

Description

Innovative high solid automotive finish with incorporation of CyGLAZ Technology to integrate superb toughness, high flexibility and excellent chemical resistance. The product is specially designed to exhibit excellent mar and scratch resistance to withstand day to day wear and tear e.g. car wash, acid rain, bird droppings etc., to ensure longer lasting beautiful look.

Suitable Substrates

nax Premila 8000 Basecoat
nax E-Cube WB Basecoat



2 nax Crystal 9905 Mirror Image Clear 2K 2:1
1 nax Crystal 905 2K Hardener



Spray-gun setup:

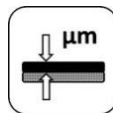
Gravity fed | 1.3-1.4 mm

Application Pressure:

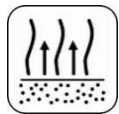
1.7-2.2 bar | 28-30 psi | At spray-gun air inlet
HVLP max 0.6-0.7 bar (8-10 psi) at the air cap



1 ½ - 2 coats



20 - 30 µm /coat



Between coats:

10 - 15 minutes at | 20°C | 70°F |

Before 60°C (140°F) baking:

15 minutes at | 20°C | 70°F |



Dust dry
Dry to handle
Dry to polish

20°C (70°F)

90 min.
10 hrs.
10 hrs.

30°C (86°F)

45 min.
5 hrs.
5 hrs.

40°C (100°F)

30 min.
3 hrs.
4 hrs.

60°C (140°F)

n/a
45 min.
2 hrs. after cooldown

Infra-Red

4+8 minutes



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

747 g/liter



Use suitable respiratory protection

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

For detailed information read entire TDS

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Suitable Substrates

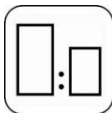
nax Premila 8000 Basecoat
nax E-Cube WB Basecoat

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

Product and Additives

Product	nax Crystal 9905 Mirror Image Clear 2K 2:1	Acrylic Polyol	
Hardener	nax Crystal 905 2K Hardener	Poly-isocyanate resin	
Reducers	nax Premila 20 Medium Thinner	Blend of solvents	20-35°C
	nax Premila 40 Extra Slow Thinner	Blend of solvents	35-45°C

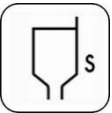
Mixing



2	nax Crystal 9905 Mirror Image Clear 2K 2:1
1	nax Crystal 905 2K Hardener
5%*	nax Premila 20 / 40 Thinners (aka 500/503) (optional)

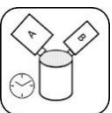
Notes: Stir after each added component
*To improve handling 5% of nax Premila Thinner 20 or 40 can be added.

Viscosity (DIN 4 Cup)



		20°C(70°F)	30°C(86°F)
▶ Standard		14-17 sec	16-17 sec

Pot Life



		20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ Standard		3 hrs	2 hrs	1½ hrs

Spray gun set-up / application pressure



Spray-gun type	Spray-gun type	Nozzle size	Application pressure
▶ LVLP	Gravity	1.3-1.4 mm	1.7-2.2 bar at the spray gun air inlet
▶ HVLP	Gravity	1.3-1.4 mm	(HVLP: max 0.6-0.7 bar at the air cap)

Application

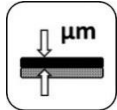


Standard Application

- ▶ Apply one medium coat, then allow to flash for 10-15 minutes.
- ▶ Apply the 2nd wet coat.

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

Film thickness



- ▶ All Using the recommended application technique 40-60 μm

Drying time



	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	Infra-Red
Dust dry	90 min.	45 min.	30 min.	-	
Dry to handle	10 hrs.	5 hrs.	3 hrs.	45 min.	4+8 min.
Dry to polish	10 hrs.	5 hrs.	4 hrs.	2hrs. after cooldown	

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

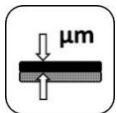


Dust and minor imperfections can be polished out after the indicated air-dry times, or after 2 hours cool down time following the full bake at 60°C object temperature. Carefully sand out dust particles and restore the surface according polishing recommendations.

- ▶ Carefully de-nib using P1500 or finer with soap and water; blow air & dry the sanded area
- ▶ Machine sanding with P3000 is recommended to avoid sanding marks & minimize orange peel effect (use of soft interface pad is recommended at speed ~ 1500 rpm)
- ▶ Compound using Fast cut compounding paste with a wool compounding pad and an air or electric buffer at 1400 to 2000 rpm.
- ▶ Polish using standard fine polishing paste with a foam polishing pad and an air or electric buffer at 1400 to 2000 rpm (reduce pressure as polish begins to dry and buff to a high gloss).
- ▶ Remove any remaining residue using Detailing Cloth.

Notes: *Recommended 3M™ Finesse-it™ SRC for better results (especially if the polishing process is being carried out after 48 hours). Polishing preferably needs to be carried out within 48 hours as longer waiting time will results in increased hardness of the paint film thereby making polishing harder as well. Polishing can be done mechanically (preferable) or manually. nax Crystal 9905 Mirror Image Clear is a hard & scratch resistant clear coat and so to get excellent results especially for gloss restoration, polishing needs to be done as per the recommended procedure especially if it done after longer curing time after application of the clear coat.

Coverage



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

- ▶ $\pm 6 \text{ m}^2/\text{liter RTS mixture at } 40\text{-}60 \mu\text{m}$

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



▶ The VOC content of this product in ready to use form is maximum 747 g/liter

Shelflife



nax Crystal 9905 Mirror Image Clear 2K 2:1

nax Crystal 905 2K Hardener

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

Notes: Avoid extreme temperature fluctuation.

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