



Description


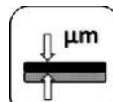
One-pack chromate free, fast drying anti-corrosive etching primer for pre-treatment for light metals and alloys. Used to provide optimal corrosion protection and adhesion to the subsequently applied coatings. Can be also sprayed with airless application.

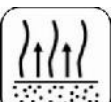
Suitable Substrates


Steel	Galvanized Steel	Aluminum
Existing finishes	Polyester laminates	nax polyester bodyfillers & putties


	5 naxPro LV1600 Wash Primer 1K CF
	3 nax Pro LV5000 Thinners


	Spray-gun setup: Gravity fed 1.3-1.5 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
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	1-3 coat		10-20 µm / coat
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	Between coats 5 - 10 minutes at 20°C 70°F
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	Dry to recoat	20°C (70°F)	30°C (86°F)	40°C (100°F)
	nax Pro LV5000 Fast Thinner	10-15 min	-	-
	nax Pro LV5000 Medium Thinner	20-30 min	10-15 min	5-10 min
	nax Pro LV5000 Slow Thinner	-	20-30 min	10-15 min

	Re – coatable with: With all nax Pro LV and Premilaprimer fillers and surfacers With naxPremila2K topcoat systems
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	2004/42/II B(c)(780)695 The EU limit value for this product (product category: IIB.c) in ready to use form is max 780 g/liter The VOC content of this product in ready to use form is maximum 695
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	Use suitable respiratory protection Nippon Paint Automotive Refinishes recommends the use of fresh air supply respirator.
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For detailed information read entire TDS

Description

One-pack chromate free, fast drying anti-corrosive etching primer for pre-treatment for light metals and alloys. Used to provide optimal corrosion protection and adhesion to the subsequently applied coatings.

Suitable Substrates

Steel	Galvanized Steel	Aluminum
Existing finishes	Polyester laminates	nax polyester bodyfillers & putties

Product and Additives

Product naxPro LV1600 1K Wash Primer 1K CF
Hardeners naxPro LV5000 Thinners

Surface preparation



Prior to any surface preparation, degrease the repair area using nax solvent borne 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



Removal of existing finish and initial sanding of polyester bodyfiller/putty	P120
Feather edge before polyester/putty and finish, sanding for complete panel priming	P220
Feather edge and final step for primer/surfacer for spot repairs, (ED) coated parts	P320
Abrasive blasted steel	SA 2.5 - 3.0



Prior to wash primer application degrease the area using nax solvent borne degreaser. Use clean quality rags or wiping towels, one for wetting and one for drying the surface. 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.

Mixing



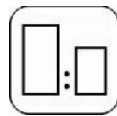
Mixing Machine

For best performance, stir primer on mixing machine twice a day for 15 minutes



Product Mix

Stir well, after each added component.

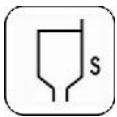


Volume	Weight	
5		naxPro LV 1600 Wash Primer 1K CF
1.5-3		nax LV 5000/Fast/Medium/Slow Thinners

Thinner selection		
Fast	Medium	Slow
15-18°C	23-25°C	>25°C

Notes: Stir after each added component

Viscosity (DIN 4 Cup)



	20°C (70°F)	
5:3	22-25	sec
5:1.5	44-48	sec

Notes:

Pot Life



	20°C (70°F)	30°C (86°F)	40°C (100°F)
5:3 (conventional application)	24 hours	24 hours	18 hours
5:1.5 (airless application)	24 hours	24 hours	18 hours

Notes: Passed the potlife, primer loses its etching property.

Spray gun set-up / application pressure



Spray-gun type	Nozzle size	Application pressure
Gravity	1.4-1.6 mm	Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)
Airless	0.28-0.33 mm	100-120 bar at the spray gun air inlet

Notes:

Application



5:3 (conventional application)	Depending on desired film build	2-3 coats
5:1.5 (airless application)	Depending on desired film build	1 coats

Apply two medium coat with 5-10 minutes flash off between coats on the sanded repair area

Notes:

Allow each coat to flash-off naturally, do not force-dry by air support
Flash-off time depends on ambient temperature, applied layer thickness and airflow.
Recommended application condition: 15-35 °C and 20-80% relative humidity

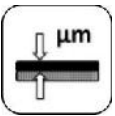
Re-coating time



	20°C (70°F)	30°C (86°F)	40°C (100°F)
Conventional application	20 min	15 min	10 min
Airless application	30 min	20 min	15 min
Recoat within 48 hours			

Notes:

Film thickness



Conventional application	Using the recommended application technique	10-20 µm/coat
Airless application	Using the recommended application technique	40-60 µm/coat

Notes:

Final sanding



After 30 minutes drying etch primer can scuffed prior to primer surfacer application
Dry scuffing: P400



After scuffing degrease the surface using naxsolventborne 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:

Re-coating

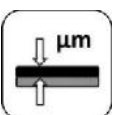


With all nax Pro LV and Premila primerfillers and surfacers
With Premila 2K topcoat systems

Notes:

To replicate OEM system and to achieve the highest quality always apply a primer surfacer prior to topcoat.

Coverage




By using the recommended application, the theoretical material coverage is:
20 µm ± 10m²/liter RTS mixture at Spraying Gravity Gun
50 µm ± 04m²/liter RTS mixture at Airless Spraying

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 nitrocellulose solvents

Solvent Content

	2004/42/IIB(c)(780)695		
	The EU limit value for this product (product category: IIB.c) in ready to use form is max	780	g/liter
	The VOC content of this product in ready to use form is maximum	695	g/liter

Shelflife

	nax Pro LV1600 Wash Primer 1K CF		
	nax Pro LV5000 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.

OAR.03.012. 300517
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