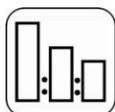


Description

Two component high solid, acrylic enamel direct gloss topcoat as part of the Premila Master Tint system. Designed to duplicate OEM finishes in solid colours. Provides easy application, fast drying, easy spot repair, excellent hiding power, and high gloss.

Suitable Substrates

Existing finishes with the exception of thermoplastic acrylic finishes
All nax Pro LV and Premila primers, primer fillers/surfacers.



4 nax Premila 7000
1 nax Premila 410 2K Hardener
1 nax Premila 500 Thinners



Spray-gun setup:

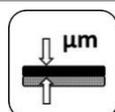
Gravity fed | 1.3-1.4 mm

Application Pressure:

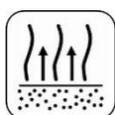
1.7-2.2 bar | 28-30 psi | At spray-gun air inlet
HVLP max 0.6-0.7 bar (8-10 psi) at the air cap



2-3 coats



20-30 μm /coat



Between coats:

5 - 10 minutes at | 20°C | 70°F

Before 60°C (140°F) baking:

5 - 10 Minutes at | 20°C | 70°F



	20°C (70°F)	30°C (70°F)	40°C (70°F)	60°C (140°F)	Infra-Red
Dust dry	12 min.	10 min.	8 min.	-	n/a
Dry to handle	8 hrs.	3 hrs.	3 hrs.	30 minutes	5+10 minutes
Dry to polish	>10 hrs.	>8 hrs.	>6 hrs.	1 hour after cooldown	5+10 minutes



nax Premila 7000	4 years
nax Premila 410 2K Hardener	2 years
nax Premila 500 Thinners	2 years



► The VOC content of this product in ready to use form is maximum 590 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 component high solid, acrylic enamel direct gloss topcoat as part of the Premila Master Tint system. Designed to duplicate OEM finishes in solid colours. Provides easy application n, fast drying, easy spot repair, excellent hiding power, and high gloss

Suitable Substrates

Existing finishes with the exception of thermoplastic acrylic finishes
 All nax Pro LV and Premila primers, primer fillers/surfacers

Notes: Follow recommended flash off and re-coating time of the wet-on-wet primer.

Product and Additives

Product	nax Premila 7000 Toners	
Hardener	nax Premila 410 2K Hardener	
	nax Premila RP 410 2K Hardener	
Reducers	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 Premila 7000 Toners	Acrylic polyol resin
nax Premila 410 2K Hardener	Poly-isocyanate resin
nax Premila 500 Thinners	Blend of solvents

Final surface preparation



▶ Finishing dry sanding steps:	P400
▶ 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:	P800
▶ Initial dry sanding step may be executed with a coarser grit:	P320
▶ Initial wet sanding step may be executed with a coarser grit:	P600
▶ For spot repair, finish the blending area with:	P1000



▶ Prior to SB topcoat application degrease the surface using nax solventborne egreaser.
▶ 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. For detailed surface preparation see TDS

Mixing

Mixing Machine

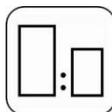


Stir toners on mixing machine twice a day for 15 minutes and just before formula mixing.

Color Mix



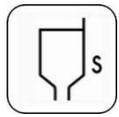
Must be stirred thoroughly directly after mixing the formula.

	Standard	Flexible	
	4	4	nax Premila 7000 color mix (formula)
	1	1	nax Premila 410 2K Hardener
	1	-	nax 500 / 501 / 502 / 503 Thinners
	-	0.5	nax Softener

	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

Viscosity (DIN 4 Cup)



	20°C(70°F)	30°C(86°F)
▶ Standard	15-22 sec	15-17 sec
▶ Flexible application	20-22 sec	15-17 sec

Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
	5 hours	4 hours	2 hours

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

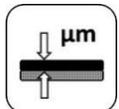


Apply one medium coat, then allow to flash for 5-7 minutes.

Apply the 2nd and if required a 3rd wet coats allowing 5-10 minutes between coats.

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

Film thickness



Using the recommended application technique 40 - 60 µm

Drying time



Dust dry	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	Infra-Red
▶ Standard	10 min.	10 min.	7 min.	n/a	n/a
Dry to handle and polish					
▶ Standard	8 hrs.	1 hr.	1 hr.	30 min.	4+8 min.

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.

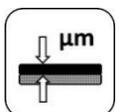
Polishing



Dust and minor imperfections can be polished out after 8 hours air-dry times, or after a one hour cool down time following the full bake at 60°C object temperature. Carefully sand out dust particles and restore the surface according polishing recommendations.

Notes:

Coverage



By using the recommended application, the theoretical material coverage is:
▶ ±10 m²/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 590 g/liter

Shelflife

	nax Premila Solid Toners	4 years
	nax Premila NB Binder	4 years
	nax Premila 410 2K Hardeners	2 years
	nax Premila 500 Thinners	2 years
	Minimum storage temperature:	5°C (41°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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