

Description

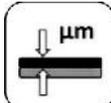
One-pack chromate free, fast drying anti-corrosive etching primer for pre-treatment for light metals and alloys. Used to provide optimal corrosion protection and adhesion to the subsequently applied coatings. Can be also sprayed with airless application.

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: | Application Pressure: |
| | Gravity fed 1.3-1.5 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 |

| | | | |
|---|----------|---|-----------------|
|  | 1-3 coat |  | 10-20 µm / coat |
|---|----------|---|-----------------|

| | |
|---|----------------------|
|  | Between coats |
| 5 - 10 minutes at | 20°C 70°F |

| | | | | |
|---|-------------------------------|--------------------|--------------------|---------------------|
|  | 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 |

| | | |
|---|---|-------------|
|  | 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 |

| | |
|---|---|
|  | Use suitable respiratory protection |
| | Nippon Paint Automotive Refinishes recommends the use of fresh air supply respirator. |

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

| | | |
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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



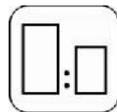
Mixing Machine

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



Product Mix

Stir well, after each added component.

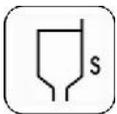


| Volume | Weight | |
|--------|--------|---------------------------------------|
| 5 | | naxPro LV 1600 Wash Primer 1K CF |
| 1.5-3 | | nax LV 5000/Fast/Medium/Slow Thinners |

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

Notes: Stir after each added component

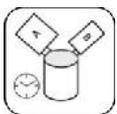
Viscosity (DIN 4 Cup)



| | 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

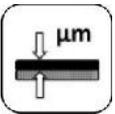
Re-coating time



| | 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

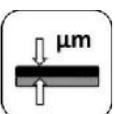


With all nax Pro LV and Premila primerfillers and surfacers
With Premila 2K topcoat systems

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

| | | | |
|---|---|-----|---------|
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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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