nax Premila 9600 Extra Solid Clear 2K 2:1

Description

High quality extra solid two component acrylic urethane clear. Provides excellent gloss and protection over Solvent and water borne basecoats. Ideal clearcoat from spot repair to complete respray, providing excellent chemical resistance and UV protection.

Suitable Substrates

nax Premila 8000 series basecoat
nax E-Cube WB basecoat system

2	nax Premila 9600 Extra Solid Clear 2K 2:1
1	nax Premila 210 2K Hardeners
0-10%	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 coats

40-60 µm

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	15 min.	10 min.	10 min.	-	n/a
Dry to handle	6-12 hrs.	3-6 hrs.	1½-3 hrs.	20-40 min.	4+8 min.
Dry to polish	6-12 hrs.	3-6 hrs.	1½-3 hrs.	1 hr. after cooldown	

VOC

- The VOC content of this product in ready to use form is maximum 550 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

High quality extra solid two component acrylic urethane clear. Provides excellent gloss and protection over solvent and water borne basecoats. Ideal clearcoat from spot repair to complete respray, providing excellent chemical resistance and UV protection.

Suitable Substrates

nax Premila 8000 series basecoat
nax E-Cube WB basecoat system

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

Product and Additives

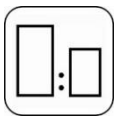
Product	nax Premila 9600 Extra Solid Clear 2K 2:1	Acrylic Polyol	
Hardeners	nax Premila 210 2K Hardener	Poly-isocyanate resin	
	nax Premila 210 RP Hardener Rapid	Poly-isocyanate resin	
	nax Premila 210 2K Slow Hardener	Poly-isocyanate resin	
Thinners	nax Premila 10 Fast Thinner (aka 502)	Blend of solvents	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		

Flexible Parts

Type of Plastic	Clearcoat	nax Softener
Flexible/Soft	100	5%
Soft	100	10%

Notes: *Hard plastic requires no softener. For plastic type information check nax Softener TDS (LAR.08.012)*
Stir well after adding the additive

Mixing

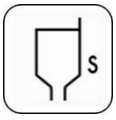


		Hardener/Thinner Selection			
			5-20°C	**20-35°C**	**≥ 35°C**
2	nax Premila 9600 Extra Solid Clear 2K 2:1				
1	nax Premila 210 2K Hardeners	1-2 panels	RP/10	RP/20	Std/30
0-10%	nax Premila Thinners	3-5 panels	RP/20	Std/20	Slow/30
		>5 panels	Std/30	Std/30	Slow/40

Above ratio is for both normal and flexible system

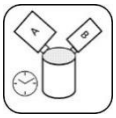
Notes: *Stir after each added component*

Viscosity (DIN 4 Cup)



	20°C(70°F)	**30°C(86°F)**
▸ Standard/Slow/Rapid	17-18 sec	14-17 sec

Pot Life



	20°C(70°F)	**30°C(86°F)**	**40°C(100°F)**
▸ Standard/Slow	2 hrs	1½ hrs	1 hr
▸ Slow	3 hrs	2 min	1½ min
▸ Rapid	1½ hrs	45 min	30 min

Spray gun set-up / application pressure

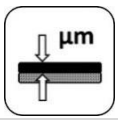
Spray-gun type	Spray-gun type	Nozzle size	Application pressure
▸ LVLP	Gravity	1.3-1.4 mm	1.7-2.2 bar at the spray gun air inlet
▸ HVLP	Gravity	1.3-1.4 mm	(HVLP: max 0.6-0.7 bar at the air cap)

Application

Standard Application
- Apply one medium coat, then allow to flash for 5-10 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



▸ All	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	10-20 min.	10-20 min.	10 min.	-	n/a
▸ Slow	25-30 min	20-25 min	20 min	-	n/a
▸ Rapid	10 min.	5-10 min.	5 min.	-	n/a
Dry to handle and polish					
▸ Standard	8 hrs.	4 hrs.	2 hrs.	30 min.	4+8 min.
▸ Slow	12 hrs.	6 hrs.	3 hrs.	40 min.	4+10
▸ Rapid	6 hrs.	3 hrs.	1½ hrs.	20 min.	4+8 min.

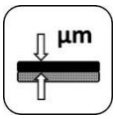
Notes:
Indicated drying times are panel temperatures. Oven temperature should be set 10 °C higher.
Allow 10 minutes flash off prior to Infra-Red drying.
The panel must not reach a temperature above 100°C (210°F) while curing.
Following the drying cycle at 60°C (140°F) object temperature, allow product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

Notes:

Coverage



By using the recommended application, the theoretical material coverage is:
- ±7 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

- The VOC content of this product in ready to use form is maximum 550 g/liter

Shelflife

nax Premila 9600 Extra Solid Clear 2K 2:1			
nax Premila 210 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.07.011. 140917

PROFESSIONAL USE ONLY

FEBRUARY 2024