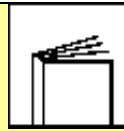




Automotive System

NaxPremila7000

2K SOLID SYSTEM



Technical
Information

Version 2, 09/2017

PRODUCT DESCRIPTION

NAX PREMILA 7000 (2K Solid System) is the 2K acrylic urethane single state for automotive refinishing.



Paint system

- High solid, Excellent hiding power
- Fast drying
- Excellent gloss.
- Excellent exposure durability and chemical resistance



Substrate preparation

- Ensure that surface on 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)

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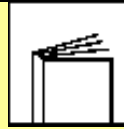
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Nippon Paints (Thailand) Co. Ltd.,
101 MOO 3 SOI SUKSAWAT 76, SUKSAWAT
ROAD, T. BANGCHAK, A. PRAPRADEANG,
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Application Guide



Mixing ratio

General Use (v/v)	Standard	Fast dry
NAX PREMILA 7000	4	4
NAX PREMILA 410 2K Hardener	1	-
NAX PREMILA 412 RP 2K Hardener	-	1
Thinner	1 - 2	1 - 2

For Flexible material, such as bumper (v/v)	Standard	Fast dry
NAX PREMILA 7000	4	4
NAX SOFTENER	0.5	0.5
NAX PREMILA 410 2K	1	-
NAX PREMILA 412 RP 2K Hardener	-	1
Thinner	1 - 2	1 - 2

Thinner

1. NAX PREMILA # 20 Medium Thinner
2. NAX PREMILA # 30 Slow Thinner

Precautions again orange peel and overspray problem from spray at high temperature (over 32°C), please using Nax Premila # 30 Slow Thinner about 10-30% with Nax Premila # 20 Medium Thinner for application

Pot Life

4 hours @ 30°C after mixed for Standard hardener
3 hours @ 30°C after mixed for Fast dry hardener

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	@30°C
NK # 2	12 to 14
Ford Cup # 4	15 to 17

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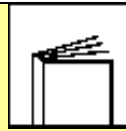
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Spray gun

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

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 and 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	<table border="1" data-bbox="628 969 1481 1111"> <tr> <td></td> <td>Standard</td> <td>Fast dry</td> </tr> <tr> <td>Between coat @ 30°C / 60% R.H.</td> <td>5-10 min</td> <td>5-10 min</td> </tr> </table> <ul style="list-style-type: none"> • 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>		Standard	Fast dry	Between coat @ 30°C / 60% R.H.	5-10 min	5-10 min
	Standard	Fast dry						
Between coat @ 30°C / 60% R.H.	5-10 min	5-10 min						
	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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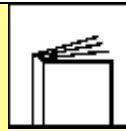
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Drying times

Air Dry (30°C)	Standard hardener	Fast dry hardener
Surface dry	8 – 10 minute	6-8 minute
Dry to assembly	3 hours	3 hours
Dry to taping	>6 hours	>5 hours
Dry to polishing	>8 hours	>6 hours

Baking(60°C/30 min)	Standard hardener	Fast dry hardener
Surface dry	Set before bake 5–10 min	Set before bake 5–10 min
Dry to assembly	2 hours	1/2 hours
Dry to taping	>4 hours	>2 hours
Dry to polishing	>6 hours	>3 hours

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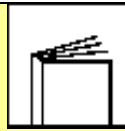
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Product Handling & Safety (for professional use only)

<p>THINK Safety first Wear personal protective equipment</p>						<p>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</p>
	Respiratory Mask	Safety Goggles	Protective Clothing	Protective Gloves	Safety Shoes	



Signal word: Danger

- Flammable liquid and vapour
- Harmful if inhaled (vapour)
- Causes skin irritation
- Causes damage to organs through prolonged or repeated exposure
- Harmful to aquatic life

Precautionary statements:

- Keep away from heat/sparks/open flames/hot surfaces. – No smoking.
- Avoid breathing dust/fume/gas/mist/vapours/spray
- Use explosion-proof electrical, ventilating, lighting and equipment.
- Wear protective gloves.
- IF ON SKIN: Wash with plenty of soap and water.
- If you feel unwell immediately call a POISON CENTRE or doctor/physician.
- Avoid release to the environment.
- Dispose of content/container to appropriate waste site or reclaimer in accordance with local/regional/nation or national regulations.

For further information please contact:

TECHNICAL SERVICES DEPARTMENT, NIPPON PAINT AUTOMOTIVE REFINISH BUSINESS UNIT

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