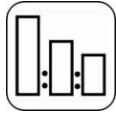


Description

Two-pack chromate free, fast drying anti-corrosive primer for pre-treatment for light metals and alloys. Can be used over abrasive blasted steel to provide optimal corrosion protection and adhesion to the subsequently applied coatings.

Suitable Substrates

Existing finishes Steel / galvanized steel / aluminum	OEM Electro-coat Glass reinforced laminates	nax polyester bodyfillers & putties nax epoxy primers
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4 nax 1200 Etching Primer
1 nax 120 Etching Primer Hardener
1 nax 510 Etching Thinner



Spray-gun setup:

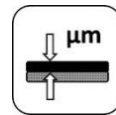
Gravity fed | 1.4 - 1.6 mm

Application Pressure:

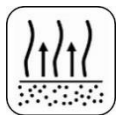
1.7 - 2.2 bar | 28-30 psi | At spray-gun air inlet
HVLP max 0.6-0.7 bar (8-10 psi) at the air cap



1 - 2 coats



10 - 15 μm / coat



Between coats:

5 - 10 minutes at

20°C

70°F



Dry to re-coat

20°C(70°F)
15-20 min.

30°C(86°F)
10-15 min.

40°C(100°F)
10-15 min.

50°C(122°F)
5-10 min.



Re – coating

With all nax Premilla and Superio primer fillers and surfacers
With all nax Premilla and Superio 2K topcoat system



nax 1200 Etching Primer	2 years
nax 120 Etching Primer Hardener	2 years
nax 510 Etching Thinner	2 years



► The VOC content of this product in ready to use form is maximum

741 g/liter



Use suitable respiratory protection

Nippon Paint Automotive Refinishes recommends the use of fresh air supply respirator.

For detailed information read entire TDS

Description

Two-pack chromate free, fast drying anti-corrosive primer for pre-treatment for light metals and alloys. Can be used over abrasive blasted steel to provide optimal corrosion protection and adhesion to the subsequently applied coatings.

Suitable Substrates

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

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 for primer/surfacer for spot repairs, (ED) coated parts P320
- ▶ Abrasive blasted steel SA 2.5 - 3.0



- ▶ Prior to primer 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



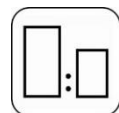
Mixing Machine

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



Product Mix

Stir well, after each added component.

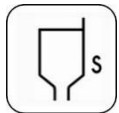


Volume	Weight
4	nax 1200 Etching Primer
1	nax 120 Etching Primer Hardener
1	nax 510 Etching Thinner

Thinner selection		
Fast	Medium	Slow
5-20°C	20-35°C	35-45°C

Notes: Stir after each added component

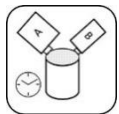
Viscosity (DIN 4 Cup)



	20°C(70°F)
Spraying	14-16 Sec.

Notes:

Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ Spraying	18 Hrs.	18 Hrs.	18 Hrs.
▶ Brushing	18 Hrs.	18 Hrs.	18 Hrs.

Notes: Passed potlife primer loses its etching property.

Spray gun set-up / application pressure



Spray-gun type	Nozzle size	Application pressure
Gravity (HVLP, LVLP)	1.4-1.6 mm	Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)

Application



		Number of coats
▶ Spraying	Depending on desired film build	1-2 coats
▶ Brushing		2-3 coats

- ▶ Apply one medium coat over the sanded repair area, then allow to flash for 5-10 minutes
- ▶ Apply a 2nd wet coat within the previous coat.

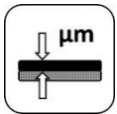
Notes: Allow each coat to flash-off naturally, do not force-dry by air support
Flash-off time depends on ambient temperature, applied layer thickness and airflow.
Recommended application criteria: 15-38 °C and 20-85% relative humidity

Re-coating time



	20°C(70°F)	30°C(86°F)	40°C(100°F)	50°C(122°F)
▶ Spraying	15-20 min.	10-15 min.	10-15 min.	5-10 min.
▶ Brushing	2-3 hours	1.5-2 hours	1-1.5 hours	1-1.5 hours

Film thickness



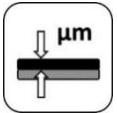
▶ Spraying	Using the recommended application technique	±10 µm/coat
▶ Brushing	Using the recommended application technique	±15 µm/coat

Re-coating



With all nax Premilla and Superio primer fillers and surfacers
With all nax Premila and Superio 2K topcoat system

Coverage



By using the recommended application, the theoretical material coverage is:

- ▶ ± 05 m²/liter RTS mixture at Spraying
- ▶ ± 07 m²/liter RTS mixture at Brushing

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.

Equipment cleaning

Solvent borne guncleaners

Solvent Content



- ▶ The VOC content of this product in ready to use form is max 741 g/liter

Shelflife



nax 1200 Etching Primer	2 years
nax 120 Etching Primer Hardener	2 years
nax 510 Etching Thinner	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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