Description

Productive VOC compliant grey shade two-pack Extra High Built (XHB), High Built (HB) and Wet-on-Wet (WOW) surfacer, with excellent application and sanding properties. Helps to reduce process time and provides good enamel hold-out with automotive topcoats. WOW can be applied on sound OEM e-coat.

Suitable Substrates

Existing finishes	Steel and Electro-coat (ED)	Glass reinforced laminates

nax Pro LV and nax etch primers, plastic primers, epoxy primers and polyester bodyfillers & putties

3	nax Pro LV3601/04/07 VHS Primer Surfacer
1	nax Pro LV360 Hardener
0.6-1.2	nax Pro LV5000 Thinners

Spray-gun setup:

Gravity fed | 1.3-1.8 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 for WOW	25-35 µm /coat
2 - 3 coats for HB	50-60 µm /coat
1 - 2 coats for XHB	60-80 µm /coat

Between coats:

5 - 10 minutes at | 20°C | 70°F

Before 60°C (140°F) baking:

5 - 10 minutes at | 20°C | 70°F

	20°C (70°F)	30°C (86°F)	40°C (100°F)	60°C (140°F)	Infra-Red
Dry to recoat (WOW)	30 min.	20 min.	10 min.		
Dry to sand (XHB & HB)	3 hours	2½ hours	1½ hours	30 min.	4+8 min.

Final dry sanding:

P400-P500

Final wet sanding:

P800-P1000

Re-coating:

With nax E-Cube WB Basecoat, nax Premila 8000 Basecoat and nax Premila 7000 2K Topcoat

VOC

2004/42/IIB(c)(540)539

- The EU limit value for this product [product category: IIB(c)] in ready to use form is maximum 540 g/liter
- The VOC content of this product in ready to use form is maximum 539 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

Productive VOC compliant grey shade two-pack Extra High Built (XHB), High Built (HB) and Wet-on-Wet (WOW) surfacer, with excellent application and sanding properties. Helps to reduce process time and provides good enamel hold-out with automotive topcoats. WOW can be applied on sound OEM e-coat.

Suitable Substrates

Existing finishes | Steel and Electro-coat (ED) | Glass reinforced laminates
nax Pro LV and nax etch primers, plastic primers, epoxy primers and polyester bodyfillers & putties

Product and Additives

Products	nax Pro LV3601 VHS Primer Surfacer (White)	Acrylic resin	
	nax Pro LV3604 VHS Primer Surfacer (Grey)	Acrylic resin	
	nax Pro LV3607 VHS Primer Surfacer (Black)	Acrylic resin	
Hardeners	nax Pro LV360 Hardener	Poly-isocyanate resin	15- 40°C
Solvents	nax Pro LV5000 Thinner Fast	Blend of Solvent	15-20°C
	nax Pro LV5000 Thinner Medium	Blend of Solvent	20-25°C
	nax Pro LV5000 Thinner Slow	Blend of Solvent	25-35°C
Additives	nax Pro LV4100 Anti-Silicone		
	nax Pro LV4200 Flexible Additive		

Surface preparation

- Prior to any surface preparation remove oily contamination 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 before spraying primer/surfacer for spot repairs.	P320
▸ Sound OEM electro (ED) coated parts: DEGREASE ONLY.	

- Prior to primer surfacer application degrease the surface 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.

Notes: *Respect 100 grit maximum jump in dry sanding steps*

Gray Shade Mix (3601 : 3607)

Shade	Impression	Tone	3601	3604*	3607
S1		White	100	-	-
S2		Extra Light Gray	90	-	10
S3*		Light Gray	70	*	30
S4		Medium Gray	50	-	50
S5		Dark Gray	30	-	70
S6		Extra Dark Gray	90	-	10
S7		Black	-	-	100

Notes: *Stir well after adding the different tones together*
**nax Pro LV3604 VHS Primer Surfacer is similar to shade S3 and can be used as a standalone quick gray solution.*

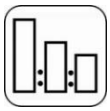
Mixing

Mixing Machine

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

Product Mix

Stir well, after each added component.

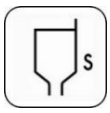


XHB	HB	WOW	
3	3	3	nax Pro LV3601/04/07 VHS Primer Surfacer
1	1	1	nax Pro LV360 Hardener
0.6	0.9	1.2	nax Pro LV5000 Thinners

Thinner Selection			
	15-20°C	20-25°C	25-35°C
1-2 panels/spot	Fast	Medium	Slow
3-5 panels	Medium	medium	Slow
>5 panels	Slow	Slow	Slow

Notes: *Stir after each added component*

Viscosity (DIN 4 Cup)



	20°C (70°F)
▸ XHB	30-45 sec.
▸ HB	24-28 sec.
▸ WOW	19-23 sec.

Notes:

Pot Life

	20°C (70°F)	30°C (86°F)	40°C (100°F)
▸ XHB & HB	60 min.	40 min.	20 min.
▸ WOW	90 min.	60 min.	30 min.

Notes:

Spray gun set-up / application pressure

	Spray-gun type	Nozzle size	Application pressure
▸ XHB & HB	Gravity	1.6-1.8 mm	Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)
▸ WOW	Gravity	1.3-1.4 mm	Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)

Application

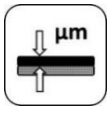
		Number of coats
▸ XHB & HB	Depending on required film build	2-3 coats
▸ WOW		1 coat

Sanding	Apply one medium coat over the sanded repair area, then allow to flash for 5-10 minutes.
	Apply the 2nd and 3rd 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 on the panel.

Notes:

Allow each coat to flash-off naturally until the surface is completely matt. Do not force-dry by air support.
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.

Film thickness



▸ XHB	Using the recommended application technique	60-80 µm/coat
▸ HB	Using the recommended application technique	50-60 µm/coat
▸ WOW	Using the recommended application technique	25-35 µm/coat

Drying time

	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	IR
Dust dry	5-10 min.	5-7 min.	3-5 min.	n/a	n/a
Dry to recoat with topcoat (WOW)	15-20 min.	10 min.	5 min.	n/a	n/a
Dry to sand (HB &XHB)	3 hours	2 hours	1 hour	30 min.	4+8 min.

Notes: ***Recoat wet-on-wet application within 3 hours****. After 3 hours of drying the primer must be sanded prior to proceeding applications.*
Allow 10 minutes flash off prior to Infra-Red drying.
Following the drying cycle at 60°C (140°F) object temperature, allow product to completely cool down to ambient temperature.

Finishing surface preparation

- Finishing dry sanding steps: 2K Topcoat / Basecoat: P400/P500
- Initial dry sanding step may be executed with a coarser grit: P320
- For spot repair, finish the blending area with: P500

- Finishing wet sanding steps: 2K Topcoat / Basecoat: P800/P1000
- Initial dry sanding step may be executed with a coarser grit: P320
- Initial wet sanding step may be executed with a coarser grit: 2K Topcoat / Basecoat: P600/P800
- For spot repair, finish the blending area with: P1000

- Prior to SB topcoat application degrease the surface using nax solvent-borne degreaser.
- Prior to WB basecoat application degrease the surface using nax E-Cube 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.

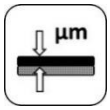
Notes: *Respect 100 grit maximum jump in dry sanding steps and 200 grit maximum jump in wet sanding steps.*

Re-coating

With nax E-Cube WB Basecoat, nax Premila 8000 Basecoat and nax Premila 7000 2K Topcoat (direct gloss)

Notes: *Avoid applying polyester bodyfiller on top of the primer surfacer.*

Coverage



By using the recommended application, the theoretical material coverage is:

±8	m²/liter RTS mixture at	50µm	XHB & HB
±13	m²/liter RTS mixture at	30µm	WOW

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 gun cleaners

Solvent Content

2004/42/IIB(c)(540)539

The EU limit value for this product [product category: IIB(c)] in ready to use form is maximum	540	g/liter
The VOC content of this product in ready to use form is maximum	539	g/liter

Shelf-life

nax Pro LV3601/04/07 VHS Primer Surfacer			
nax Pro LV360 Hardener			
nax Pro LV5000 Thinners			
Minimum storage temperature:	5°C (41°F)	Maximum storage temperature:	35°C (95°F)

Notes: *Avoid extreme temperature fluctuation.*

OAR.04.011. 140917

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.**