

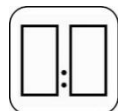
Description

Single component acrylic master tint basecoat system designed to duplicate OEM finishes in solid, and effect colours. Provides easy application, fast drying, easy spot repair. nax Premila 8000 must be re-coated with nax Premium category clearcoats to secure complete system performance.

Suitable Substrates

Existing finishes with the exception of thermoplastic acrylic finishes

All nax Premila and nax Pro LV preparatory products, with the exception of acid containing etch primer.



100 nax Premila 8000 basecoat system
100 nax Premila 500 Thinners



Spray-gun setup:

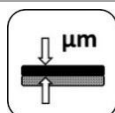
Gravity fed | 1.3-1.4 mm

Application Pressure:

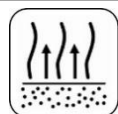
1.7-2.2 bar | 28-30 psi | At spray-gun air inlet
HVLP max 0.6-0.7 bar (8-10 psi) at the air cap



2 – 3 coats

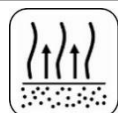


20-30 μm Solid colours
15-30 μm Effect colours



Between coats:

5 - 10 minutes at | 20°C | 70°F | | | |



Before re-coat:

10-15 minutes at | 20°C | 70°F |

Re-coat within:

24 hours at | 20°C | 70°F |



Re – coating

With all nax Pro LV and nax Premila clearcoats

With nax Multi Eco 3:1 GL Clear, and nax Crystal Mirror Image Clear 2K



nax Premila 8000 basecoat

2-4 years

nax Premila 500 Thinners

2 years



VOC

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

748 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

Single component acrylic basecoat system designed to duplicate OEM finishes in solid, and effect colours. Provides easy application, fast drying, easy spot repair. nax Premila 8000 must be re-coated with nax Premila clearcoats to secure complete system performance.

Suitable Substrates

Existing finishes with the exception of thermoplastic acrylic finishes
All nax Premila and nax Pro LV preparatory products, with the exception of acid containing etch primer.

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

Product and Additives

Product	nax Premila Master Tint Toners	
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

Basic Raw Materials

Product	Raw Material
nax Premila Master Tint Toners	Acrylic resins
nax Premila 500 Thinners	Blend of solvents

Final surface preparation



- ▶ Finishing dry sanding step: P500
- ▶ Initial dry sanding step may be executed with a coarser grit: P320/P400
- ▶ For spot repair, finish the basecoat blending area with: P500



- ▶ Finishing wet sanding steps: P1000
- ▶ Initial dry sanding step may be executed with: P320/P400
- ▶ Initial wet sanding step may be executed with: P800
- ▶ For spot repair, finish the basecoat 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. Use guide coat to control sanding.

Mixing



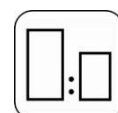
Mixing Machine

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.

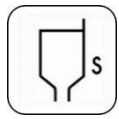


Standard	Low hide	
100	100	nax Premila 8000 color mix (formula)
100	80	nax 500 / 501 / 502 / 503 Thinners

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

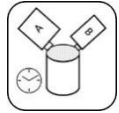
Notes: To improve: elasticity, recoat properties, stone chip resistance, adhesion properties and total system robustness it is possible to add nax Premila 410 2K Hardener to basecoat. The Hardener is added in the ratio of 5% by volume of the base (color) mix prior to adding nax Premila 500 thinners. After adding hardener mix thoroughly and mix with thinners as mentioned above.

Viscosity (DIN 4 Cup)



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ Standard	14-16 sec	13-15 sec	13-15 sec

Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ Standard	1 day	1 day	1 day
▶ With 5% hardener	6 hours.	6 hours.	4 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



2 coat colors	Number of coats	3 coat pearl color	Number of coats
▶ Solid	2-3 single coats	▶ Foundation (Solid)	2
▶ Metallic	2 + drop-coat	▶ Foundation (Effect)	2-3
▶ Pearl	2-3 + drop-coat	▶ Mica	2-4

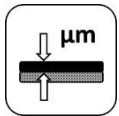
Solid colors 1. Apply 2-3 single coats till opacity achieved, with 5-10 minutes flash off time between coats

Metallic/ Pearl colors 1. Apply a wet coat followed by a medium coat, with 5-10 minutes flash off time between coats
2. Apply a drop-coat for optimal metallic orientation coat by reducing the pressure to 1.5 bar (20-25psi) at the gun inlet and apply the drop coat with full trigger, increase the distance to 30 cm (12 inches).

Spot Repair When making spot repairs, use lower application pressure and apply thin coats until reaching opacity. Allow for a 3-5 minutes flash-off time at 20°C between coats. Next, fade out, by extending beyond the edges, using similar application pressure. In case of metallic colors apply a drop coat (metallic orientation coat) when needed by increasing the spray gun distance.

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

Film thickness



Colors		
▶ Solid	Using the recommended application technique	20-25 µm
▶ Effect	Using the recommended application technique	15-25 µm

❖ **The total dry layer thickness should never exceed 30µm.**

Denibbing



Following a 20 minutes flash off at 20°C (70°F) the basecoat can be de-nibbed for minor defects (e.g. dust) with light pressure using P500 dry sanding or P1000 wet sanding. Prior to the subsequent basecoat application secure a sanding residue free surface.

Taping

Following a 20 minutes flash off at 20°C (70°F) the basecoat can be taped for multi-color application. Temperature increase in combination with air acceleration helps the ability for masking, then allow the object to cool down to ambient temperature before masking.

Re-coating time



nax Premila 8000 Basecoat System can be re-coated with clearcoat after 10-15 minutes flash off time and within 24 hours.

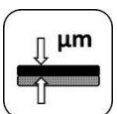
Re-coating



- ▶ All nax Pro LV Clearcoats
- ▶ All nax Premila Clearcoats
- ▶ nax Multi Eco (3+1) GL Clear
- ▶ nax Crystal 9905 Mirror Image Clear

Notes:

Coverage



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

- ▶ ± 09 m²/liter RTS mixture for Solid colours
- ▶ ± 10 m²/liter RTS mixture for Effect colours (metallic/pearl)
- ▶ ± 10 m²/liter RTS mixture for 3 coat pearl colours

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 750 g/liter

Shelflife



nax Premila 8000 basecoat

- | | |
|-----------------------------------|---------|
| a) Pearl/Solid toners and binders | 4 years |
| b) Metallic toners | 2 years |

nax Premila 500 Thinners

Minimum storage temperature:	5°C (41°F)	Maximum storage temperature:	35°C (95°F)
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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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