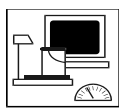


Description

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

Colour Mixing



nax Premila Master Tint (MT) Toners
nax Acrylic Binder

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



Solid 100
Thinner* 100

Effect 100
Thinner* 130 - 150

(Colour Mix)

*Thinner nax Acrylic 7320 Thinner

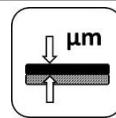


Spray-gun Setup:
Gravity fed | 1.3-1.4 mm

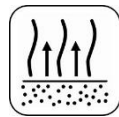
Application Pressure:
1.7-2.2 bar | 28-30 psi | At spray-gun air inlet
HVLP max 0.6-0.7 bar (8-10 psi) at the air cap



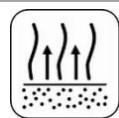
3 - 4 coats



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



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



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

Re-coat within:
24 hours 25°C 77°F



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



Use suitable respiratory protection

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

For detailed information, read entire TDS.

Description

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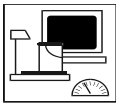
Suitable Substrates

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

Product and Additives

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

Colour Mixing



nax Premila Master Tint (MT) Toners
nax Acrylic Binder

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

Surface Preparation



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



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



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



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

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

Mixing



Mixing Machine

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




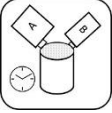
Colour Mix


Must be stirred thoroughly directly after mixing the formula.




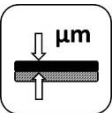
Solid	Effect	
100	100	nax Acrylic Colour Mix
100	130-150	nax Acrylic 7320 Thinner

Viscosity (DIN 4 Cup)		
	Application	25°C(77°F)
	▶ Standard	15-17 sec

Pot Life		
	Application	25°C(77°F)
	▶ Standard	Not applicable

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

Application		
	Colours	Number of coats
	▶ Solid	3-4 single coats
	▶ Metallic	4-5 + drop-coat
	▶ Pearl	4-5 + drop-coat
Solid Colours	1. Apply 3-4 single coats till opacity is achieved, with 3-5 minutes flash off between coats.	
Metallic/Pearl Colours	1. Apply 3-4 wet coats followed by a medium coat, with 3-5 minutes flash off between coats. 2. Apply a drop-coat for optimal metallic orientation coat by reducing the pressure to 1.5 bar (20-25psi) at the gun inlet and apply the drop coat with full trigger, increase the distance to 30 cm (12 inches).	
<i>Notes: Flash-off time depends on ambient temperature, applied layer thickness and airflow.</i>		

Film Thickness			
	Colours		
	▶ Solid	Using the recommended application technique	30-40 µm
	▶ Effect	Using the recommended application technique	20-30 µm

Denibbing

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

Taping

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

Re-coating Time

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

Re-coating



- ▶ nax Acrylic 320 #09 Topcoat Clear

Equipment Cleaning

Solvent borne gun cleaners.

Shelf-life



nax Premila MT Pearl/Solid toners

nax Premila MT Metallic toners

nax Acrylic binder

nax Acrylic 7320 Thinner

Minimum storage temperature:

5°C (41°F)

Maximum storage temperature:

35°C (95°F)

Notes:

Avoid extreme temperature fluctuation.

PROFESSIONAL USE ONLY

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