

**Description**

Two component quality acrylic urethane primer surfacer for automotive refinishes with excellent application and sanding properties. Designed for all spray application from spot repair to overall repair. Provides excellent filling and gloss hold out.

**Suitable Substrates**

Existing finishes	OEM Electro-coat	Nax PP Primer
Steel	Glass reinforced laminates	Nax polyester bodyfillers & putties
Plastic (except pure PP, PE)		Nax Epoxy Primer
		Nax 1200 Etch Primer

	4 Nax 2200 2K Primer Grey	
	1 Nax 220 2K PrimerHardener	
	1-2 Nax Superio 400 Thinners	

	<b>Spray-gun setup:</b> Gravity fed   1.4 - 1.8 mm	<b>Application Pressure:</b> 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
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	2 - 3 coats		30 - 50 μm / coat
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	<b>Between coats:</b> 5 - 10 minutes at   20°C   70°F	<b>Before 60°C (140°F) baking:</b> 15 minutes at   20°C   70°F
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	<b>Product selection</b>	20°C (70°F)	30°C (86°F)	40°C (100°F)	60°C (140°F)
	<b>Dry to sand</b>	2 hours	1½ hours	1½ hours	30 minutes

3 coat application

	<b>Short wave</b>	<b>Medium wave</b>
	Distance	Distance
	50-70 cm	40-60 cm
	Drying time	Drying time
	4-5 minutes	6-8 minutes

IR Drying The panel must not reach a temperature above 100°C (000°F) while curing

	<b>Final dry sanding:</b> P400 - P500		<b>Final wet sanding:</b> P800 - P1000
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	<b>Re – coatable with:</b> Nax Superio 300 Basecoat System	Nax Superio 400 2K Solid System
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	<b>Use suitable respiratory protection</b> Nippon Paint Automotive Refinishes recommends the use of fresh air supply respirator.
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## Description

Two component quality acrylic urethane primer surfacer for automotive refinishes with excellent application and sanding properties. Designed for all spray application from spot repair to overall repair. Provides excellent filling and gloss hold out.

## Suitable Substrates

Existing finishes	OEM Electro-coat (ED)	Nax PP Primer
Steel	Glass reinforced laminates	Nax polyester bodyfillers & putties
Plastic (except pure PP, PE)		Nax Epoxy Primer
		Nax 1200 Etch Primer

**Notes:** *In the following cases the use etch primer is advised:*

- When the system is required to meet the highest quality standard*
- Repairs that requires an extensive primer surface application, such as complete panel*

## Product and Additives

<b>Product</b>	Nax 2200 2K Primer Grey	<b>Temperature range</b>
<b>Hardeners</b>	Nax 220 2K Primer Hardener	
<b>Thinners</b>	Nax Superio 400 Thinner (Standard)	≤ 30°C
	Nax Superio 401 Thinner (High Temperature)	≥ 30°C
<b>Additives</b>	Nax Softener	

## Basic Raw Materials

<b>Product</b>	<b>Raw Material</b>
Nax 2200 2K Primer Grey	Acrylic resins
Nax 220 2K Primer Hardener	Poly-isocyanate resin
Nax Superio 400 Thinners	Blend of solvents

## Surface preparation



- ▶ Prior to any surface preparation, degrease the repair area using Nax Silicone Off degreaser.
- ▶ Use clean quality rags or wiping towels, one for wetting and one for drying the surface.
- ▶ Apply sufficient degreaser to keep the surface wet.
- ▶ Wipe degreaser off before it can evaporate.



- ▶ Finishing dry sanding steps P220 - P320
- ▶ Nax polyester bodyfillers and putties; finished with P120 - P220
- ▶ For spot repair, finish the area beyond the featheredge sanding with: P400
- ▶ Sound OEM electro (ED) coated parts: P320



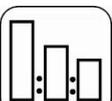
- ▶ Prior to primer surfacer application degrease the application area using Nax Silicone Off degreaser.
- ▶ Use clean quality rags or wiping towels, one for wetting and one for drying the surface.
- ▶ Apply sufficient degreaser to keep the surface wet
- ▶ Wipe degreaser off before it can evaporate

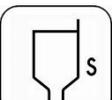
**Notes:** *Respect 100 grit maximum jump in dry sanding steps.  
For detailed surface preparation see TDS*

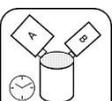
## Flexible Parts

Type of Plastic	Primer Surfacer	Softener	Mixture	Hardener	Thinners
Flexible	100	5%	4	1	1-2
Soft	100	10%	4	1	1-2

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

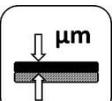
Mixing									
	<p>▶ <b>Mixing Machine</b></p> <p>For best performance, stir primer surfacer on mixing machine twice a day for 15 minutes</p>								
	<p>▶ <b>Product Mix</b></p> <p>Stir well, after each added component.</p>								
	<table border="1"> <thead> <tr> <th>Medium Build</th> <th>Low build</th> </tr> </thead> <tbody> <tr> <td>4</td> <td>4</td> </tr> <tr> <td>1</td> <td>1</td> </tr> <tr> <td>1</td> <td>2</td> </tr> </tbody> </table>	Medium Build	Low build	4	4	1	1	1	2
Medium Build	Low build								
4	4								
1	1								
1	2								
	<p>◀ <b>Application</b></p> <p>Nax 2200 2K Primer Grey                  Nax 220 2K Primer Hardener                  Nax Superio 400 Thinners</p>								

Viscosity (DIN 4 Cup)				
	<b>Application</b>	20°C(70°F)	30°C(86°F)	40°C(100°F)
	▶ Standard	19-23 sec	15-17 sec	13-15 sec
	▶ Flexible Parts	17-19 sec	14-18 sec	12-14 sec

Pot Life				
	<b>Application</b>	20°C(70°F)	30°C(86°F)	40°C(100°F)
	▶ Standard	3 hrs.	2 hrs.	45 min.
	▶ Flexible Parts	3 hrs.	2 hrs.	60 min.

Spray gun set-up / application pressure				
	<b>Applications</b>	<b>Spray-gun type</b>	<b>Nozzle size</b>	<b>Application pressure</b>
	Medium Build	Gravity	1.8-2.0 mm	Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)
	Low build	Gravity	1.4-1.6 mm	1.7-2.2 bar at the spray gun air inlet

Application		
	<b>Applications</b>	<b>Number of coats</b>
	▶ All	Depending on desired film build
	▶ Apply one medium coat over the sanded repair area, then allow to flash for 5-7 minutes	2-3 coats
	▶ Apply the 2 <sup>nd</sup> and 3 <sup>rd</sup> wet coat within each previous coats allowing 5-7 min. between coats.	
<b>Notes:</b>	Allow each coat to flash-off naturally until the surface is completely matt, Do not force-dry by air support Proper flash off helps achieving higher film build. Flash-off time depends on ambient temperature, applied layer thickness and airflow. For maximum build use large fluid tip and lower the application pressure.	

Film thickness			
	<b>Application</b>		
	▶ Standard:	Using the recommended application technique	30-50 µm/coat
	▶ Flexible:	Using the recommended application technique	20-40 µm/coat

Drying time					
		20°C(70°F)	30°C(86°F)	>40°C(100°F)	60°C(140°F)
	▶ Dust dry	10 min.	5 min.	5 min.	-
	▶ Dry to sand (Standard)	2 hours	1½ hours	1½ hour	30 min.
	▶ Dry to sand (Flexible)	3 hours	2 hours	2 hours	40 min.
	▶ Allow 5 minutes flash off prior to infra-red curing ▶ Dry to sand after approximately 10 minutes. ▶ The panel must not reach a temperature above 100°C (210°F) while curing. ▶ For additional infra-red drying information; see TDS				
<b>Notes:</b>	Allow a minimum of 10 minutes flash off at 20°C (70°F) before moving the car into a pre-heated 60°C (140°F) drying oven. All drying times relate to standard application and object temperature. Allow time for the spraybooth to reach the air temperature to enable the heat transfer of 60°C (140°F) to the object. Following the drying cycle at 60°C (140°F) object temperature, allow product to completely cool down to ambient temperature.				

## Surface preparation



- ▶ Prior to primer surfacer sanding, degrease the sanding area using Nax Silicone Off degreaser.
- ▶ Use clean quality rags or wiping towels, one for wetting and one for drying.
- ▶ Apply sufficient degreaser to keep the surface wet.
- ▶ Wipe degreaser off before it can evaporate.



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



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



- ▶ Prior to topcoat application degrease the surface using Nax Silicone Off degreaser.
- ▶ Use clean quality rags or wiping towels, one for wetting and one for drying.
- ▶ Apply sufficient degreaser to keep the surface wet
- ▶ Wipe degreaser off before it can evaporate

*Respect 100 grit maximum jump in dry sanding steps and 200 grit maximum jump in wet sanding steps.*

**Notes:** For detailed surface preparation see TDS

## Re-coating

- ▶ All Nax Superio Topcoats

## Coverage

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

- ▶ ± 08 m<sup>2</sup>/liter RTS mixture at 50µm
- ▶ ± 90 ft<sup>2</sup>/liter RTS mixture at 50µm

**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

## Product storage

Minimum storage temperature:	5°C (41°F)	Maximum storage temperature:	40°C (100°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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