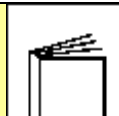




Automotive System

Nax O-de base



Technical
Information

Version 2, 05/2013



PRODUCT DESCRIPTION

NAX O-DE BASE is water system that is environmental friendly. Waterborne basecoat for use in clear over base system. Nax O-DE BASE is developed under **e³** system (**e³** = e-cube), the new coating system produced by the synergistic effect of these three development concepts, EASY – The concept of improving ease of application and colour matching and reducing the time required for coating, EXCITING – The concept of ensuring high opacity and good finish through the incorporation of the latest technology, ECOLOGY-The concept of improving the environment around us by such means as reducing the amount of VOCs emitted.



Paint system

- Easy to spray application, no mottling
- Easy to spot repair
- High build
- Beautiful paint film



Substrate preparation

- Ensure that surface of the previous coat was clean and dry, free from dirt, rust, grease, oil and other foreign matters.
- Primer sanding, dry sanding P400(machine) or wet sanding P800 (hand)

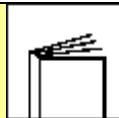
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Nippon Paints (Thailand) Co. Ltd.,
101 MOO 3 SOI SUKSAWAT 76, SUKSAWAT
ROAD, T. BANGCHAK, A. PRAPRADEANG,
SAMUTPRAKAN 10130, BANGKOK, THAILAND



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Application Guide



Mixing ratio Exterior use ; Nax O-de base 100 %, Nax O-de base Thinner 40 %

Interior use (for engine, interior part) ; Nax O-de base 100 %, Nax O-de Hardener 10 %, O-de base Thinner 40 %

*For material transfer efficiency, O-de Base thinner can be 30 %

Thinner

1. NAX O-de Thinner, for humidity > 40%
2. NAX O-de High Temp Thinner, for temperature >40°C
3. Nax O-de Thinner for Low Humidity, for Humidity < 40%
Precautions again orange peel and overspray problem from spray at high temperature (over 40°C), use Nax O-de base high temp thinner about 5 - 10% with Nax O-de base thinner

Condition	Humidity	%Thinner*	Type/Ratio of thinner
Temperature below 30 °C	< 40 %	30 %	Nax O-de Thinner for Low Humidity
	40 – 60 %	30 %	Nax O-de Thinner
	>60 %	30 %	Nax O-de Thinner
Temperature 30 - 40 °C	< 40 %	30 %	Nax O-de Thinner for Low Humidity
	40 – 60 %	30 %	Nax O-de Thinner
	>60 %	30 %	Nax O-de Thinner
Temperature over 40°C	< 40 %	40 %	Nax O-de Thinner for Low Humidity
	40 – 60 %	40 %	100% O-de Thinner + 5% High Temp Thinner
	> 60 %	40 %	100% O-de Thinner + 3% High Temp Thinner

* In case of material transfer efficiency

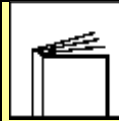
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Application window Temperature 15°C to 38°C & Relative Humidity – 20% to 85%
(Lower temperatures may slow down the curing rate),



Spraying viscosity

Viscosity/sec	@ 25°C
NK # 2	18 to 30
Ford Cup # 4	20 to 30



Spray gun Set-up

Gravity Feed
full pattern,
flow – 3 turns
from fully closed set-up

HVLP type
full pattern,
flow – 3 turns
from fully closed set-up

Nozzle size & Spray pressure

1.2 – 1.4 mm
1.5– 2.0 MPa

1.2 – 1.4 mm
Use by gun producer suggested

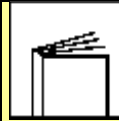
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



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Application

	<p>Number of spray coats</p>	<p>For metallic and Mica; 2+1 coats (2 coats + 1 drop coat) Apply two full coats by 70-80% material transfer efficiency, overlapping pattern 2/3 and then dry each coat with air blow until it completely dried to be matt finish. Apply drop coat to get the good metallic orientation appearance by light to medium spray with more spray distance. Then use air blow to ensure it completely dry.</p> <p>For Solid colour; 2-3 coats Apply two full coats by 70-80% material transfer efficiency, overlapping pattern 2/3 and then dry each coat with air blow until it completely dried to be matt finish. Do not spray at very high volume in order to prevent running/sagging.</p> <p>For spot repair; 2-3 coats Drop spray the under clear on the surface with overlap pattern 1/2 (the under clear spray area should cover more area than the spot area that needed to refinish.) Apply two full coats by 70-80% material transfer efficiency , overlapping pattern 2/3 and then dry each coat with air blow until it completely dried to be matt finish and then apply thin coat until opacity is achieved. Do not spray at very high volume in order to prevent running/sagging. For metallic and mica, apply drop coat to get the good metallic orientation appearance by light to medium spray with more spray distance. Then use air blow to ensure it completely dry.</p>
	<p>Interval time</p>	<p>Use air blow to ensure the paint completely dried. Interval minimum 15 minutes(max 24 hrs.) at 20 C prior to clear application'</p>
	<p>Drying times</p>	<p>Depending on temperature, humidity and Air blow. Dry until the paint skin does not move under your finger when lightly pressed.</p>

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Product Handling & Safety (for professional use only)

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

- 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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