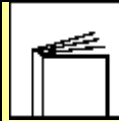




Automotive System

Nax Premila 2K Balance Tint 3000



Technical
Information

Version 1, 04/2013

PRODUCT DESCRIPTION

NAX PREMILA 2K BALANCE TINT 3000 (Basecoat System) is a base coat for metallic, pearl or solid color, use in clear over base system and can be used for spot, block and overall repair and provide excellent film properties, beautiful color and durability.



Paint system

- Easy to spray application, no mottling
- Provide film appearance with good smoothness.
- Easy to color matching
- Easy to touch up repair and fast dry
- High build and excellent hiding power with saving paint consumption.



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 P320-400(machine) or wet sanding P600-800 (hand)

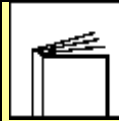
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Nippon Automotive System,
Nippon Paints (Thailand) Co. Ltd.,
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Application Guide



Mixing ratio General Use

NAX PREMILA 2K Balance Tint 3000	1.0 part
THINNER	0.8 – 1.0 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

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	10 to 12
Ford Cup # 4	13 to 15



Spray gun Set-up
Nozzle size & Spray pressure

Gravity Feed
full pattern, flow – 3 turns from fully closed set-up,
1.3 – 1.5 mm,
3.0 – 4.0 kg/cm³

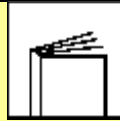
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Automotive System



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Application

	Number of spray coats	2 – 3 single coats <ul style="list-style-type: none"> • Light to medium first coat • Light to medium second coat • Drop third coat <ul style="list-style-type: none"> ○ Pearl; dry film thickness – 20 to 30µm ○ Metallics; dry film thickness – 15 to 25µm
	Flash-off time	<ul style="list-style-type: none"> • Between coats 5 - 10 minutes @ 30°C / 60% R.H. <p><i>* The specified flash times may vary with temperature & air velocity in the spray booth.</i></p>


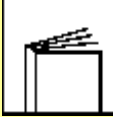


Drying times

Surface Dry	3 – 5 minutes
Dry to top clear	5 – 10 minutes
Dry to recoat	5 – 10 minutes

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 Automotive System	<h1 style="text-align: center;">Nax Premila 2K Balance Tint 3000</h1>		<h2 style="text-align: center;">Technical Information</h2> <p style="text-align: center;">Version 1, 04/2013</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

- 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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