



### Description


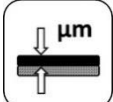
Premium two component hi-solid, high performance acrylic urethane clear. Provides deep gloss/brilliance and protection over different types of basecoats. Ideal clearcoat from spot repair to complete respray, providing excellent chemical resistance and UV protection.


### Suitable Substrates


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


	2	nax Premila 9800 Clear 2K Premium Hi-Solid 2:1
	1	nax Premila 980 2K Hardeners
	20-30%	nax Premila Thinners

	<b>Spray-gun setup:</b>	<b>Application Pressure:</b>
	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

	1 ½ - 2 coats		25-35 µm /coat
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	<b>Between coats:</b>	<b>Before 60°C (140°F) baking:</b>
	5 - 10 minutes at   20°C   70°F	10-15 minutes at   20°C   70°F

		20°C (70°F)	30°C (86°F)	40°C (100°F)	60°C (140°F)	Infra-Red
	Dust dry	20-40 min.	10-30 min.	5-20 min.	-	-
	Dry to handle	6-12 hrs.	3-6 hrs.	1½-3 hrs.	20-45 min.	4+8 minutes
	Dry to polish	8-24 hrs.	4-10 hrs.	3-6 hrs.	1 hr. after cooldown	

	VOC	▶ The VOC content of this product in ready to use form is maximum	474 g/liter
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	<b>Use suitable respiratory protection</b>
	Nippon Paint Automotive Refinishes recommends the use of fresh air supply respirator.

For detailed information read entire TDS

**Description**

Premium two component hi-solid, high performance acrylic urethane clear. Provides deep gloss/brilliance and protection over different types of basecoats. Ideal clearcoat from spot repair to complete respray, providing excellent chemical resistance and UV protection.

**Suitable Substrates**

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

**Product and Additives**


<b>Product</b>	nax Premila 9800 Clear 2K Premium Hi-Solid 2:1	Acrylic Polyol	
<b>Hardeners</b>	nax Premila 980 2K Hardener	Poly-isocyanate resin	20-40°C
	nax Premila 980 2K Slow Hardener	Poly-isocyanate resin	Above 40°C
	nax Premila 980 RP Rapid Hardener	Poly-isocyanate resin	15-25°C
<b>Thinners</b>	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
<b>Additives</b>	nax Softener		

**Flexible Parts**

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

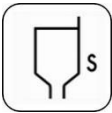
**Notes:** Hard plastic requires no softener. Stir well after adding the additive

**Mixing**

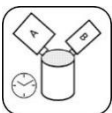
		Hardener/Thinner Selection			
		15-25°C	20-40°C	≥ 40°C	
	2 nax Premila 9800 Clear 2K Premium Hi-Solid				
	1 nax Premila 980 2K Hardeners	1-2 panels	RP/10	RP/20	Std/30
	20-30% nax Premila Thinners	3-5 panels	RP/20	Std/20	Slow/30
		>5 panels	Std/30	Std/30	Slow/40


**Notes:** Above ratio is for both normal and flexible system  
Stir after each added component


**Viscosity (DIN 4 Cup)**

	20°C(70°F)	30°C(86°F)
 Standard	15-17 sec	15-17 sec

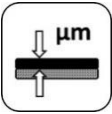
**Pot Life**


	20°C(70°F)	30°C(86°F)	40°C(100°F)
 Standard	3 Hrs.	2 Hrs.	1 Hr.
Slow	4 Hrs.	3 Hrs.	2 Hrs.
Rapid	1½ Hrs.	60 Min.	30 Min.

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


Application	
	<b>1½ coat Application</b>
	▶ Apply one light coat, then allow to flash for 2-5 minutes.
	▶ Apply a wet 2 <sup>nd</sup> coat.
	<b>2 coat Application</b>
▶ Apply one medium coat, then allow to flash for 5-10 minutes.	
▶ Apply a wet 2 <sup>nd</sup> coat.	

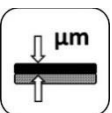
**Notes:** Flash-off time depends on ambient temperature, applied layer thickness and airflow.

Film thickness	
	Using the recommended application technique 50-70 µm

Drying time						
	<b>Dust dry</b>	<b>20°C(70°F)</b>	<b>30°C(86°F)</b>	<b>40°C(100°F)</b>	<b>60°C(140°F)</b>	<b>Infra-Red</b>
	▶ Standard	40 min.	30 min.	20 min.	-	n/a
	▶ Slow	60 min.	45 min.	30 min.	-	n/a
	▶ Rapid	20 min.	10 min.	5 min.	-	n/a
	<b>Dry to handle</b>					
	▶ Standard	12 hrs.	6 hrs.	3 hrs.	45 min.	4+8 min.
	▶ Slow	16 hrs.	8 hrs.	4 hrs.	40 min.	4+10
	▶ Rapid	6 hrs.	3 hrs.	1½ hrs.	20 min.	4+8 min.
	<b>Dry to Polish</b>					
	▶ Standard	16 hrs.	10 hrs.	6 hrs.	1 hour after cool down	
	▶ Slow	24 hrs.	12 hrs.	8 hrs.		
	▶ Rapid	8 hrs.	4 hrs.	3 hrs.		

**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 drying 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.
<b>Notes:</b>	

Coverage	
	By using the recommended application, the theoretical material coverage is: ▶ ± 8 m <sup>2</sup> /liter RTS mixture at 50 -70 µm
<b>Notes:</b>	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 474 g/liter

**Shelflife**



nax Premila 9800 Clear 2K Premium Hi-Solid 2:1  
 nax Premila 980 2K Hardeners  
 nax Premila Thinners  
 Minimum storage temperature: 5°C (41°F)      Maximum storage temperature: 35°C (95°F)

**Notes:** Avoid extreme temperature fluctuation.

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**PROFESSIONAL USE ONLY**

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