


**Description**


Ultra-fast curing clear coat for improved productivity and cost reduction. The **prominent** feature of this clear coat is its ultra-high productivity cycle with a dry to polish time of less than 30 minutes under ambient cure conditions (25-30 °C). Avoiding the need of a high temperature baking cycle, therefore meeting the requirements of “quick repair” and “energy saving” concepts. If require, an extremely short time bake of 5 minutes at 50 °C is more than sufficient to achieve ultra-fast curing properties. As a premium clear coat, it offers outstanding application properties, it is easy to polish, and has excellent gloss and appearance.

**Suitable Substrates**


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



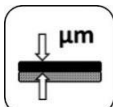
**2** nax Premila 9800HP Velocity Clear  
**1** nax Premila 980 2K Hardener




**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 coats



25-35 µm /coat




**Between coats:** 2 - 5 minutes at | 20°C | 70°F |  
**Before 50°C (122°F) baking:** 2 - 5 minutes at | 20°C | 70°F |



	20°C (70°F)	30°C (70°F)	40°C (70°F)	50°C (122°F)
Dust dry	10 min.	7 min.	5 min.	n/a
Dry to handle	30 min	15 min.	10 min.	5 min.
Dry to polish	60 min.	25 min.	15 min.	after cooldown



nax Premila 9800HP Velocity Clear	4 years
nax Premila 980 2K Hardener	2 years



▶ The VOC content of this product in ready to use form is maximum 520 g/liter



**Use suitable respiratory protection**  
Nippon Paint Automotive Refinishes recommends the use of fresh air supply respirator.

For detailed information read entire TDS

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Ultra-fast curing clear coat for improved productivity and cost reduction. The salient feature of this clear coat is its ultra-high productivity cycle with a dry to polish time of less than 30 minutes under ambient cure conditions (25-30 °C). Avoiding the need of a high temperature baking cycle, therefore meeting the requirements of "quick repair" and "energy saving" concepts. If require, an extremely short time bake of 5 minutes @50 °C is more than sufficient to achieve ultra-fast curing properties. As a premium clear coat, it offers outstanding application properties, it is easy to polish, and has excellent gloss and appearance.

**Suitable Substrates**

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nax E<sup>3</sup> WB basecoat system

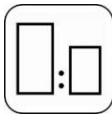
**Notes:** Follow recommended flash off and re-coating time of the basecoat.

**Product and Additives**

<b>Product</b>	nax Premila 9800HP Velocity Clear 2K 2:1		
<b>Hardener</b>	nax Premila 980 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 Premila 9800HP Velocity Clear 2K 2:1	Acrylic resin
nax Premila 980 2K Hardener	Poly-isocyanate resin
nax Premila 500 Thinners	Blend of solvents

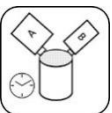
**Mixing**


<b>2</b>	nax Premila 9800HP Velocity Clear 2K 2:1
<b>1</b>	nax Premila 980 2K Hardener
<b>5%*</b>	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>	<b>40°C(100°F)</b>
▶ Standard		14-16 sec	13-14 sec	12-13 sec

**Pot Life**


		<b>20°C(70°F)</b>	<b>30°C(86°F)</b>	<b>40°C(100°F)</b>
▶ Standard		2 hours	1 hour	30 min.

**Notes:** For efficient use, the clearcoat should be applied within 15 minutes after mixing to minimize any impact on application due to rise in viscosity.

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


<b>Spray-gun type</b>	<b>Spray-gun type</b>	<b>Nozzle size</b>	<b>Application pressure</b>
▶ 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

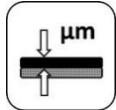


### Standard Application

- ▶ Apply one medium coat, then allow to flash for 2-5 minutes.
- ▶ Apply the 2<sup>nd</sup> wet coat.

**Notes:** Application window: 15°C to 38°C, Relative Humidity – 20% to 85%  
Flash-off time depends on ambient temperature, applied layer thickness and airflow.  
Clean spray-gun immediately after application

## Film thickness



Using the recommended application technique 50-60 µm

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

## Drying time



	20°C(70°F)	30°C(86°F)	40°C(100°F)	50°C(122°F)
Dust dry	10 min.	7 min.	5 min.	n/a
Dry to handle	30 min.	15 min.	10 min.	5 min.
Dry to polish	60 min.	25 min.	15 min.	After cool down

**Notes:** Indicated drying times are panel temperatures. Oven temperature should be set 10 °C higher.  
Following the drying cycle at 50°C (122°F) object temperature, allow product to completely cool down to ambient temperature.

## Polishing



Dust and minor imperfections can be polished out after the indicated air-dry times, or after cool down time following the full bake at 50°C object temperature. Carefully sand out dust particles and restore the surface according polishing recommendations.

- Notes:** **Dirt Removal, Gloss retention and polishing & waxing**
- De-nib using P1500 or finer with soap and water; blow air & dry the sand 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 3M™ with a wool compounding pad and an air or electric buffer at 1400 to 2000 rpm.
  - Polish using 3M™ 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.

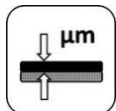
## Re-coating



With itself after complete drying cycle (after 24 hours of drying sanding is necessary)

**Notes:**

## 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 520 g/liter

**Shelflife**


nax Premila 9800HP Velocity Clear	4 years		
nax Premila 980 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 ---

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