

Description

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

Suitable Substrates

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

	4 nax 2600 2K Premium Primer
	1 nax 260 2K Premium Primer Hardener / nax 260 2K Slow Hardener
	1-2 nax Premila Thinners

	Spray-gun Setup: Gravity fed 1.4 - 1.8 mm	Application Pressure: 1.7 - 2.2 bar 28-30 psi At spray-gun air inlet HVLP max 0.6-0.7 bar (8-10 psi) at the air cap
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	2 - 3 coats		50-60 µm /coat (4:1:1) 40-50 µm /coat (4:1:2)
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	Between coats: 3 - 8 minutes at 20°C 70°F	Before 60°C (140°F) baking: 5 - 10 minutes at 20°C 70°F
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	Dry to sand	20°C (70°F) 2 hours	30°C (86°F) 1½ hours	40°C (100°F) 1½ hours	60°C (140°F) 30 minutes	Infra-Red 4+8 minutes
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	Final dry sanding: P400- P500		Final wet sanding: P800-P1000
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	Re-coating With itself and all nax Premila primers, primer fillers and surfacers With nax E-Cube WB Basecoat, nax Premila 8000 Basecoat and nax Premila 7000 2K Solid Topcoat
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	▶ The VOC content of this product in ready to use form is maximum 636 g/liter
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	Use suitable respiratory protection Nippon Paint Automotive Refinishes recommends the use of fresh air supply respirator. <small>For detailed information read entire TDS.</small>
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Suitable Substrates

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

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

Product and Additives

Product	nax 2600 2K Premium Primer	Acrylic resin	Temperature Range
Hardeners	nax 260 2K Premium Primer Hardener nax 260 2K Slow Hardener	Poly-isocyanate resin Poly-isocyanate resin	
Thinners	nax Premila 10 Fast Thinner nax Premila 20 Medium Thinner nax Premila 30 Slow Thinner nax Premila 40 Extra Slow Thinner	Blend of solvents Blend of solvents Blend of solvents Blend of solvents	20-35°C Above 35°C 5-20°C 20-35°C 35-45°C 35-50°C
Additives	nax Softener		

Surface Preparation



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



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



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

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

Grey Shades (volume, % / weight, gr)

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

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

Tinting

nax 2600 2K Premium Primer can be custom tinted for special needs, up to 10% by volume with nax Premila MT Solid Toners added to the primer prior to addition of hardener and thinner. Once toner is added, stir the primer well prior to adding the hardener. Do not add more than 10% toner strictly under any circumstances to the primer.

Flexible Parts

Type of Plastic	Flexible	Soft	
nax 2600 2K Premium Primer	100	100	By volume
nax Softener	5	10	By volume

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

Mixing



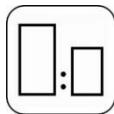
Mixing Machine

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



Product Mix

Stir well, after each added component.



HB	MB		Hardener/Thinner Selection			
4	4	nax 2600 2K Premium Primers		5-20°C	20-35°C	≥ 35°C
1	1	nax 260 2K Hardeners	1-2 panels/spot	Std/10	Std/20	Slow/30
1	2	nax Premila 10/20/30/40 Thinners	3-5 panels	Std/20	Std/20	Slow/30
			>5 panels	Std/30	Slow/20	Slow/30

Notes: Stir after each added component.

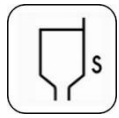
Mixing (by weight) High Build

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

Mixing (by weight) Medium Build

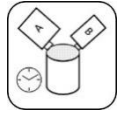
RFU (ml)	nax 2600 2K Premium Primer (gr)							nax 260 2K Hardeners (gr)	nax Premila Thinners (gr)
	S1	S2	S3	S4	S5	S6	S7		
100	88	87	86	84	83	81	81	14	25
150	132	131	129	126	124	122	121	21	38
200	176	175	172	169	166	163	161	27	50
250	220	218	214	211	207	203	201	34	63
300	264	262	257	253	248	244	242	41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

Viscosity (DIN 4 Cup)



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ High Build	17-23 sec.	19-23 sec.	19-23 sec.
▶ Medium Build	14-18 sec.	14-18 sec.	14-18 sec.

Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ High build	40 min.	30 min.	20 min.
▶ Medium build	1½ hrs.	60 min.	30 min.

Spray Gun Set-up / Application Pressure



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

Application



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

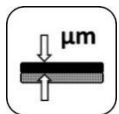
Notes: Allow each coat to flash-off naturally until the surface is completely matt. Do not force-dry by air support. Proper flash off helps achieving higher film build. Flash-off time depends on ambient temperature, applied layer thickness and airflow. For maximum build use large fluid tip and lower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

Drying Time



	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C (140°F)	IR Drying
▶ Dust dry	10 min.	5 min.	5 min.	-	n/a
▶ Dry to sand (Standard)	2 hrs.	1½ hrs.	1½ hrs.	30 min.	4+8 min.
▶ Dry to sand (Slow)	3 hrs.	2½ hrs.	2 hrs.	30 min.	4+8 min.

Film Thickness



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

Finishing Surface Preparation



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



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



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

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

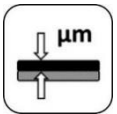
Re-coating



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

Notes:

Coverage



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

8-12	m ² /litre RTS mixture at	30-60µm
86-129	ft ² /litre RTS mixture at	30-60µm

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

Equipment Cleaning

Solvent borne gun cleaners.

Solvent Content



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

Shelf-life



nax 2600 2K Premium Primers
 nax 260 2K Hardeners
 nax Premila Thinners

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

Notes: Avoid extreme temperature fluctuation.

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

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

LAR.04.011. 140917

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