

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:	Application Pressure:
	Gravity fed 1.3-1.4 mm	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
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	Between coats:	Before 60°C (140°F) baking:
	5 - 10 minutes at 20°C 70°F	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	

	<p>► The VOC content of this product in ready to use form is maximum</p> <p>590 g/liter</p>
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	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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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 nax Premila 412 RP 2K Hardener	Poly-isocyanate resin Poly-isocyanate resin	
Thinners	nax Premila 10 Fast Thinner (aka 502) nax Premila 20 Medium Thinner (aka 500) nax Premila 30 Slow Thinner (aka 501) nax Premila 40 Extra Slow Thinner (aka 503)	Blend of solvents Blend of solvents Blend of solvents Blend of solvents	5-20°C 20-35°C 35-45°C 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



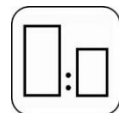
Mixing Machine

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.

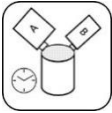



Standard	Flexible	
4	4	nax Premila 7000 colour mix (formula)
1	1	nax Premila 410 / 412RP 2K Hardeners
1	-	nax Premila Thinners
-	0.5	nax Softener


	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

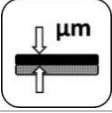
Notes: Stir after each added component


Viscosity (DIN 4 Cup)			
		20°C(70°F)	30°C(86°F)
	▶ Standard		15-22 sec
▶ 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

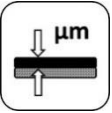
Spray gun set-up / application pressure				
	Spray-gun type	Spray-gun type	Nozzle size	Application pressure
	▶ LVLP	Gravity	1.3-1.4 mm	1.7-2.2 bar at the spray gun air inlet
▶ HVLP	Gravity	1.3-1.4 mm	(HVLP: max 0.6-0.7 bar at the air cap)	

Application	
	Apply one medium coat, then allow to flash for 5-7 minutes.
	Apply the 2 nd and if required a 3 rd wet coats allowing 5-10 minutes between coats.
Notes:	<i>Flash-off time depends on ambient temperature, applied layer thickness and airflow.</i>

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
	Dry to handle and polish					
	▶ Standard		8 hrs.	1 hr.	1 hr.	30 min.
Notes:	<i>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.</i>					

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 m ² /liter RTS mixture at 40 - 60 µm
Notes:	<i>The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.</i>

Equipment cleaning
Solvent borne guncleaners

Solvent Content
<div style="display: flex; align-items: center;"> <div style="border: 1px solid black; border-radius: 10px; padding: 5px; margin-right: 10px;">VOC</div> <div> <p>▶ The VOC content of this product in ready to use form is maximum 590 g/liter</p> </div> </div>

Shelflife				
<div style="display: flex; align-items: center;"> <div style="border: 1px solid black; border-radius: 10px; padding: 5px; margin-right: 10px;">  </div> <div> <p>nax Premila Solid Toners</p> <hr/> <p>nax Premila NB 200 2K Binder</p> <hr/> <p>nax Premila 410 / 412RP 2K Hardeners</p> <hr/> <p>nax Premila Thinners</p> </div> </div>				
<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">Minimum storage temperature:</td> <td style="width: 33%;">5°C (41°F)</td> <td style="width: 33%;">Maximum storage temperature:</td> <td style="width: 33%;">35°C (95°F)</td> </tr> </table>	Minimum storage temperature:	5°C (41°F)	Maximum storage temperature:	35°C (95°F)
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<p>Notes: <i>Avoid extreme temperature fluctuation.</i></p>				

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