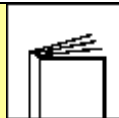




Automotive System

## Nax 2400 Urethane Primer Grey



Technical  
Information

Version 1, 04/2013

### PRODUCT DESCRIPTION

NAX 2600 URETHANE PRIMER GREY is the premium quality 2K urethane primer-surfacer for automotive refinish and general use. It is designed for all spray application-form spot repair to overall repair.



#### Paint system

- High solid and provide excellent gloss holdout
- Excellent filling properties
- Fast dry, Easy wet and dry sandability
- Excellent adhesion



#### Surface preparation

- Ensure that surface of the previous coat was clean and dry, free from dirt, rust, grease, oil and other foreign matter. Before recoating, Nax Silicone off # 101 can be applied for cleaning and degreasing before wiped dry with clean and dry cloths. For old paint film, wet sanding P400-600 (hand) or dry sanding P240-320 (machine)

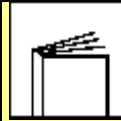
The Product is suitable strictly for professional use only. The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only.

Nippon Automotive System,  
Nippon Paints (Thailand) Co. Ltd.,  
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SAMUTPRAKAN 10130, BANGKOK, THAILAND



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## Application Guide



Mixing ratio	Product	By Volume	By Weight
	NAX 2400 Urethane Primer Grey	4 parts	6 parts
	NAX 240 Urethane Primer Hardener	1 part	1 part
	Nax Premila 500 Standard Thinner	1-2 parts	1-2 parts
	<b>For Plastic Part</b>		
	NAX 2400 Urethane Primer Grey	4 parts	6 parts
	NAX Softener	0.5part	0.5 part
	NAX 240 Urethane Primer Hardener	1 part	1 part
	Nax Premila 500 Standard Thinner	1-2 parts	1-2 parts

**Pot Life** 4 hours after mixed with hardener @ 30°C

**Application window** Temperature 15°C to 38°C & Relative Humidity – 20% to 85%  
(Lower temperatures may slow down the curing rate),



**Spraying viscosity**

Viscosity/sec	@ 25°C
NK # 2	13 to 15
Ford Cup # 4	16 to 18



**Spray gun** Gravity Feed  
**Set-up** full pattern, flow – 3 turns from fully closed set-up,  
**Nozzle size &** 1.4 – 1.5 mm,  
**Spray pressure** 3.0 – 4.0 kg/cm<sup>3</sup>



**Drying times**

Condition	@ 30°C	baking@60°C - 30 mins.
Dry to Sand	60 - 90 mins	30 – 60 mins

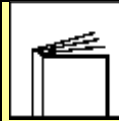
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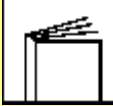
Version 1, 04/2013

## Application

	Number of spray coats	<p>2 single coats</p> <ul style="list-style-type: none"> <li>• Light to medium first coat</li> <li>• Full wet second coat <ul style="list-style-type: none"> <li>○ Recommended dry film thickness – 40 to 60µm</li> <li>○ Clean the spray gun immediately after use</li> </ul> </li> </ul>
	Flash-off time	<ul style="list-style-type: none"> <li>• Between coats - 5 minutes @ 30°C / 60% R.H.</li> <li>• Set time prior to force drying @ 60°C – 0 to 10 minutes</li> </ul> <p><i>* The specified flash times may vary with temperature &amp; air velocity in the spray booth.</i></p>
	<b>Drying times</b>	<p>Flash-off time 0-10 minutes prior to moving the car or car part into a pre-heated drying oven (booth @ 60°C.</p> <p>All drying times listed below relate to standard application and object temperature.</p>

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 Automotive System	<h1>Nax 2400 Urethane</h1> <h2>Primer Grey</h2>		<h3>Technical Information</h3> <p>Version 1, 04/2013</p>	
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## Product Handling & Safety (for professional use only)

	 <b>Respiratory Mask</b>	 <b>Safety Goggles</b>	 <b>Protective Clothing</b>	 <b>Protective Gloves</b>	 <b>Safety Shoes</b>	<p><i>Please refer to Material Safety Data Sheets for full health &amp; safety details and product can labels. Safety &amp; Risk Phrases: Hardeners contains polyisocyanates and therefore safety precautions must be taken while use</i></p>
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### Waning

- Flammable liquid and vapor
- Harmful, if swallowed
- Toxic, if inhaled (vapor)
- Causes skin irritation
- Causes serious eye irritation
- May causes allergy or asthma symptoms or breathing difficulties if inhaled
- Toxic to aquatic life
- Store in a closed container.
- Avoid release to the environment.
- Keep away from heat/sparks/open flames/hot surfaces.
- Keep container tightly closed.
- Do not allow to get in eyes, on skin, or on clothing.
- Wear protective gloves/protective clothing/eye protection/face protection.
- IF INHALED: if breathing is difficult, remove victim to fresh air and keep at rest in a position comfortable for breathing.
- IF COMES IN CONTACT WITH EYES: Rinse cautiously with excess water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing.

For further information please contact:

TECHNICAL SERVICES DEPARTMENT, NIPPON PAINT AUTOMOTIVE REFINISH BUSINESS UNIT

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