	540	g/liter
The VOC content of this product in ready to use form is maximum	539	g/liter

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)

Notes: *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

Description

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 finishes	Electro-coat (ED)	Polyester laminates
Steel, Stainless Steel	Galvanized Steel, Aluminum	nax polyester bodyfillers & putties

1 nax Pro LV3200 Epoxy Primer
1 nax Pro LV320 Hardener

Spray-gun setup:
Gravity fed | 1.2-1.4 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 coat wet on wet
2 - 3 coats sanding

20-30 µm / coat

Between coats:
5 - 10 minutes at | 20°C | 70°F
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
Dry to re-coat	15-30 min.	10-20 min.	5-10 min.	N/A	n/a
Dry to sand	3 hours	2 hours	1.5 hours	45 min.	4+8 min

Final dry sanding:
P400- P500

Final wet sanding:
P800-P1000

Re – coatable with:
With all nax Pro / Pro LV and Premila surface preparation products
With nax E³ WB and Premila topcoat systems

nax Pro LV3200 Epoxy primer	2 years
nax Pro LV320 Hardener	2 years

2004/42/IIB(c)(540)537
- 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

Use suitable respiratory protection

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

Read complete TDS for detailed product information

Description

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 (Surfacers)

Existing finishes	OEM Electro-coat (ED)	Polyester laminates
Steel, Stainless Steel	Galvanized Steel, Aluminum	nax polyester bodyfillers & putties

Product and Additives

Product	nax Pro LV 3200 Epoxy Primer Surfacer	**Temperature range**
Hardener	nax Pro LV 320 Epoxy Hardener	10-40°C

Basic Raw Materials

nax Pro LV3200 Epoxy Primer Surfacer
nax Pro LV320 Epoxy Hardener

Surface preparation

- Prior to any surface preparation remove oily contamination 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

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 for primer/surfacer for spot repairs, (ED) coated parts	P320
Abrasive blasted steel	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 dry sanding steps.*

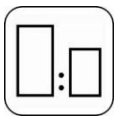
Mixing

Mixing Machine

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

Product Mix

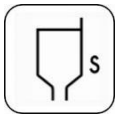
Stir well, after each added component.



Volume	Weight	
1	100	nax Pro LV3200 Epoxy Primer Surfacer
1	52	nax Pro LV320 Epoxy Hardener

Notes: *Stir after each added component*

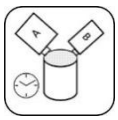
Viscosity (DIN 4 Cup)



20°C (70°F)		**30°C** (86°F)	
14-15	sec	16-18	sec

Notes:

Pot Life



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

Notes:

Spray gun set-up / application pressure

Spray-gun type	Nozzle size	Application pressure
▸ 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 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. Where a full panel application is required apply 2-3 coats over the total panel.
Wet on Wet	Apply one flowing coat over the panel

Notes:

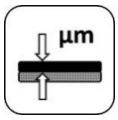
Allow each coat to flash-off naturally until the surface is completely matt, Do not force-dry by air support
Apply product above 15°C and below 80%RH.
Proper flash off helps achieving higher film build.
Flash-off time depends on ambient temperature, applied layer thickness and airflow.
For maximum build 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
Dry to recoat with bodyfiller	30 min.	20 min	10 min	n/a	n/a
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 primer must be abraded prior to proceeding applications.*
Allow 10 minutes flash off prior to Infra-Red drying.

Film thickness



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 µm.*

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 degreaser.
- ▸ Prior to WB basecoat application degrease the surface using nax E³ 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 before it can evaporate

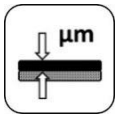
Notes: *Respect 100 grit maximum jump in dry sanding steps*

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

Notes:

Coverage



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

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

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

Professional Use Only

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.

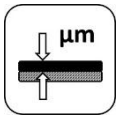
Suitable Substrates

Steel, galvanized steel, aluminum	OEM Electro-coat (sanded)	nax epoxy primers
Polyester laminates	Existing finishes	Plastics (except pure PP, PE)

100 nax Pro Multifunctional Lightweight Bodyfiller
2-3 nax Hardener For Polyester

1 – 3 coats (without sanding between coats)

3 – 6 min. application time at 20°C



5 mm (max) after sanding

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

Before IR drying:
5 minutes at | 20°C | 70°F

Dry to sand

20°C (70°F)	30°C (86°F)	40°C (100°F)	Infra-Red
20-30 min	15-20 min	10- 15 min	4+6 minutes

Dry sanding by block

P120- P220

Dry sanding by machine

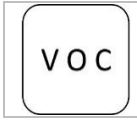
P120 – P220

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 ½ years



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

- 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

Use suitable respiratory protection

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

For detailed information read entire TDS

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
Polyester laminates	Existing finish	Plastic (except pure PP, PE)

Product and Additives

Product	nax Pro Multifunction Lightweight Bodyfiller	unsaturated polyester resin
Hardener	nax Hardener for Polyester	peroxide

Initial surface preparation

- Prior to any surface preparation, degrease the repair area using nax Pro LV100 Universal 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.
- Wipe degreaser off before it can evaporate.

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 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.*

Mixing

- **Product Mix**

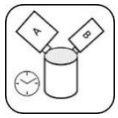
For best performance mix up newly opened can and keep lid closed after use

- **Mix By Weight**

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

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

Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
2%	5-6 min.	4-6 min.	3-4 min.
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

- ▸ Initial block (dry) sanding of polyester bodyfiller/putty P120
- ▸ Final block (dry) sanding of polyester bodyfiller/putty 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

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

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

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

Shelflife

nax Pro Multifunctional Lightweight Bodyfiller	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 (70°F).Avoid extreme temperature fluctuation.*

Description

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 Substrates

Steel, aluminum and galvanized	OEM Electro-coat (sanded)	nax epoxy primers
Polyester laminates	Existing finishes	Plastics (except pure PP, PE)

100 nax Pro LV2000 Light Filling putty
2-3% nax Hardener for Polyester

1 – 3 coats (without sanding between coats)

5-8 minutes application time at 20°C

5 mm (max) after sanding

Between coats:			Before IR drying:		
10 minutes at	20°C	70°F	5 minutes at	20°C	70°F

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

Dry sanding by block:

P120- P220

Dry sanding by machine

P120 – P220

Re coating:

With itself or a finer polyester nax Pro bodyfiller/putty or nax Spot Filler

With all nax Pro LV and Premilla primers, fillers and surfacers

nax Pro LV2000 Light Filling putty	1 year
nax Hardener for Polyester	1 ½ years

VOC

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

- 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

Use suitable respiratory protection

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

For detailed information read entire TDS

Description

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	unsaturated polyester resin
Hardeners	nax Hardener for Polyester	peroxide

Initial Surface preparation

- Prior to any surface preparation, degrease the repair area using nax Pro LV100 Universal 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.
- Wipe degreaser off before it can evaporate.

▸ 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 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.*

Mixing

▸ **Product Mix**

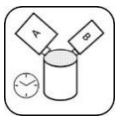
For best performance mix up newly opened can and keep lid closed after use

▸ **Mix By Weight**

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

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

Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▸ 2% Hardener	6-8 min	5-6 min	3-4 min
▸ 3% Hardener	5-6 min	4-5 min	2-3 min

Notes:

Application

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**
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 — P120
- Final block (dry) sanding of polyester bodyfiller/putty — 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

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

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

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

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 are stored unopened at 20°C (70°F).Avoid extreme temperature fluctuation.*

OAR.02.010. 300517
Professional Use Only

Description

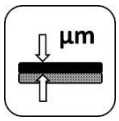
nax Spot Filler (1K Acrylic) is a finishing knifing putty, designed to fill small scratches and pinholes those occurring in polyester bodyfillers/putties, primer surfacers and existing finishes.

Suitable Substrates

Polyester bodyfiller / putty
Primer surfacers
Existing finishes (incl. TPA)
Polyester laminates

1 – 3 coats

3 – 4 min. application time at 20°C



30-50 µm / layer

Dry to sand

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

Dry sanding

P320 – P400

Wet sanding

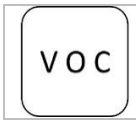
P800 – P1000

Re – coatable with:

All nax Pro LV / Premila / Superio preparatory products

All nax Pro / Premila / Superio topcoat systems

nax Spot Filler (1K Acrylic) 2 years



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

▸ The EU limit value for this product (product category: IIB.d) in ready to use form is max	250	g/liter
▸ The VOC content of this product in ready to use form is maximum	430	

Use suitable respiratory protection

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

For detailed information read entire TDS

Description

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	Existing finishes (incl. TPA)	Polyester laminates
Primer surfacers		

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.

Surface preparation

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

- ▸ 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

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

Application

Maximum number of applied coats	1-3
Maximum DFT after sanding	30-50 µm/layer
Apply it with a knifing technique and as smooth as possible	

Notes: *Do not apply directly on any metal substrate.*

Drying time

	20°C(70°F)	30°C(86°F)	40°C(100°F)
Dry to sand	25-30 min.	15-20 min.	10-15 min

Final Sanding

▸ When applied on bodyfiller	P320-P400
▸ When applied on polyester laminates / existing finishes	P320-P400
▸ Before topcoat in case of small pinholes	P400-P500

▸ When applied on bodyfiller	n/a
▸ When applied on polyester laminates / existing finishes	P800
▸ Before topcoat in case of small pinholes	P800/P1000

- ▸ 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 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

nax Spot Filler 1K		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.02.012. 300517
Professional Use Only

CLEANERS & DEGREASERS

nax PRO LV

Description

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 plastics | Existing finishes, except TPA like finishes | Primers and surfacers
Steel, aluminum, galvanized steel (GI), stainless steeland Electro deposition coat (ED)

Application Method 1

Wet surface usingclean wet cloth

Wipe degreaser off with clean dry cloth before it can evaporate

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

Apply with spray atomizer

Wipe degreaser off with clean dry cloth before it can evaporate

Notes: *In case of heavy contamination surface should be degreased twice, with a clean wipe-off cloth each time.*
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

- The EU limit value for this product (product category: IIB.a) in ready to use form is max 850
- The VOC content of this product in ready to use form is maximum 847 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.

OAR.01.011. 300517
Professional Use Only

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
Steel, aluminum, galvanized steel (GI) and stainless steel
OEM Electro-coat (ED)
Polyester bodyfillers & putties
Primers and surfacers

Application Method 1

Wet surface with new wet cloth

Wipe degreaser off with clean dry cloth before it can evaporate

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

Apply with spray atomizer

Wipe degreaser off with clean dry cloth before it can evaporate

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 850 g/liter
- The VOC content of this product in ready to use form is maximum 780

Health & Safety

Use suitable personal protection equipment

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

ANCILLARIES

Description

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 Surfacer	Topcoats	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:

Gravity fed | 1.2-1.4 mm

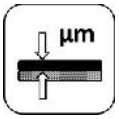
Application Pressure:

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

Application With :

Primer Surfacer Clearcoats, and Topcoats



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.

Equipment cleaning

Solvent borne guncleaners

Product storage

Minimum storage temperature:	5°C (41°F)	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

Description

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.

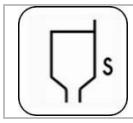
Suitable Products

Pro LV Clearcoats Pro LV Topcoats

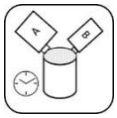
Anti-Silicone is added to the mixture of the RTS Pro LV clearcoats/topcoats in the amount of 2-4%

Example: To 1Lt RTS of Clearcoat with Hardener and Thinner, add 20ml (2%) Anti-Silicone

nax Pro LV4100 Anti-Silicone does not affect product drying



nax Pro LV4100 Anti-Silicone does not affect product spray viscosity, but may reduce paint flow at application.



nax Pro LV4100 Anti-Silicone does not affect pot life.

Use suitable respiratory protection

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

nax Pro LV4100 Anti-Silicone		2 years	
Minimum storage temperature:	5°C (41°F)	Maximum storage temperature:	35°C (95°F)

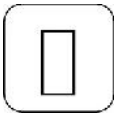
Notes: *Product shelf-life is determined when products are stored unopened at 20°C (70°F). Avoid extreme temperature fluctuation.*

OAR.08.011. 181218

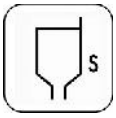
PROFESSIONAL USE ONLY

Description

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.

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 fed	1.2-1.3	mm

Application Pressure:

1.2-1.5	bar	28-30	psi	At spray-gun air inlet

HVLP max 0.6-0.7 bar(8-10 psi) at the air cap

1 x 2 coat

1-2 medium coat

Between coats:

3 - 5	minutes at	20°C	70°F

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

Description

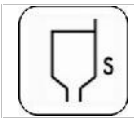
naxProLV 4000 Acceleratorreduces the drying and curing time of two-component acrylic and polyurethane products. It is specially recommended for low temperature and high air humidity applications.

Suitable Products

2K Clearcoats 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



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.

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

OTHER

Description

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.

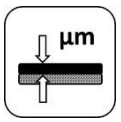
Suitable Substrates

Existing finishes	Epoxy primers	Primer surfacer

Ready to spray

Only requires a shake before use

2 – 3 even coats



15 - 20 µm / coat

Between coats:

5 - 10 minutes at | 20°C | 70°F

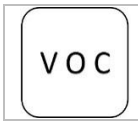
Dry to handle

20°C (70°F)	30°C (86°F)	40°C (100°F)
50-60 min	30-40 min	20-30 min

Re – coating:

With all nax clearcoat

Nax Pro LV1201 Matt Black Aerosol 2 Years



2004/42/IIB(e)(840)715

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	715	

Use suitable respiratory protection

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

For detailed information read entire TDS

Description

nax Pro LV1201 Matt Black Aerosol is single component fast drying thermoplastic acrylic aerosol matt black.

Suitable Substrates

Existing finish	Epoxy primers	Primer surfacers

Product

Product	Nax Pro LV1201 Matt Black Aerosol (Acrylic)	Acrylic resin

Final surface preparation

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

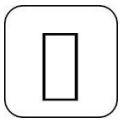
- Finishing wet sanding steps: P1000
- Initial dry sanding step may be executed with: P320/P400
- Initial wet sanding step may be executed with: P800

- 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:

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.*

Product preparation



Ready to spray

Shake thoroughly before use

Shake for several minutes after the mixing ball has loosened

Application

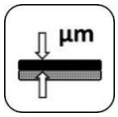
Distance to surface: 12 – 18 cm

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

	20°C (70°F)	30°C (86°F)	40°C (100°F)
▸ Dry to handle	50-60 min	30-40 min	20-30 min
▸ 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

2004/42/IIb(e)(840)715

▸ 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	715	

Product storage

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.

Shelflife

Nax Pro LV1201 Matt Black Aerosol	2 years

OAR.05.010. 300517

Professional Use Only