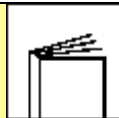




Automotive System

Nax Premila 9400 Top Coat Clear



Technical
Information

Version 1, 04/2013

PRODUCT DESCRIPTION

NAX PREMILA 9400 Top Coat Clear, the premium quality 2K acrylic urethane clear. It is applied on metallic or mica color to providing excellent gloss hold out and appearance. It is ideal for all spray applications from spot repair to overall refinishing.



Paint system

- High build finish
- Fast drying
- It can be applied on NC lacquer, Acrylic lacquer and 2K polyurethane paint.
- Excellent chemical and UV resistance

Suitable Substrates

- Nax Premila 8000 series base coats
(after a minimum flash-off time of 10 minutes @ 30°C)



Substrate preparation

- Must be applied on top of a clean, dry, dust free base coat surface (use of tack rag is suggested to remove dirt & dust particles from the base coat surface).

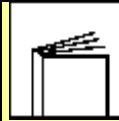
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Nippon Paints (Thailand) Co. Ltd.,
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Application Guide



Mixing ratio **General Use**

NAX PREMILA 9400 Top Coat Clear	4 parts
NAX 410 2K Hardener	1 part
NAX PREMILA 500 Standard Thinner	0 - 10 %

For Flexible material, such as bumper

NAX PREMILA 9400 Top Coat Clear	4 parts
NAX SOFTENER	0.5 part
NAX 410 2K Hardener	1 part
NAX PREMILA 500 Standard Thinner	0 - 10 %

Pot Life 6 hours @ 25°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/cm³

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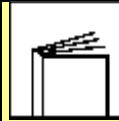
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

Top Coat Clear



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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 • Full wet 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>

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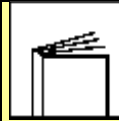
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Drying times

Air dry conditions*

Surface Dry 7 - 10 minutes

Hard Dry 40 - 50 minutes


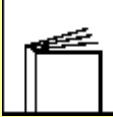
Dry to spot repair >1 hour

Dry to polish >6 hours

*@ 30°C, Relative Humidity ~ 60%

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 Automotive System	<h1 style="text-align: center;">Nax Premila 9400</h1> <h2 style="text-align: center;">Top Coat Clear</h2>		<h3 style="text-align: center;">Technical Information</h3> <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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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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