Description

nax Pro LV7400 HS Clear is a two component high solid 1 ½ coat clearcoat with an increased scratch resistance. Designed to suit all repair sizes from spot repair to a complete respray. Provides high gloss, extra hardness, exceptional flow, and good protection against weathering.

Suitable Substrates

nax Premila 8000 series base coat (solvent-borne)

nax E³ WB basecoat (water-borne)

2	nax Pro LV7400 HS Clear
1	nax Pro LV740 Hardeners
0-10%	nax Pro LV5000 Thinners

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 ½ coats w/o thinner

2 - 3coats with thinner

45-60	µm	1 ½ coat
50-60	µm	2 coats
60-75	µm	3 coats

Between coats:

3 - 5 minutes at | 20°C | 70°F

Before 60°C (140°F) baking:

3 - 5 minutes at | 20°C | 70°F

Drying	20°C (70°F)	30°C (86°F)	40°C (100°F)	60°C (140°F)	Infra-Red
Dust dry	20-30 min	10-20 min	5-10 min	n/a	n/a
Dry to handle	6-12 hours	3-6 hours	1.5-3 hours	20-40 min	4+8 min
Dry to polish	6-12 hours	3-6 hours	1.5-3 hours	2hrs after cool down	4+8 min

VOC

2004/42/IIb(e)(840)545

- The EU limit value for this product (product category: IIB.e) in ready to use form is max 840 g/liter
- The VOC content of this product in ready to use form is maximum 545

Use suitable respiratory protection

Nippon Paint Automotive Refinishes recommends the use of fresh air supply respirator.

For detailed information read entire TDS

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Suitable Substrates

nax Premila 8000 series base coat (solvent-borne) nax E³ WB basecoat (water-borne)

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

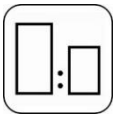
Product and Additives

Product	nax Pro LV7400 HS Clear	
Hardener	nax Pro LV740 Hardener Fast	15-20°C
	nax Pro LV740 Hardener Medium	20-25°C
	nax Pro LV740 Hardener Slow	30-40°C
Solvents	nax Pro LV5000 Thinner Fast	15-20°C (1-2 panel)
	nax Pro LV5000 Thinner Medium	20-25°C (3-5 panel)
	nax Pro LV5000 Thinner Slow	30-40°C (>5 panel)
Additives	nax Pro LV5101 Topcoat Blending Thinner Spray	
	nax Topcoat Blending Thinner	
	nax Pro LV4000 Accelerator	
	nax Pro LV4200 Flexible Additive	

Basic Raw Materials

nax Pro LV7400 HS Clear	Acrylic resins
nax Pro LV740 Hardener	Poly-isocyanate resin
nax Pro LV5000 Thinners	Blend of solvents

Mixing

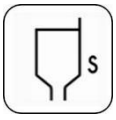


2	nax Pro LV7400 HS Clear
1	nax Pro LV740 Hardener
0-10%	nax Pro LV5000 Thinners

Hardener/Thinner selection			
Surface	**15-20°C**	**20-25°C**	**25-35°C**
1-2 panels/spot	Fast/Fast	Med./Fast	Med./Med.
3-5 panels	Fast/Fast	Med./Med.	Med./Slow
>5 panels	Fast/Med	Med./Slow	Slow/Slow

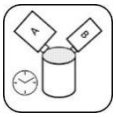
Notes: *Stir after each added component*

Viscosity (DIN 4 Cup)



	20°C(70°F)	**30°C(86°F)**	**40°C (100°F)**
▸ W/o Thinner	17-19 sec	16-18 sec	15-17 sec
▸ With Thinner	15-17 sec	14-16 sec	13-15 sec

Pot Life



	20°C(70°F)	**30°C(86°F)**	**40°C(100°F)**
▸ Slow / Medium Hardener	2 hours	1.5 hours	1 hours
▸ Fast Hardener	30 Min	25 min	20 min

Spray gun set-up / application pressure

Spray-gun type	Spray-gun type	Nozzle size	Application pressure
▸ LVLP	Gravity	1.2-1.4 mm	1.7-2.2 bar at the spray gun air inlet
▸ HVLP	Gravity	1.2-1.4 mm	(HVLP: max 0.6-0.7 bar at the air cap)

Application

1 ½ coat Application	▸	Apply one light coat, then allow to flash for 1-3 minutes. Apply the 2nd flowing coat.
2-3 coat Application	▸	Apply one medium coat, then allow to flash for 3-5 minutes. Apply the 2nd and if required a 3rd wet coats allowing 3-5 minutes between coats.

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

Drying time

Dust dry	**20°C(70°F)**	**30°C(86°F)**	**40°C(100°F)**	**60°C(140°F)**	**Infra-Red**
▸ Slow Hardener	30 min.	20 min.	10 min.	n/a	n/a
▸ Medium Hardener	25 min.	15 min.	7 min.	n/a	
▸ Fast Hardener	20 min.	10 min.	5 min.	n/a	
Dry to handle and polish					
▸ Slow Hardener	12 hours	6 hours	3 hours	40 min.	4+8 min.
▸ Medium Hardener	8 hours	4 hours	2 hours	30 min.	
▸ Fast Hardener	6 hours	3 hours	1.5 hours	20 min.	

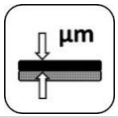
Notes:
Indicated drying times are panel temperatures. Oven temperature should be set 10 °C higher.
Allow 10 minutes flash off prior to Infra-Red drying.
The panel must not reach a temperature above 100°C (210°F) while curing.
Following the drying cycle at 60°C (140°F) object temperature, allow product to completely cool down to ambient temperature.
Using fast hardener at high temperatures can decrease the gloss.

Polishing

Following the recommended ambient drying or **after the 2 hours cool down** time following the full bake at 60°C object temperature, carefully sand out dust particles and restore the surface according polishing recommendations.

Notes:

Film thickness



1 ½ coats application	Using the recommended application technique	45-60 µm
2 coats application	Using the recommended application technique	50-60 µm
3 coats application	Using the recommended application technique	60-75 µm

Coverage

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

▸ ±8 m²/liter RTS mixture at 50 µm

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

Solvent Content

2004/42/IIb(e)(840)545

The EU limit value for this product (product category: IIB.e) in ready to use form is max	840	g/liter
The VOC content of this product in ready to use form is maximum	545	g/liter

Shelflife

nax Pro LV7400 HS Clear			
nax Pro LV740 Hardeners			
nax Pro LV5000 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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