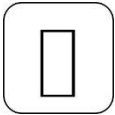


Description

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:

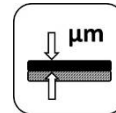
Gravity fed | 1.2-1.4 mm

Application Pressure:

1.7 - 2.2 bar | 28-30 psi | At spray-gun air inlet
HVLV 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)
15 min

30°C (86°F)
10 min

40°C (100°F)
5 min



Re – coating

With all nax Pro LV and Premila primer fillers and surfacers

With all nax Premila 2K topcoat systems



2004/42/II B(e)(840)840

- ▶ 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

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 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.



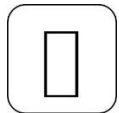
- ▶ Non primed new plastic (raw) → Use grey scuff pad with matting paste and warm water
- ▶ In case of plastic repair finish surface before priming, with: P320



- ▶ 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

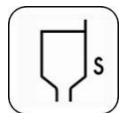


Ready to spray

Lightly agitate can before use.

Unused product can be returned into can

Viscosity (DIN 4 Cup)



20°C (70°F)
10-12 sec

30°C (86°F)
10-12 sec

40°C (100°F)
8-9 sec

Spray gun set-up / application pressure



Spray-gun type

Gravity

Nozzle size

1.2-1.4 mm
mm

Application pressure

Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)
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

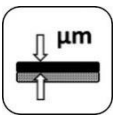
Re-coating



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
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Equipment cleaning

Solvent borne guncleaners

Solvent Content



2004/42/IIIB(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

Minimum storage temperature:	5°C (41°F)	Maximum storage temperature:	35°C (95°F)
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Notes: Avoid extreme temperature fluctuation.

OAR.03.010. 300517

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