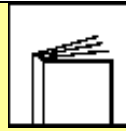




Automotive System

NaxPremila2K Balance Tint 3000



Technical
Information

Version 1, 04/2013

PRODUCT DESCRIPTION

NAX PREMILA 2K BALANCE TINT 3000 (Basecoat System) is a base coat for metallic, pearl or solid color, use in clear over base system and can be used for spot, block and overall repair and provide excellent film properties, beautiful color and durability.



Paint system

- Easy to spray application, no mottling
- Provide film appearance with good smoothness.
- Easy to color matching
- Easy to touch up repair and fast dry
- High build and excellent hiding power with saving paint consumption.



Substrate preparation

- Ensure that surface of 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)

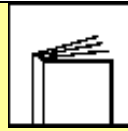
The Product is suitable strictly for professional use only. The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own 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.

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Application Guide



Mixing ratio **General Use**

NAX PREMILA 2K Balance Tint 3000 1.0 part
THINNER 0.8 – 1.0 part

Thinner

1. NAX PREMILA 500 Standard Thinner
2. NAX PREMILA 503 Slow Thinner

Precautions against orange peel and overspray problem from spray at high temperature (over 32°C), please use NaxPremila 503 slow thinner about 10-30% with NaxPremila 500 thinner for application

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	10 to 12
Ford Cup # 4	13 to 15



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

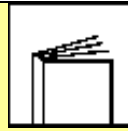
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Application

	Number of spray coats	2 – 3 single coats <ul style="list-style-type: none"> • Light to medium first coat • Light to medium second coat • Drop third coat <ul style="list-style-type: none"> ○ Pearl; dry film thickness – 20 to 30µm ○ Metallics; dry film thickness – 15 to 25µm
	Flash-off time	<ul style="list-style-type: none"> • Between coats 5 - 10 minutes @ 30°C / 60% R.H. <i>* The specified flash times may vary with temperature & air velocity in the spray booth.</i>



Drying times

Surface Dry	3 – 5 minutes
Dry to top clear	5 – 10 minutes
Dry to recoat	5 – 10 minutes

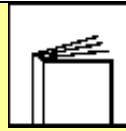
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Product Handling & Safety (for professional use only)

						<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(vapour)(Category 4)
- Causes eye irritation (Category 2B)
- May causes damage to lung and respiratory system(Category 2)
- May cause damage to lung and respiratory system through prolonged or repeated exposure(Category 2)
- Harmful to aquatic life(Category 3)

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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