

Description

Two-pack fast drying light grey sanding primer filler with excellent application and sanding properties. Due to its fast ambient drying, it helps to reduce process time and provides exceptional enamel hold-out with all Nippon Paint AR topcoats.

Suitable Substrates

Existing finishes	Glass reinforced laminates	nax polyester bodyfillers & putties
Steel	nax plastic primers	nax etching primers
OEM Electro-coat	nax epoxy primers	

	4 nax 2400 Urethane Primer Grey
	1 nax 240 Urethane Primer Hardener
	1-2 nax Premila 500 Thinners

	Spray-gun setup:	Application Pressure:
	Gravity fed 1.4 - 1.8 mm	1.7 - 2.2 bar 28-30 psi At spray-gun air inlet HVLP max 0.6-0.7 bar (8-10 psi) at the air cap

	2 - 3 coats		40-50 µm /coat (4:1:1)
			30-40 µm /coat (4:1:2)

	Between coats:	Before 60°C (140°F) baking:
	5 - 7 minutes at 20°C 70°F	10 minutes at 20°C 70°F

	Dry to sand	20°C (70°F)	30°C (86°F)	40°C (100°F)	60°C(140°F)	Infra-Red 4+8 minutes
		2 hours	1½ hours	1½ hours	30 minutes	

	Final dry sanding:		Final wet sanding:
	P400 - P500		P800 - P1000

Re – coating
With all nax Premilla primers, primer fillers and surfacers
With nax E³ WB basecoat, and Premila topcoat system

	nax 2400 Urethane Primer Grey	2 years
	nax 240 Urethane Primer Hardener	2 years
	nax Premila 500 Thinners	2 years

	▶ The VOC content of this product in ready to use form is maximum	606 g/liter
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Use suitable respiratory protection
Nippon Paint Automotive Refinishes recommends the use of fresh air supply respirator.

For detailed information read entire TDS

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Suitable Substrates

Existing finishes	Glass reinforced laminates	nax epoxy primers
Steel	nax plastic primers	nax etching primers
OEM Electro-coat (ED)	nax polyester bodyfillers & putties	

Notes: *In the following cases the use etch primer is advised:*
a. *When the system is required to meet the highest quality standard*
b. *Repairs that requires an extensive primer surface application, such as complete panel*

Product and Additives

Product	nax 2400 Urethane Primer Grey	Temperature range
Hardeners	nax 240 Urethane Primer Hardener	
Thinners	nax Premila 500 Thinner (Standard)	20-35°C
	nax Premila 501 Thinner (High Temperature)	35-45°C
	nax Premila 502 Thinner (Fast)	5-20°C
	nax Premila 503 Thinner (Slow)	35-50°C
Additives	nax Softener	

Basic Raw Materials

Product	Raw Material
nax 2400 Urethane Primer Grey	Acrylic resins
nax 240 Urethane Primer Hardener	Poly-isocyanate resin
nax Premila 500 Thinners	Blend of solvents

Surface preparation



- ▶ Prior to any surface preparation, degrease the repair area using nax solventborne degreaser.
- ▶ Use clean quality rags or wiping towels, one for wetting and one for drying the surface.
- ▶ Apply sufficient degreaser to keep the surface wet and wipe degreaser off before it can evaporate



- ▶ Removal of existing finish and initial sanding of polyester bodyfiller/putty P120
- ▶ Feather edge before polyester/putty and finish, sanding for complete panel priming P220
- ▶ Feather edge and final step before spraying primer/surfacer for spot repairs P320
- ▶ Sound OEM electro (ED) coated parts: P320



- ▶ Prior to primer surfacer application degrease the application area using nax solventborne degreaser.
- ▶ Use clean quality rags or wiping towels, one for wetting and one for drying the surface.
- ▶ Apply sufficient degreaser to keep the surface wet and wipe degreaser off before it can evaporate

Notes: *Respect 100 grit maximum jump in dry sanding steps.*

Mixing



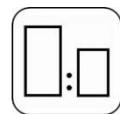
Mixing Machine

For best performance, stir primer on mixing machine twice a day for 15 minutes



Product Mix

Stir well, after each added component.



HB	MB	
4	4	nax 2400 Urethane Primer Grey
1	1	nax 240 Urethane Primer Hardener
1	2	nax Premila 500 Thinners

	Thinner selection		
	Fast	Medium	Slow
	5-20°C	20-35°C	35-45°C
1-2 panels/spot	Fast	Medium	Slow
3-5 panels	Medium	medium	Slow
>5 panels	Slow	Slow	Slow

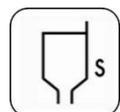
Notes: *Stir after each added component*

Flexible Parts

Type of Plastic	Primer Surfacer	Softener	Mixture	Hardener	Thinner
Flexible/Soft	100	5%	4	1	1-2
Soft	100	10%	4	1	1-2

Notes: Hard plastic requires no softener.
Stir well after adding the additive

Viscosity (DIN 4 Cup)

		20°C(70°F)	30°C(86°F)	40°C(100°F)
		▶ High Build	19-23 sec	19-23 sec
▶ Medium Build		14-18 sec	14-18 sec	14-18 sec

Pot Life

		20°C(70°F)	30°C(86°F)	40°C(100°F)
		▶ High build	2 hours	30 min.
▶ Medium build		3 hours	1.5 hours	45 min.

Spray gun set-up / application pressure

		Spray-gun type	Nozzle size	Application pressure
		▶ High build	Gravity	1.6-1.8 mm
▶ Med. build		Gravity	1.4-1.6 mm	1.7-2.2 bar at the spray gun air inlet

Application

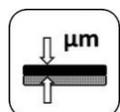
			Number of coats
			▶ High build
▶ Medium build			2-3 coats
▶ Apply one medium coat over the sanded repair area, then allow to flash for 5-7 minutes			
▶ Apply the 2 nd and 3 rd wet coat within each previous coats allowing 5-7 min. between coats.			

Notes: Allow each coat to flash-off naturally until the surface is completely matt. Do not force-dry by air support. Proper flash off helps achieving higher film build. Flash-off time depends on ambient temperature, applied layer thickness and airflow. For maximum build use large fluid tip and lower the application pressure.

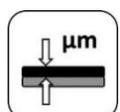
Drying time

		20°C(70°F)	30°C(86°F)	>40°C(100°F)	60°C(140°F)	IR DRYING
		▶ Dust dry	10 min.	5 min.	5 min.	-
▶ Dry to sand	2 hours	1½ hours	1½ hour	30 min.	n/a	
▶ Flexible use	3 hours	2 hours	2 hours	40 min.	4+8 min.	

Film thickness

			Film thickness
			▶ High build
▶ Medium build	Using the recommended application technique	30-40 µm/coat	

Coverage

	By using the recommended application, the theoretical material coverage is:		
	07 - 10	m ² /liter RTS mixture at	30-60 µm
80-100	ft ² /liter RTS mixture at	30-60 µm	

Notes: The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.

Finishing surface preparation



- | | |
|---|-----------|
| ▶ Finishing dry sanding steps: 2K Topcoat / Basecoat | P400/P500 |
| ▶ Initial dry sanding step may be executed with a coarser grit: | P320 |
| ▶ For spot repair, finish the blending area with: | P500 |
| ▶ | |



- | | |
|---|------------|
| ▶ Finishing wet sanding steps: 2K Topcoat / Basecoat | P800/P1000 |
| ▶ Initial dry sanding step may be executed with a coarser grit: | P320 |
| ▶ Initial wet sanding step may be executed with a coarser grit: 2K Topcoat / Basecoat | P600/P800 |
| ▶ For spot repair, finish the blending area with: | P1000 |



- ▶ Prior to SB topcoat application degrease the surface using nax solventborne degreaser.
- ▶ Prior to WB basecoat application degrease the surface using nax E³ WB Degreaser.
- ▶ Use clean quality rags or wiping towels, one for wetting and one for drying.
- ▶ Apply sufficient degreaser to keep the surface wet and wipe degreaser off before it can evaporate

Notes: Respect 100 grit maximum jump in dry sanding steps and 200 grit maximum jump in wet sanding steps.

Re-coating



With all nax Premilla primers, primer fillers and surfacers
With nax E³ WB basecoat, and Premila topcoat system

Notes:

Equipment cleaning

Solvent borne guncleaners

Solvent Content



- ▶ The VOC content of this product in ready to use form is max 606 g/liter

Shelflife



nax 2400 Urethane Primer Grey	2 years
nax 240 Urethane Primer Hardener	2 years
nax Premila 500 Thinners	2 years
Minimum storage temperature:	5°C (41°F) Maximum storage temperature: 35°C (95°F)

Notes: Product shelf-life is determined when products are stored unopened at 20°C (70°F). Avoid extreme temperature fluctuation.

--- Local organization address with phone number ---

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