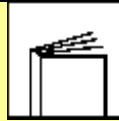




Automotive System

Nax Premila 9800

Clear 2K Premium Hi-Solid 2:1



Technical
Information

Version 1, 04/2013

PRODUCT DESCRIPTION

NAX PREMILA 9800 CLEAR 2K Premium Hi-Solid 2:1, the 2-Component clear coat high solid grade with high performance. To be used in clear over base system to providing deep gloss and brilliance. Can be used for spot, block and overall repair.



Paint system

- High build finish
- Provide film appearance with good smoothness and deep gloss and brilliance
- It can be applied on NC lacquer, Acrylic lacquer and 2K polyurethane paint.
- Can be used over solventborne and waterborne basecoated

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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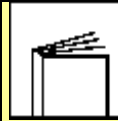
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Application Guide



Mixing ratio	2 to 1	
	NAX PREMILA 9800 Clear 2K Premium Hi-Solid 2:1	2 part
	NAX PREMILA 980 2K Hardener	1 part
	NAX PREMILA 500 Standard Thinner	20 -30 %

Pot Life 1 hour 30 minutes @ 30°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	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 & 1.4 – 1.5 mm,
Spray pressure 3.0 – 4.0 kg/cm³

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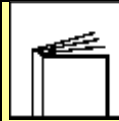
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

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Application

	Number of spray coats	<p>1.5 – 2 single coats</p> <ul style="list-style-type: none"> • Light to medium first coat • Full wet second coat <ul style="list-style-type: none"> ○ Recommended dry film thickness – 50 to 70µm ○ 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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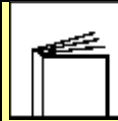
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Drying times

Air dry conditions

Climate conditions* @ 30°C

Dirt free time (minutes) 30 minutes

Dry to handle (hours) 6 hours

Dry to polish (hours) 16 hours

* Relative Humidity ~ 60%

Force dry conditions*

60 °C X 30 minutes

Dirt free time Immediate

Dry to handle 1 hour

Dry to polish 6 hours

*ambient temperature 30°C / 60% R.H.

Complete through hardening of the clear coat will be achieved after approximately 72 hours @ 25°C.

** Under low temperature ambient conditions (less than 20°C) drying behaviour might be slower especially in terms of hard dry for polishing. Hence, it is preferable to force dry the system @ 60°C for 45 to 60 minutes to ensure complete cure and maintain productivity in terms of handling / polishing time.*

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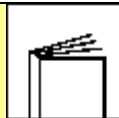
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Product Handling & Safety (for professional use only)

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



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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