

Description
 nax Pro LV3200 Epoxy Primer Surfacer is a two component quick drying epoxy primer. It provides excellent adhesion to multiple metal substrates. Excellent moisture and chemical resistance. Can be used as wet on wet or sanding.

Suitable Substrates

Existing finishes Steel, Stainless Steel	Electro-coat (ED) Galvanized Steel, Aluminum	Polyester laminates nax polyester bodyfillers & putties
---------------------------------------------	-------------------------------------------------	------------------------------------------------------------

	1 nax Pro LV3200 Epoxy Primer 1 nax Pro LV320 Hardener
--	-----------------------------------------------------------

	Spray-gun setup: Gravity fed 1.2-1.4 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
--	-----------------------------------------------------	--------------------------------------------------------------------------------------------------------------------------------------

	1 coat wet on wet 2 - 3 coats sanding		20-30 μm / coat
--	------------------------------------------	--	-----------------

	Between coats: 5 - 10 minutes at 20°C 70°F 10 - 15 minutes at 20°C 70°F
--	---------------------------------------------------------------------------------------------

	Dry to re-coat Dry to sand	20°C (70°F) 15-30 min. 3 hours	30°C (86°F) 10-20 min. 2 hours	40°C (100°F) 5-10 min. 1.5 hours	60°C (140°F) N/A 45 min.	Infra-Red n/a 4+8 min
--	-------------------------------	--------------------------------------	--------------------------------------	----------------------------------------	--------------------------------	-----------------------------

	Final dry sanding: P400- P500		Final wet sanding: P800-P1000
--	-----------------------------------------	--	-----------------------------------------

	Re – coatable with: With all nax Pro / Pro LV and Premila surface preparation products With nax E ³ WB and Premila topcoat systems
--	------------------------------------------------------------------------------------------------------------------------------------------------------------

	2004/42/IIIB(c)(540)537 ▶ The EU limit value for this product (product category: IIB.c) in ready to use form is max 540 g/liter ▶ The VOC content of this product in ready to use form is maximum 537
--	--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------

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

Read complete TDS for detailed product information

Description

nax Pro LV3200 Epoxy Primer Surfacer is a two component quick drying epoxy primer. It provides excellent adhesion to multiple metal substrates. Excellent moisture and chemical resistance. Can be used as wet on wet or sanding.

Suitable Substrates (Surfacers)

Existing finishes Steel, Stainless Steel	OEM Electro-coat (ED) Galvanized Steel, Aluminum	Polyester laminates nax polyester bodyfillers & putties
---------------------------------------------	-----------------------------------------------------	------------------------------------------------------------


Product and Additives

Product	nax Pro LV 3200 Epoxy Primer Surfacer	Temperature range 10-40°C
Hardener	nax Pro LV 320 Epoxy Hardener	


Basic Raw Materials

nax Pro LV3200 Epoxy Primer Surfacer
nax Pro LV320 Epoxy Hardener


Surface preparation



- ▶ Prior to any surface preparation remove oily contamination using nax solventborne 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 epoxy primer application degrease the surface using nax solventborne 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: Respect 100 grit maximum jump in dry sanding steps.

Mixing



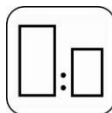
Mixing Machine

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



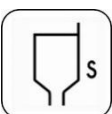
Product Mix

Stir well, after each added component.

	Volume	Weight	
	1	100	nax Pro LV3200 Epoxy Primer Surfacer
	1	52	nax Pro LV320 Epoxy Hardener

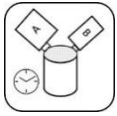
Notes: Stir after each added component

Viscosity (DIN 4 Cup)

	20°C (70°F)	30°C (86°F)
	14-15 sec	16-18 sec

Notes:

Pot Life



20°C (70°F)	30°C (86°F)	40°C (100°F)
6 hours	4 hours	2 hours

Notes:

Spray gun set-up / application pressure



Spray-gun type	Nozzle size	Application pressure
▶ Gravity (HVLP, LVLP)	1.2-1.4 mm	Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)

Notes:

Application



		Number of coats
▶ Sanding	Depending on required film build	2-3 coats
▶ Wet on Wet		1 coat
Sanding	Apply one medium coat over the sanded repair area, then allow to flash for 5-10 minutes. Apply the 2 nd and 3 rd wet coat within each previous coats allowing 5-10 min between coats. Where a full panel application is required apply 2-3 coats over the total panel.	
Wet on Wet	Apply one flowing coat over the panel	

Notes: Allow each coat to flash-off naturally until the surface is completely matt, Do not force-dry by air support. Apply product above 15°C and below 80%RH. Proper flash off helps achieving higher film build. Flash-off time depends on ambient temperature, applied layer thickness and airflow. For maximum build use large fluid tip and lower the application pressure.

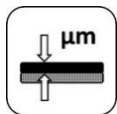
Drying time



	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	IR
Dry to recoat with bodyfiller	30 min.	20 min	10 min	n/a	n/a
Dry to recoat with Surfacer or topcoat	15 min.	10 min.	5 min.	n/a	n/a
Dry to sand	3 hours	2 hours	1.5 hour	45 min.	4+8 min.

Notes: Recoat within 12 hour. After 12 hours of drying the primer must be abraded prior to proceeding applications. Allow 10 minutes flash off prior to Infra-Red drying.

Film thickness



Using the recommended application technique 20-30 µm/coat

Notes: To obtain the best corrosion protection over bare steel, the recommended minimum DFT is 80 µm.

Final sanding



In case as sanding application nax Pro LV3200 Epoxy PS can be sanded as follows:

- ▶ Finishing dry sanding steps in case of surfacer application: P320
- ▶ Finishing dry sanding steps in case of topcoat application: P400-P500



- ▶ Prior to SB topcoat application degrease the surface using nax solventborne degreaser.
- ▶ Prior to WB basecoat application degrease the surface using nax E³ WB Silicone Off.
- ▶ 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: Respect 100 grit maximum jump in dry sanding steps

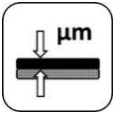
Re-coating



With all nax Pro / Pro LV and Premila surface preparation products (incl. polyester bodyfillers/putty)
 With nax E³ WB basecoat and Premila topcoat systems

Notes:

Coverage



By using the recommended application, the theoretical material coverage is:
 ± 13 m²/liter RTS mixture at 30μm

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 or nitrocellulose solvents

Solvent Content



2004/42/IIB(c)(540)537

The EU limit value for this product (product category: IIB.c) in ready to use form is max	540	g/liter
The VOC content of this product in ready to use form is maximum	537	g/liter

Shelflife



nax Pro LV3200 Epoxy primer
 nax Pro LV320 Hardener

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

Notes:

Avoid extreme temperature fluctuation.

OAR.04.010. 300517

Professional Use Only

Brand names and Logos mentioned in this data sheet are trademarks of or are licensed to NIPPON PAINT.

This product is for professional use only and not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, or as a warranty, nor the suitability of the products for a specific purpose. Standard drying times quoted are average times at 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only. In the light of experience and our policy of continuous product development, they may change without prior information and do not constitute the agreed contractual quality of the products (product specification).

It is always the responsibility of the recipient of our products to ensure that any proprietary rights, existing laws, legislation are observed and to take all necessary steps to fulfill the demands set out in the local rules and legislation. **THE LATEST VERSION OF TDS SUPERSEDES ALL PREVIOUS VERSIONS.**