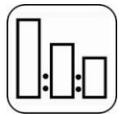


Description

Ultra-fast ambient curing clear coat for improved productivity and cost reduction. The prominent feature of this clear coat is its ultra-high productivity cycle with a dry to polish time of less than 30 minutes under ambient cure conditions (25-30 °C). Avoiding the need of a high temperature baking cycle, therefore meeting the requirements of “quick repair” and “energy saving” concepts. If require, an extremely short time bake of 5 minutes at 50 °C is more than sufficient to achieve ultra-fast curing properties. As a premium clear coat, it offers outstanding application properties, it is easy to polish, and has excellent gloss and appearance.

Suitable Substrates

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



2 nax Premila 9800 HP Velocity Clear 2K 2:1
1 nax Premila 980 HP 2K Hardener

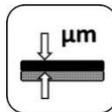


Spray-gun setup:
Gravity fed | 1.3 -1.4 mm

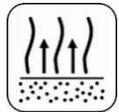
Application Pressure:
1.7-2.2 bar | 28-30 psi | At spray-gun air inlet
HVLP max 0.6-0.7 bar (8-10 psi) at the air cap



2 coats



25-35 μm /coat



Between coats:
2 - 5 minutes at | 20°C | 70°F |

Before 50°C (122°F) baking:
2 - 5 minutes at | 20°C | 70°F |



	20°C (70°F)	30°C (70°F)	40°C (70°F)	50°C (122°F)
Dust dry	10 min.	7 min.	5 min.	n/a
Dry to handle	30 min	15 min.	10 min.	5 min.
Dry to polish	60 min.	25 min.	15 min.	after cooldown



▶ The VOC content of this product in ready to use form is maximum 520 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

Ultra-fast curing clear coat for improved productivity and cost reduction. The salient feature of this clear coat is its ultra-high productivity cycle with a dry to polish time of less than 30 minutes under ambient cure conditions (25-30 °C). Avoiding the need of a high temperature baking cycle, therefore meeting the requirements of “quick repair” and “energy saving” concepts. If require, an extremely short time bake of 5 minutes @50 °C is more than sufficient to achieve ultra-fast curing properties. As a premium clear coat, it offers outstanding application properties, it is easy to polish, and has excellent gloss and appearance.

Suitable Substrates

nax Premila 8000 Basecoat
nax E-Cube WB Basecoat

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

Product and Additives

Product	nax Premila 9800 HP Velocity Clear 2K 2:1	Acrylic resin	
Hardener	nax Premila 980 HP 2K Hardener	Poly-isocyanate resin	
Reducers	nax Premila 20 Medium Thinner (aka 500)	Blend of solvents	20-35°C
	nax Premila 40 Extra Slow Thinner (aka 503)	Blend of solvents	35-45°C

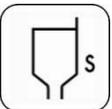
Mixing



2	nax Premila 9800HP Velocity Clear 2K 2:1
1	nax Premila 980 HP 2K Hardener
5%*	nax Premila 20 / 40 Thinners (optional)*

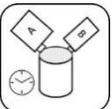
Notes: Stir after each added component
*To improve handling 5% of nax Premila Thinner 20 or 40 can be added.

Viscosity (DIN 4 Cup)



20°C(70°F)	30°C(86°F)	40°C(100°F)
14-16 sec	13-14 sec	12-13 sec

Pot Life



20°C(70°F)	30°C(86°F)	40°C(100°F)
2 hours	1 hour	30 min.

Notes: For efficient use, the clearcoat should be mixed and applied within 2-3 minutes after mixing to minimize any impact on application due to rise in viscosity.

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

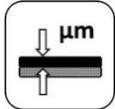


Standard Application

- ▶ Apply one medium coat, then allow to flash for 2-5 minutes.
- ▶ Apply the 2nd wet coat.

Notes: Application window: 15°C to 38°C, Relative Humidity – 20% to 85%
Flash-off time depends on ambient temperature, applied layer thickness and airflow.
Clean spray-gun immediately after application

Film thickness



Using the recommended application technique 50-60 µm

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

Drying time



	20°C(70°F)	30°C(86°F)	40°C(100°F)	50°C(122°F)
Dust dry	10 min.	7 min.	5 min.	n/a
Dry to handle	30 min.	15 min.	10 min.	5 min.
Dry to polish	60 min.	25 min.	15 min.	After cool down

Notes: Indicated drying times are panel temperatures. Oven temperature should be set 10 °C higher.
Following the drying cycle at 50°C (122°F) object temperature, allow product to completely cool down to ambient temperature.

Polishing



Dust and minor imperfections can be polished out after the indicated air-dry times, or after cool down time following the full bake at 50°C object temperature. Carefully sand out dust particles and restore the surface according polishing recommendations.

- Notes:** **Dirt Removal, Gloss retention and polishing & waxing**
- De-nib using P1500 or finer with soap and water; blow air & dry the sand area
 - Machine sanding with P3000 is recommended to avoid sanding marks & minimize orange peel effect (use of soft interface pad is recommended at speed ~ 1500 rpm)
 - Compound using 3M™ with a wool compounding pad and an air or electric buffer at 1400 to 2000 rpm.
 - Polish using 3M™ with a foam polishing pad and an air or electric buffer at 1400 to 2000 rpm (reduce pressure as polish begins to dry and buff to a high gloss).
 - Remove any remaining residue using Detailing Cloth.

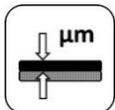
Re-coating



With itself after complete drying cycle (after 24 hours of drying sanding is necessary)

Notes:

Coverage



By using the recommended application, the theoretical material coverage is:
▶ ± 6 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 520 g/liter

Shelflife



nax Premila 9800 HP Velocity Clear 2K 2:1

nax Premila 980 HP 2K Hardener

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

Notes: Avoid extreme temperature fluctuation.

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