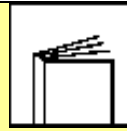




Automotive System

Nax CRYSTAL 9905

(Mirror Image Clear 2K 2: 1)



Technical Information

Version 1, 02/2013

PRODUCT DESCRIPTION

NAX CRYSTAL 9905 Mirror Image Clear 2K, an innovative high solids automotive finish with incorporation of CyGLAZ Technology to integrate superb toughness, high flexibility and excellent chemical resistance. The product is specially designed to exhibit excellent mar and scratch resistance to withstand day to day wear and tear e.g. car wash, acid rain, bird droppings etc., to ensure longer lasting beautiful look.



Paint system

- High Performance, High scratch resistant clear.
- Suitable for repairing of highly scratch resistant OEM finishes and for any refinish paint system.

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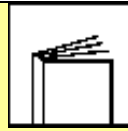
Nippon Automotive System,
Nippon Paints (Thailand) Co. Ltd.,
101 MOO 3 SOI SUKSAWAT 76, SUKSAWAT
ROAD, T. BANGCHAK, A. PRAPRADEANG,
SAMUTPRAKAN 10130, BANGKOK, THAILAND



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Application Guide



Mixing ratio 2 to 1
100 parts by volume – NAX CRYSTAL 9905 Mirror Image Clear
50 parts by volume – NAX CRYSTAL 905 2K Hardener
Thinner – Not required (5% Nax Premila Reducer 500 or 503 can be used for handling ease if necessary)

Pot Life 3 hours @ 25°C
2 hours @ 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	@ 20°C	@25°C	@ 30°C
NK #2	13 to 14	12 to 13	11 to 12
Ford Cup # 4	15 to 16	14 to 15	13" to 14



Spray gun Set-up Gravity Feed
full pattern, flow – 3 turns
from fully closed set-up,
Nozzle size & Spray pressure 1.3 – 1.4 mm,
1.5 – 2.0 bar (20-30 psi)

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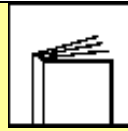
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Application

	Number of spray coats	<p>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 – 45 to 60µ ○ Clean the spray gun immediately after use
	Flash-off time	<ul style="list-style-type: none"> • Between coats - 0 to 2 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	Air dry conditions		
		Climate conditions*	@ 25°C	@ 30°C
		Dirt free time (minutes)	~ 8	~ 7
		Dry to handle (minutes)	~ 20	~ 15
		Dry to polish (minutes)	~ 30	~ 25
	Recoat time	Recoat with itself after complete drying cycle however, sanding is necessary after 24 hours to ensure good adhesion – P500 (dry) or P800 (wet).		

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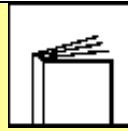
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Technical Information

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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	



Signal word: Warning

- Flammable liquid and vapor (Category 3)
- Harmful if swallowed & inhaled (vapor) (Category 4)
- Causes skin & serious eye irritation(Category 2&2A)
- May causes damage to lung and Central Nervous System(Category 2)
- May cause damage to Central Nervous System through prolonged or repeated exposure(Category 2)
- Harmful to aquatic life(Category 2)

Precautionary statements:

- 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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