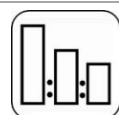


Description

High quality medium solid two component acrylic urethane clear. Provides excellent gloss and protection over different types of basecoats. Ideal clearcoat from spot repair to complete respray.

Suitable Substrates

nax Premila 8000 series base coat



4 nax Premila 9400
 1 nax Premila 410 2K Hardener
 0-10% nax Premila 500 Thinners

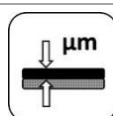


Spray-gun setup:
 Gravity fed | 1.3-1.4 mm

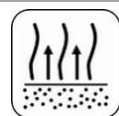
Application Pressure:
 1.7-2.2 bar | 28-30 psi | At spray-gun air inlet
 HVLP max 0.6-0.7 bar (8-10 psi) at the air cap



2-3 coats



20-30 μm /coat



Between coats:
 4 - 6 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 (86°F)	40°C (100°F)	60°C (140°F)	Infra-Red
Dust dry	5-10 min.	5-10 min.	5 min.	-	4+8 minutes
Dry to handle	6 hours	4 hrs.	3 hrs.	30 minutes	
Dry to polish	7 hours	5 hrs.	4 hrs.	1 hr. after cooldown	



nax Premila 9400	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 **572 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

High quality medium solid two component acrylic urethane clear. Provides excellent gloss and protection over different types of basecoats. Ideal clearcoat from spot repair to complete respray.

Suitable Substrates

nax Premila 8000 series base coat

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

Products

Product	nax Premila 9400 Top Coat Clear	
Hardener	nax Premila 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	

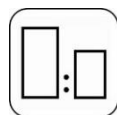
Basic Raw Materials

Product	Raw Material
nax Premila 9400 Top Coat Clear	Acrylic polyil
nax Premila 410 2K Hardeners	Poly-isocyanate resin
nax Premila 500 Thinners	Blend of solvents

Flexible Parts

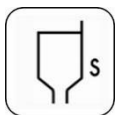
Type of Plastic	Clearcoat	nax Softener
Flexible/Soft	100	5%
Soft	100	10%

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

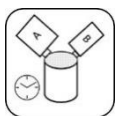
Mixing


Standard		Thinner Selection		
		5-20°C	20-35°C	35-45°C
4	nax Premila 9400 Top Coat Clear			
1	nax Premila 410 2K Hardener	1-2 panels/spot	Fast	Medium
0-10%	nax 500 / 501 / 502 / 503 Thinners (optional)	3-5 panels	Medium	medium
		>5 panels	Slow	Slow

Notes: Stir after each added component

Viscosity (DIN 4 Cup)


	20°C(70°F)		30°C(86°F)	
▶ Standard	15-18	sec	14-16	sec
▶ Flexible	15-18	sec	14-16	sec

Pot Life


	20°C(70°F)		30°C(86°F)		40°C(100°F)	
▶ 0% thinner	2	Hrs.	1 ½	Hrs.	1 ½	Hrs.
▶ 10% thinner	3	Hrs.	2 ½	Hrs.	2	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: max 0.6-0.7 bar at the air cap)
▶ HVLP	Gravity	1.3-1.4 mm	

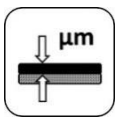
Application



- Standard Application**
- ▶ Apply one medium coat, then allow to flash for 4-6 minutes.
 - ▶ Apply the 2nd and if required a 3rd wet coats allowing 4-6 minutes between coats.

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

Film thickness



▶ Standard	Using the recommended application technique	40-60 μm
▶ Flexible	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	6-8 min.	5-10 min.	5 min.	n/a	n/a
▶ Flexible	6-8 min.	5-10 min.	5 min.	n/a	n/a
Dry to handle / polish					
▶ Standard	6 / 7 hrs.	4 / 5 hrs.	3 / 4 hrs.	30 min.	4+8 min.
▶ Flexible	7 / 8 hrs.	5 / 6 hrs.	4 / 5 hrs.	45 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.

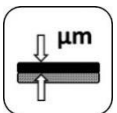
Polishing



Dust and minor imperfections can be polished out after the indicated 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:

- ▶ ±7 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 572 g/liter

Shelflife



nax Premila 9400	4 years
nax Premila 410 2K Hardener	2 years
nax Premila 500 Thinners	2 years
Minimum storage temperature: 5°C (41°F)	Maximum storage temperature: 40°C (100°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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