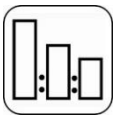
# nax Premila 7000 2K Solid Topcoat

## Description

Two component high solid, acrylic enamel direct gloss topcoat as part of the Premila Master Tint system. Designed to duplicate OEM finishes in solid colours. Provides easy application, fast drying, easy spot repair, excellent hiding power, and high gloss.

## Suitable Substrates

Existing finishes with the exception of thermoplastic acrylic finishes.
All nax Pro LV and Premila primers, primer fillers/surfacers.

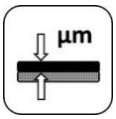


4 nax Premila 7000 2K Solid Topcoat (Ready Colour Mix)
1 nax Premila 410 / 412RP 2K Hardeners
1 nax Premila Thinners

**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

2-3 coats




20-30 µm /coat

**Between coats:**
5 - 10 minutes at | 20°C | 70°F

**Before 60°C (140°F) baking:**
5 - 10 Minutes at | 20°C | 70°F

| | 20°C (70°F) | 30°C (70°F) | 40°C (70°F) | 60°C (140°F) | Infra-Red |
|---|---|---|---|---|---|
| Dust dry | 12 min. | 10 min. | 8 min. | - | n/a |
| Dry to handle | 8 hrs. | 3 hrs. | 3 hrs. | 30 minutes | 5+10 minutes |
| Dry to polish | >10 hrs. | >8 hrs. | >6 hrs. | 1 hour after cooldown | 5+10 minutes |


▸ The VOC content of this product in ready to use form is maximum 590 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

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All nax Pro LV and Premila primers, primer fillers/surfacers.

***Notes:*** *Follow recommended flash off and re-coating time of the wet-on-wet primer.*

## Product and Additives

| | | | |
|---|---|---|---|
| **Product** | nax Premila Master Tint Solid Toners / 2K Binder | Acrylic polyol resin | |
| **Hardener** | nax Premila 410 2K Hardener | Poly-isocyanate resin | |
| | nax Premila 412 RP 2K Hardener | Poly-isocyanate resin | |
| **Thinners** | nax Premila 10 Fast Thinner (aka 502) | Blend of solvents | 5-20°C |
| | nax Premila 20 Medium Thinner (aka 500) | Blend of solvents | 20-35°C |
| | nax Premila 30 Slow Thinner (aka 501) | Blend of solvents | 35-45°C |
| | nax Premila 40 Extra Slow Thinner (aka 503) | Blend of solvents | 35-50°C |
| **Additives** | nax Softener | | |

## Final surface preparation

- Finishing dry sanding steps: P400
- 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: P800
- Initial dry sanding step may be executed with a coarser grit: P320
- Initial wet sanding step may be executed with a coarser grit: P600
- For spot repair, finish the blending area with: P1000

- Prior to SB topcoat application degrease the surface using nax solventborne 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. For detailed surface preparation see TDS*

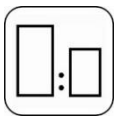
## Mixing

### 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.

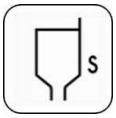


| Standard | Flexible | |
|---|---|---|
| 4 | 4 | nax Premila 7000 colour mix (formula) |
| 1 | 1 | nax Premila 410 / 412RP 2K Hardeners |
| 1 | - | nax Premila Thinners |
| - | 0.5 | nax Softener |

| Thinner selection | | | |
|---|---|---|---|
| | **Fast** | **Medium** | **Slow** |
| | **5-20°C** | **20-35°C** | **35-45°C** |
| 1-2 panels/spot | Fast | Medium | Slow |
| 3-5 panels | Medium | medium | Slow |
| >5 panels | Slow | Slow | Slow |

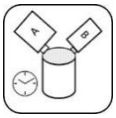
***Notes:*** *Stir after each added component*

## Viscosity (DIN 4 Cup)




| | 20°C(70°F) | 30°C(86°F) |
|---|---|---|
| ▸ Standard | 15-22 sec | 15-17 sec |
| ▸ Flexible application | 20-22 sec | 15-17 sec |

## Pot Life



| 20°C(70°F) | 30°C(86°F) | 40°C(100°F) |
|---|---|---|
| 5 hours | 4 hours | 2 hours |

## 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) |

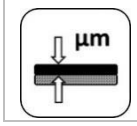
## Application

Apply one medium coat, then allow to flash for 5-7 minutes.

Apply the 2nd and if required a 3rd wet coats allowing 5-10 minutes between coats.

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

## Film thickness




Using the recommended application technique 40 - 60 µm

## Drying time

| Dust dry | 20°C(70°F) | 30°C(86°F) | 40°C(100°F) | 60°C(140°F) | Infra-Red |
|---|---|---|---|---|---|
| ▸ Standard | 10 min. | 10 min. | 7 min. | n/a | n/a |
| **Dry to handle and polish** | | | | | |
| ▸ Standard | 8 hrs. | 1 hr. | 1 hr. | 30 min. | 4+8 min. |

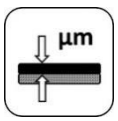
***Notes:*** *Indicated drying times are panel temperatures. Oven temperature should be set 10 °C higher.*
*Allow 10 minutes flash off prior to Infra-Red drying.*
*The panel must not reach a temperature above 100°C (210°F) while curing.*
*Following the drying cycle at 60°C (140°F) object temperature, 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 8 hours air-dry times, or after a one hour cool down time following the full bake at 60°C object temperature. Carefully sand out dust particles and restore the surface according polishing recommendations.

***Notes:***

## Coverage




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

▸ ±10 m²/liter RTS mixture at 40 - 60 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

## Solvent Content

VOC

- The VOC content of this product in ready to use form is maximum 590 g/liter

## Shelflife

| | | | |
|---|---|---|---|
| nax Premila Solid Toners | | | |
| nax Premila NB 200 2K Binder | | | |
| nax Premila 410 / 412RP 2K Hardeners | | | |
| nax Premila Thinners | | | |
| Minimum storage temperature: | 5°C (41°F) | Maximum storage temperature: | 35°C (95°F) |

***Notes:*** *Avoid extreme temperature fluctuation.*

**LAR.05.010. 140917**

**PROFESSIONAL USE ONLY**