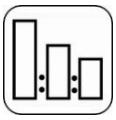
nax 2800HP 2K Velocity Primer

Description

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

Suitable Substrates

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

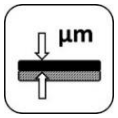


2 nax 2800HP 2K Velocity Primer
2 nax 580 2K Velocity Reducer
1 nax 280HP 2K Velocity Primer Hardener

Spray-gun setup:
Gravity fed | 1.4 - 1.8 mm

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

2 - 3 coats



20 - 40 µm /coat

Between coats:
1 - 2 minutes at | 20°C | 70°F

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

Final dry sanding:
P400- P500

Final wet sanding:
P800-P1000

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

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

Use suitable respiratory protection

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

For detailed information read entire TDS

nax 2800HP 2K Velocity Primer

Description

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

Suitable Substrates

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

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

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

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

Product and Additives

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

Surface preparation

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

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

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

Notes: *Respect 100 grit maximum jump in dry sanding steps. For detailed surface preparation see TDS*

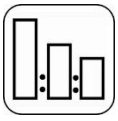
Mixing

Mixing Machine

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

Product Mix

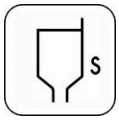
Stir well, after each added component.



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

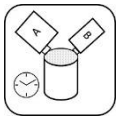
Notes: *Stir after each added component*
Reducer must be added and stirred well before adding the hardener

Viscosity (DIN 4 Cup)



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

Pot Life



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

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

Spray gun set-up / application pressure

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

Application

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

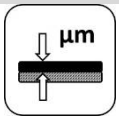
- Apply one medium coat over the sanded repair area, then allow to flash for 1-2 minutes.
- Apply the 2nd and 3rd wet coat within each previous coats allowing 1-2 min. between coats.

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

Drying time

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

Film thickness



Using the recommended application technique	20-40 µm/coat

Final surface preparation

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

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

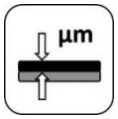
- Prior to SB topcoat application degrease the surface using nax solventborne degreaser.
- Prior to WB basecoat application degrease the surface using nax E-Cube WB Degreaser.
- Use clean quality rags or wiping towels, one for wetting and one for drying.
- Apply sufficient degreaser to keep the surface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

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

Re-coating

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

Coverage



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

- ± 09 m²/liter RTS mixture at 40-50 µm

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

Equipment cleaning

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

Solvent Content

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

Shelflife

nax 2800HP 2K Velocity Primer			
nax 580 2K Velocity Reducer			
nax 280HP 2K Velocity Primer Hardener			
Minimum storage temperature:	5°C (41°F)	Maximum storage temperature:	35°C (95°F)

Notes: *Avoid extreme temperature fluctuation.*

LAR.04.012. 140917
PROFESSIONAL USE ONLY