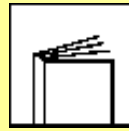




NAX 2800HP 2K VELOCITY PRIMER



Technical Information

Version 1, 02/2014

DESCRIPTION

NAX 2800HP 2K Velocity Primer, The acrylic urethane with high flexible and excellent of Hiding power. Suitable for “Quick Repair” with outstand of fast drying to sand a film at 15 minute by no need to bake (25-30 C). Saving energy and although a time.



Paint System

- 2K Primer sanding after spray at 15 min.
- High solid, No absorption of T/C
- High hiding power, Easy to cover a mark
- Excellent of adhesion on steel and old paint
- Design for spot and 1 blog repair

Substrate

- Steel with properly preparation on surface
- OEM Automotive coating
- Refinish coating
- Putty & Filler
- ABS Plastic



Preparation

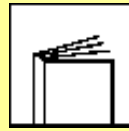
- Clean surface of substrate by no dust, rust, wax and any dirt use NAX Silicone off # 101 clean surfaces before spray primer. Before spray primer need to sand old paint by use sand paper P240-320(Dry sand) and P400-P600(Wet sand)

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



NAX 2800HP 2K VELOCITY PRIMER



Technical Information

Version 1, 02/2014

Mixing Ratios



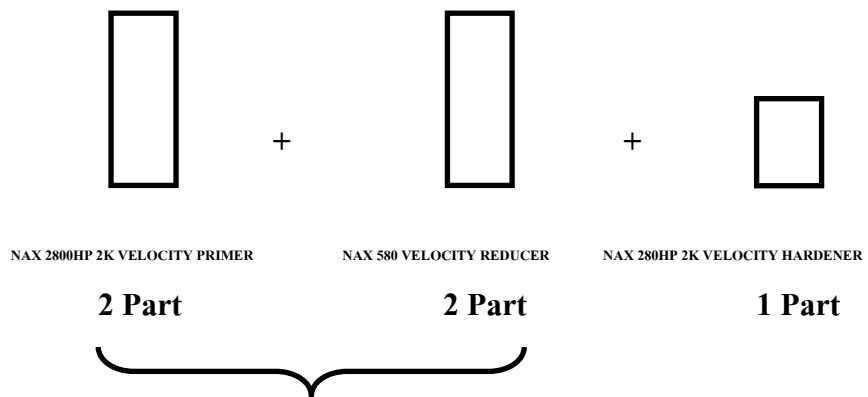
Mixing Ratio 2 : 2 : 1 By Volumetric

100 **By Volumetric** – NAX 2800HP 2K VELOCITY PRIMER

100 **By Volumetric** – NAX 580 VELOCITY REDUCER

***** Mix Primer with Reducer well before mix Hardener *****

50 **By Volumetric** - NAX 280HP 2K VELOCITY HARDENER



Mix well before mix with Hardener

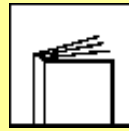
Pot Life	15 min. at 20 C
	15 min. at 25 C
	10 min. at 30 C

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



NAX 2800HP 2K VELOCITY PRIMER



Technical Information

Version 1, 02/2014

Applications Temperature 15°C to 38°C & Relative Humidity – 20% to 85%
 (Lower temperatures may slow down the curing rate and higher temperature may cause a shorter of pot life), Higher humidity cause speed up the curing rate.

Window



Spraying viscosity

Viscosity/Sec.	25 C
Ford # 4	14.0 – 20.0



Spray gun

Gravity Feed

HVLP

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

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

nozzle size

1.4 – 1.5 mm,

1.4 mm

set-up & air pressure

1.5 – 2.0 bar (20-30 psi)

2.0 bar

Application

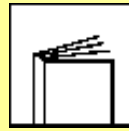
	Number of spray coats	2 single coats Wet on wet <ul style="list-style-type: none"> • Light in first coat and immediately with Full coat 2 Coats <ul style="list-style-type: none"> • Light to medium first coat • Full wet second coat <ul style="list-style-type: none"> ○ Recommended dry film thickness – 40 to 50µ ○ Clean the spray gun immediately after use ○ Appropriate time to wash spray gun should be within 15 minute after mix Hardener
	Flash time (@ 30°C / 60% R.H.)	Between coats 0 - 1 minute @ 30°C / 60% R.H. * The specified flash times may vary with temperature & air ventilation in the spray booth.
	Setting time	Wait primer drying 3 – 5 min. before move substrate to sanding area

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



NAX 2800HP 2K VELOCITY PRIMER



Technical Information

Version 1, 02/2014



Drying

Air Dry Condition

	@ 20°C	@ 25°C	@ 30°C
Dirt free time (min)	7	5	5
Wet sanding (min)	10	10	10
Dry sanding (min)	15	15	15

* Relative Humidity ~ 60%

Force dry

- Baking at 60°C, No need applicable under baking condition
- IR , Half Power distance 80 cm. at 10 min.

Overcoat / Recoat time

Recoat able with itself after complete drying cycle however, sanding is necessary to ensure good adhesion after 60minute using P400 (dry) or P800 (wet).



Wet Sand

Wet sanding use sand paper **P800** and use sanding pad to prevent track of finger on surface



Dry Sand

Dry sanding use sand paper **P400** with sanding machine

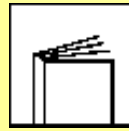
- Carefully of dust from dry sand, ware PPE when operate with dry sanding
- Use support foam pad between machine sanding and sand paper for smoothness and prevent too much of penetration on primer
- Remove any remaining residue using Detailing Cloth.

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



NAX 2800HP 2K VELOCITY PRIMER



Technical Information

Version 1, 02/2014

Storage

- Store in a cool & dry area (avoid temperature above 40°C)
Product shelf-life
 - NAX 2800 2K Velocity Primer = 24 months
 - NAX 580 Velocity Reducer = 12 months
 - NAX 280 2K Velocity Primer Hardener = 12 months
- All product stored unopened at 25°C

Remark

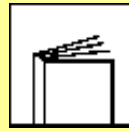
For repair of damaged parts coated it is necessary to thoroughly sand the parts prior to re-spray to avoid adhesion issues.

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



NAX 2800HP 2K VELOCITY PRIMER



Technical Information

Version 1, 02/2014

Product Handling & Safety



Warning

- Flammable liquid and vapor
- Harmful if swallowed
- Fatal 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.
- Keep away from heat/sparks/open flames/hot surfaces.
- Keep container tightly closed.
- Do not get in eyes, on skin, or on clothing.
- Avoid release to the environment.
- 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 IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing.

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