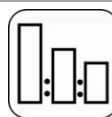


Description


Premium two component hi-solid, hi performance acrylic urethane clear. Provides deep gloss/brilliance and protection over different types of basecoats. Ideal clearcoat from spot repair to complete respray, providing excellent chemical resistance and UV protection.

Suitable Substrates

nax Premila 8000 series base coat
nax E³ WB basecoat system



2 nax Premila 9800 Hi-Solid
1 nax Premila 980 2K Hardener
20-30% 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



1 ½ - 2 coats




25-35 μm /coat




Between coats:
5 - 10 minutes at | 20°C | 70°F |


Before 60°C (140°F) baking:
10-15 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	40 min.	30 min.	20 min.	-	4+8 minutes
Dry to handle	10 hrs.	6 hrs.	5 hrs.	45 min.	
Dry to polish	24 hrs.	16 hrs.	10 hrs.	1 hr. after cooldown	

	nax Premila 9800 Clear 2K Premium Hi-Solid	4 years
	nax Premila 980 2K Hardener	2 years
	nax Premila 500 Thinners	2 years



▶ The VOC content of this product in ready to use form is maximum 474 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

Premium two component hi-solid, hi performance acrylic urethane clear. Provides deep gloss/brilliance and protection over different types of basecoats. Ideal clearcoat from spot repair to complete respray, providing excellent chemical resistance and UV protection.

Suitable Substrates

nax Premila 8000 series base coat
nax E³ WB basecoat system

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

Product and Additives

Product	nax Premila 9800 Clear 2K Premium Hi-Solid		
Hardener	nax Premila 980 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

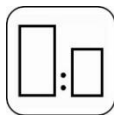
nax Premila 9800 Clear 2K Premium Hi-Solid	Acrylic Polyol
nax Premila 980 2K Hardener	Poly-isocyanate resin
nax Premila 500 Thinners	Blend of solvents

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

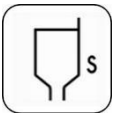
Mixing



Standard	Thinner selection		
	5-20°C	20-35°C	35-45°C
2 nax Premila 9800 Clear 2K Premium Hi-Solid			
1 nax Premila 980 2K Hardener	1-2 panels/spot	Fast	Medium
20-30% nax 500 Thinners	3-5 panels	Medium	medium
	>5 panels	Slow	Slow

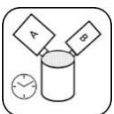
Notes: Stir after each added component

Viscosity (DIN 4 Cup)



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

Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ Standard	2 hours	1 hr	45 min

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	

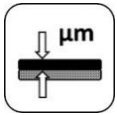
Application



1½ coat Application	▶ Apply one light coat, then allow to flash for 5 minutes. ▶ Apply a wet 2 nd coat.
2 coat Application	▶ Apply one medium coat, then allow to flash for 5-10 minutes. ▶ Apply a wet 2 nd coat.

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

Film thickness



Using the recommended application technique 50-70 µm

Drying time



Dust dry	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	Infra-Red
▶ Standard	40 min.	30 min.	20 min.	-	n/a
Dry to handle and polish					
▶ Standard	10 hrs.	6 hrs.	5 hrs.	45 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.

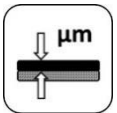
Polishing



Dust and minor imperfections can be polished out after 16 hours on 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:

- ▶ ± 8 m²/liter RTS mixture at 50 -70 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 474 g/liter

Shelflife



nax Premila 9800 Hi-Solid	4 years
nax Premila 980 2K Hardener	2 years
nax Premila 500 Thinners	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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