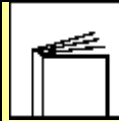




Automotive System

Nax Premila 2K Balance Tint 4000



Technical
Information

Version 1, 04/2013

PRODUCT DESCRIPTION

NAX PREMILA 2K BALANCE TINT 4000 (2K Solid System) is the 2 component top coat for solid colours and can be used for spot, block and overall repair and provides excellent film properties, beautiful color and durability



Paint system

- Easy to spray application, provide film appearance with good smoothness.
- Provide excellent high gloss finish
- Excellent gloss.
- Excellent exposure durability and chemical resistance



Substrate preparation

- Ensure that surface of the previous coat was clean and dry free from dirt, rust, grease, oil and other foreign matters.
- Degreasing and cleaning with Nax Silicone off before recoating and wipe dry with clean, dry cloths.
- Primer sanding, dry sanding P400-600(machine) or wet sanding P800-1000 (hand)

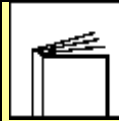
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Application Guide



Mixing ratio	NAX PREMILA 2K BALANCE TINT #4000	2 parts
	NAX PREMILA 2K BALANCE TINT 021 Hardener	1 part
	Thinner	0.5 part

Thinner

1. NAX PREMILA 500 Standard Thinner
2. NAX PREMILA 503 Slow Thinner

Precautions again orange peel and overspray problem from spray at high temperature (over 32°C), please using Nax premila 503 slow thinner about 10-30% with Nax Premila 500 thinner for application

Pot Life 4 hours @ 30°C after mixed hardener

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	12 to 13
Ford Cup # 4	15 to 16



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/cm³

Application

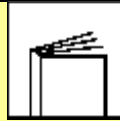
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

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	Number of spray coats	2 – 3 single coats <ul style="list-style-type: none"> • Light to medium first coat • Full wet second coat and third coat <ul style="list-style-type: none"> ○ Recommended dry film thickness – 40 to 60µm ○ Clean the spray gun immediately after use
	Flash-off time	<ul style="list-style-type: none"> • Between coats 3 - 5 minutes @ 30°C / 60% R.H. • Set time prior to force drying @ 60°C – 0 to 5 minutes <i>* The specified flash times may vary with temperature & air velocity in the spray booth.</i>
	Drying times	Flash-off time 0-5 minutes prior to moving the car or car part into a pre-heated drying oven (booth @ 60°C. All drying times listed below relate to standard application and object temperature. The time required for the spray booth to reach an acceptable air temperature to enable the heat transfer of 60°C to the object needs to be considered.

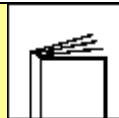


Drying times

Drying type	Air Dry (30°C)	Baking (60°C/30 min)
Surface dry	5 – 10 minute	Immediately
Dry to assembly	2 hours	1 hour
Dry to taping	>6 hours	>4 hours
Dry to polishing	>6 hours	>4 hours

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Product Handling & Safety (for professional use only)

						<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>
	Respiratory Mask	Safety Goggles	Protective Clothing	Protective Gloves	Safety Shoes	



Warning

- 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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