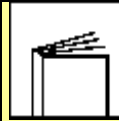




Automotive System

Nax Premila 7000

2K SOLID SYSTEM



Technical
Information

Version 1, 04/2013

PRODUCT DESCRIPTION

NAX PREMILA 7000 (2K Solid System) is the 2K acrylic urethane single state for automotive refinishing.



Paint system

- High solid, Excellent hiding power
- Fast drying
- Excellent gloss.
- Excellent exposure durability and chemical resistance



Substrate preparation

- Ensure that surface on 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)

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.

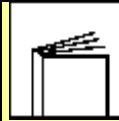
Nippon Automotive System,
Nippon Paints (Thailand) Co. Ltd.,
101 MOO 3 SOI SUKSAWAT 76, SUKSAWAT
ROAD, T. BANGCHAK, A. PRAPRADEANG,
SAMUTPRAKAN 10130, BANGKOK, THAILAND



Automotive System

Nax Premila 7000

2K SOLID SYSTEM



Technical Information

Version 1, 04/2013

Application Guide



Mixing ratio

General Use

NAX PREMILA 7000	4 parts
NAX PREMILA 410 2K Hardener	1 part
Thinner	1-2 parts

For Flexible material, such as bumper

NAX PREMILA 7000	4 parts
NAX PREMILA 410 2K Hardener	1 part
Thinner	1-2 parts

Thinner

1. NAX PREMILA 500 Standard Thinner
2. NAX PREMILA 501 High Temp Thinner

Precautions again orange peel and overspray problem from spray at high temperature (over 32°C), please using Nax premila 501 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 14
Ford Cup # 4	15 to 17



Spray gun

Gravity Feed

Set-up

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

Nozzle size &

1.3 – 1.5 mm,

Spray pressure

3.0 – 4.0 kg/cm³

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.

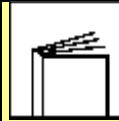
Nippon Automotive System,
Nippon Paints (Thailand) Co. Ltd.,
101 MOO 3 SOI SUKSAWAT 76, SUKSAWAT
ROAD, T. BANGCHAK, A. PRAPRADEANG,
SAMUTPRAKAN 10130, BANGKOK, THAILAND



Automotive System

Nax Premila 7000

2K SOLID SYSTEM



Technical Information

Version 1, 04/2013

Application

	Number of spray coats	<p>2 – 3 single coats</p> <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 - 5 minutes @ 30°C / 60% R.H. • Set time prior to force drying @ 60°C – 0 to 10 minutes <p><i>* The specified flash times may vary with temperature & air velocity in the spray booth.</i></p>
	Drying times	<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> <p>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.</p>


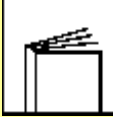


Drying times

Drying type	Air Dry (30°C)	Baking (60°C/30 min)
Surface dry	8 – 10 minute	Set before bake 5–10 min
Dry to assembly	3 hours	2 hours
Dry to taping	>6 hours	>4 hours
Dry to polishing	>8 hours	>6 hours

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.,
101 MOO 3 SOI SUKSAWAT 76, SUKSAWAT
ROAD, T. BANGCHAK, A. PRAPRADEANG,
SAMUTPRAKAN 10130, BANGKOK, THAILAND

 Automotive System	<h2 style="text-align: center;">Nax Premila 7000</h2> <h3 style="text-align: center;">2K SOLID SYSTEM</h3>		<h3 style="text-align: center;">Technical Information</h3> <p style="text-align: center;">Version 1, 04/2013</p>	
---	--	---	--	--

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>
---	--	--	---	---	--	---



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

<p>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.</p>	<p style="text-align: center;">Nippon Automotive System, Nippon Paints (Thailand) Co. Ltd., 101 MOO 3 SOI SUKSAWAT 76, SUKSAWAT ROAD, T. BANGCHAK, A. PRAPRADEANG, SAMUTPRAKAN 10130, BANGKOK, THAILAND</p>
--	---