

## Description

Innovative high solid automotive finish with incorporation of CyGlaz Technology to integrate superb toughness, high flexibility and excellent chemical resistance. The product is specially designed to exhibit excellent mar and scratch resistance to withstand day to day wear and tear e.g. car wash, acid rain, bird droppings etc., to ensure longer lasting beautiful look.

## Suitable Substrates

nax Premila 8000 series base coat  
nax E<sup>3</sup> WB basecoat system

	2	nax Crystal 9905 Mirror Image Clear
	1	nax Premila 905 2K Hardener

	<b>Spray-gun setup:</b>	<b>Application Pressure:</b>
	Gravity fed   1.3-1.4 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

	1 ½ - 2 coats		20 - 30 μm /coat
--	---------------	--	------------------

	<b>Between coats:</b>	<b>Before 60°C (140°F) baking:</b>
	10 - 15 minutes at   20°C   70°F	15 minutes at   20°C   70°F

		<b>20°C (70°F)</b>	<b>30°C (86°F)</b>	<b>40°C (100°F)</b>	<b>60°C (140°F)</b>	<b>Infra-Red</b>
	Dust dry	90 min.	45 min.	30 min.	n/a	4+8 minutes
	Dry to handle	10 hrs.	4-5 hrs.	3 hrs.	45 min.	
Dry to polish	10 hrs.	5 hrs.	4 hrs.	2 hrs. after cooldown		

	nax Crystal 9905 Mirror Image Clear	4 years
	nax Premila 905 2K Hardener	2 years

	VOC	► The VOC content of this product in ready to use form is maximum	747 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**

Innovative high solids automotive finish with incorporation of CyGLAZ Technology to integrate superb toughness, high flexibility and excellent chemical resistance. The product is specially designed to exhibit excellent mar and scratch resistance to withstand day to day wear and tear e.g. car wash, acid rain, bird droppings etc., to ensure longer lasting beautiful look.

**Suitable Substrates**

nax Premila 8000 series base coat  
nax E<sup>3</sup> WB basecoat system

**Notes:** Follow recommended flash off and re-coating time of the basecoat.

**Product and Additives**

<b>Product</b>	nax Crystal 9905 Mirror Image Clear 2K	
<b>Hardener</b>	nax Crystal 905 2K Hardener	
<b>Reducers</b>	nax Premila 500 Thinner (Standard)	20-35°C
	nax Premila 503 Thinner (Slow)	35-45°C

**Basic Raw Materials**

nax Crystal 9905 Mirror Image Clear 2K	Acrylic Polyol
nax Crystal 905 2K Hardener	Poly-isocyanate resin
nax Premila 500/503 Thinner	Blend of solvents

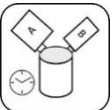
**Mixing**


2	nax Crystal 9905 Mirror Image Clear 2K
1	nax Crystal 905 2K Hardener
5%*	nax 500 / 503 Thinners (optional)

**Notes:** Stir after each added component  
\*To improve handling 5% of nax Premila Thinner 500 or 503 can be added.

**Viscosity (DIN 4 Cup)**


		<b>20°C(70°F)</b>	<b>30°C(86°F)</b>
▶ Standard		14-17 sec	16-17 sec

**Pot Life**


		<b>20°C(70°F)</b>	<b>30°C(86°F)</b>	<b>40°C(100°F)</b>
▶ Standard		3 hrs	2 hrs	1½ hrs

**Spray gun set-up / application pressure**


Spray-gun type	Spray-gun type	Nozzle size	Application pressure
▶ LVLP	Gravity	1.3-1.4 mm	1.7-2.2 bar at the spray gun air inlet
▶ HVLP	Gravity	1.3-1.4 mm	(HVLP: max 0.6-0.7 bar at the air cap)

**Application**

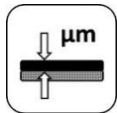


**Standard Application**

- ▶ Apply one medium coat, then allow to flash for 10-15 minutes.
- ▶ Apply the 2<sup>nd</sup> wet coat.

**Notes:** Flash-off time depends on ambient temperature, applied layer thickness and airflow.

**Film thickness**



- ▶ All Using the recommended application technique 40-60 µm

**Drying time**



	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	Infra-Red
Dust dry	90 min.	45 min.	30 min.	-	
Dry to handle	10 hrs.	4-5 hrs.	3 hrs.	45 min.	4+8 min.
Dry to polish	10 hrs.	5 hrs.	4 hrs.	2hrs. after cooldown	

**Notes:** Indicated drying times are panel temperatures. Oven temperature should be set 10 °C higher. Allow 10 minutes flash off prior to Infra-Red drying. The panel must not reach a temperature above 100°C (210°F) while curing. Following the drying cycle at 60°C (140°F) object temperature, allow product to completely cool down to ambient temperature. Using fast hardener at high temperatures can decrease the gloss.

**Polishing**

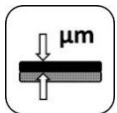


Dust and minor imperfections can be polished out after the indicated air-dry times, or after 2 hours cool down time following the full bake at 60°C object temperature. Carefully sand out dust particles and restore the surface according polishing recommendations.

- ▶ Carefully de-nib using P1500 or finer with soap and water; blow air & dry the sanded area
- ▶ Machine sanding with P3000 is recommended to avoid sanding marks & minimize orange peel effect (use of soft interface pad is recommended at speed ~ 1500 rpm)
- ▶ Compound using Fast cut compounding paste with a wool compounding pad and an air or electric buffer at 1400 to 2000 rpm.
- ▶ Polish using standard fine polishing paste with a foam polishing pad and an air or electric buffer at 1400 to 2000 rpm (reduce pressure as polish begins to dry and buff to a high gloss).
- ▶ Remove any remaining residue using Detailing Cloth.

**Notes:** \*Recommended 3M™ Finesse-it™ SRC for better results (especially if the polishing process is being carried out after 48 hours). Polishing preferably needs to be carried out within 48 hours as longer waiting time will results in increased hardness of the paint film thereby making polishing harder as well. Polishing can be done mechanically (preferable) or manually. nax Crystal 9905 Mirror Image Clear is a hard & scratch resistant clear coat and so to get excellent results especially for gloss restoration, polishing needs to be done as per the recommended procedure especially if it done after longer curing time after application of the clear coat.

**Coverage**



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

- ▶ ± 6 m<sup>2</sup>/liter RTS mixture at 40-60 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.

**Equipment cleaning**

Solvent borne guncleaners

**Solvent Content**



▶ The VOC content of this product in ready to use form is maximum 747 g/liter

**Shelflife**



nax Crystal 9905 Mirror Image Clear 4 years

nax Premila 905 2K Hardener 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 ---

**Brand names and Logos mentioned in this data sheet are trademarks of or are licensed to NIPPON PAINT.**

This product is for professional use only and not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. 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, or as a warranty, nor the suitability of the products for a specific purpose. Standard drying times quoted are average times at 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only. In the light of experience and our policy of continuous product development, they may change without prior information and do not constitute the agreed contractual quality of the products (product specification).

It is always the responsibility of the recipient of our products to ensure that any proprietary rights, existing laws, legislation are observed and to take all necessary steps to fulfill the demands set out in the local rules and legislation. The latest version of TDS supersedes all previous versions.

**Nippon Paint Group AR Office:**

148, Sector – 7, IMT Manesar, Gurgaon Haryana – 122050, India

[www.nipponpaint-autorefinishes.com](http://www.nipponpaint-autorefinishes.com)