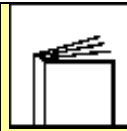




Automotive System

Nax Premila 9800 HP Velocity Clear 2K 2:1



Technical
Information

Version 2, 11/2017

PRODUCT DESCRIPTION

NAX Premila 9800 HP Velocity Clear 2K 2:1 is an ultra-fast curing type clear coat for improved productivity and cost reduction. The salient feature of this clear coat is its ultra-high productivity cycle with a dry to polish time of less than 30 minutes under ambient cure conditions (25-30 °C). Avoiding the need of a high temperature baking cycle, therefore meeting the requirements of “quick repair” and “energy saving” concepts. If require, an extremely short time bake of 5 minutes @50 °C is more than sufficient to achieve ultra-fast curing properties. As a premium clear coat, it offers outstanding application properties, it is easy to polish, and has excellent gloss and appearance.



Paint system

- Extra fast time. Quick repair to help the task finished in one day.
- Save energy. Preserve environment.
- Best quality over the normal clear in both color and paint film.

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).

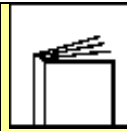
The Product is suitable strictly for professional use only. The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own 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 2 : 1 By volume

NAX Premila 9800 HP Velocity Clear 2K 2:1 100 part

NAX Premila 980 HP 2K Hardener 50 part

Thinner – Not required (5% Nax Premila # 20 Medium Thinner or Nax Premila # 40 Super Slow Thinner) can be used for handling ease if necessary)

Pot Life 2 hours @ 20°C
1.5 hours @ 25°C
1 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)

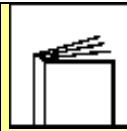
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Application

	Number of spray coats	2 single 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 – 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*

Dirt free time (minutes)

@ 25°C

@ 30°C

~ 8

~ 7

Dry to handle (minutes)

~ 20

~ 15

Dry to polish (minutes)

~ 30

~ 25

Recoatable time

Recoatable with itself after complete drying cycle however, sanding is necessary after 24 hours to ensure good adhesion – P500 (dry) or P800 (wet).

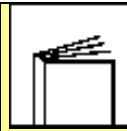
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Product Handling & Safety (for professional use only)

						<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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