

Description

Single component acrylic master tint basecoat system designed to duplicate OEM finishes in solid, and effect colours. Provides easy application, fast drying, easy spot repair. nax Premila 8000 must be re-coated with nax Premium category clearcoats to secure complete system performance.

Suitable Substrates

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

	100 nax Premila 8000 Basecoat (Ready Colour Mix)
	100 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	Solid colours
			15-30 µm	Effect colours

	Between coats:	5 - 10 minutes at	20°C	70°F			
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	Before re-coat:	10-15 minutes at	20°C	70°F	Re-coat within:	24 hours at	20°C	70°F
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	Re – coating
	With all nax Pro LV and nax Premila clearcoats
	With nax Crystal 9905 Mirror Image Clear 2K 2:1

	VOC	▶ The VOC content of this product in ready to use form is maximum	748 g/liter
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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 / basecoat.

Product and Additives

Product	nax Premila Master Tint Toners / B/C Binder	Acrylic resins	
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

Final surface preparation



- ▶ Finishing dry sanding step: P500
- ▶ Initial dry sanding step may be executed with a coarser grit: P320/P400
- ▶ For spot repair, finish the basecoat blending area with: P500



- ▶ Finishing wet sanding steps: P1000
- ▶ Initial dry sanding step may be executed with: P320/P400
- ▶ Initial wet sanding step may be executed with: P800
- ▶ For spot repair, finish the basecoat 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.
Use guide coat to control sanding.

Mixing



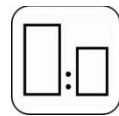
Mixing Machine

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.

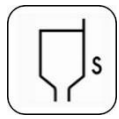


Standard	Low hide	
100	100	nax Premila 8000 colour mix (formula)
100	80	nax Premila Thinners

Thinner selection		
Fast	Medium	Slow
5-20°C	20-35°C	35-45°C

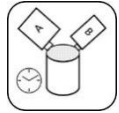
Notes: To improve: elasticity, recoat properties, stone chip resistance, adhesion properties and total system robustness it is possible to add nax Premila 410 2K Hardener to basecoat. The Hardener is added in the ratio of 5% by volume of the base (colour) mix prior to adding nax Premila Thinners. After adding hardener mix thoroughly and mix with thinners as mentioned above.

Viscosity (DIN 4 Cup)



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ Standard	14-16 sec	13-15 sec	13-15 sec

Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ Standard	1 day	1 day	1 day
▶ With 5% hardener	6 hours.	6 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



2 coat colours	Number of coats	3 coat pearl colour	Number of coats
▶ Solid	2-3 single coats	▶ Foundation (Solid)	2
▶ Metallic	2 + drop-coat	▶ Foundation (Effect)	2-3
▶ Pearl	2-3 + drop-coat	▶ Mica	2-4

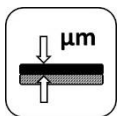
Solid colours 1. Apply 2-3 single coats till opacity achieved, with 5-10 minutes flash off time between coats

Metallic/ Pearl colours 1. Apply a wet coat followed by a medium coat, with 5-10 minutes flash off time between coats.
2. Apply a drop-coat for optimal metallic orientation coat by reducing the pressure to 1.5 bar (20-25psi) at the gun inlet and apply the drop coat with full trigger, increase the distance to 30 cm (12 inches).

Spot Repair When making spot repairs, use lower application pressure and apply thin coats until reaching opacity. Allow for a 3-5 minutes flash-off time at 20°C between coats. Next, fade out, by extending beyond the edges, using similar application pressure. In case of metallic colours apply a drop coat (metallic orientation coat) when needed by increasing the spray gun distance.

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

Film thickness



Colours		
▶ Solid	Using the recommended application technique	20-25 µm
▶ Effect	Using the recommended application technique	15-25 µm

❖ **The total dry layer thickness should never exceed 30µm.**

Denibbing



Following a 20 minutes flash off at 20°C (70°F) the basecoat can be de-nibbed for minor defects (e.g. dust) with light pressure using P500 dry sanding or P1000 wet sanding. Prior to the subsequent basecoat application secure a sanding residue free surface.

Taping

Following a 20 minutes flash off at 20°C (70°F) the basecoat can be taped for multi-colour application. Temperature increase in combination with air acceleration helps the ability for masking, then allow the object to cool down to ambient temperature before masking.

Re-coating time



nax Premila 8000 Basecoat System can be re-coated with clearcoat after 10-15 minutes flash off time and within 24 hours.

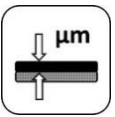
Re-coating



- ▶ All nax Pro LV Clearcoats
- ▶ All nax Premila Clearcoats
- ▶ nax Crystal 9905 Mirror Image Clear 2K 2:1

Notes:

Coverage



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

- ▶ ± 09 m²/liter RTS mixture for Solid colours
- ▶ ± 10 m²/liter RTS mixture for Effect colours (metallic/pearl)
- ▶ ± 10 m²/liter RTS mixture for 3 coat pearl colours

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 750 g/liter

Shelflife



nax Premila 8000 Basecoat

- a) Pearl / Solid toners and B/C binder
- b) Metallic toners

nax Premila Thinners

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

Notes:

Product shelf-life is determined when products are stored unopened at 20°C (70°F). Avoid extreme temperature fluctuation.

LAR.06.010. 140917

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