

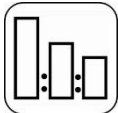
Description

NAX PREMILA 9600HP VELOCITY CLEAR 2K 2:1 is an ultra-fast curing type 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 45 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 20 minutes @60 °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 BASE COAT
NAX SUPERIO BASE COAT

NAX E-CUBE WB
PYLAC 4000

Mixing


Product	Standard	
	By Volume	By Weight
NAX PREMILA 9600HP VELOCITY CLEAR 2K 2:1	2	100
NAX PREMILA 960HP 2K HARDENER	1	50
NAX PREMILA # 20 MEDIUM THINNER NAX PREMILA # 30 SLOW THINNER	5 - 10%	7.5 – 15.0

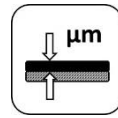
Spray gun setup


Spray-gun setup:
Nozzle size : 1.3 – 1.5 mm

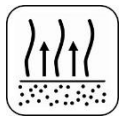
Application Pressure:
1.7 - 2.2 bar, 28 – 30 psi At spray-gun air inlet
HVLP max 0.7 bar (10 psi) at the air cap

Application


Number of spray coats : 2 coats



40 – 60 micron

Flash-off time



Between coats:
2 - 3 minutes at 30°C, 86°F

Drying times


Drying 30°C (86°F)
Dust free
Dry to handle
Dry to polish
Dry to polish (60 C x 20 min.)


NAX PREMILA 960HP 2K HARDENER
10 – 15 min
40 min
45 min
20 min

IR Drying

	Short wave		Medium wave	
	Distance	Drying time	Distance	Drying time
	50 - 70 cm	4 - 8 minutes	40 - 60 cm	8 - 12 minutes

** The panel must not reach a temperature above 100°C (210°F) while curing*

PPE

	Use suitable respiratory protection ▶ Nippon Paint Automotive Refinishes recommends the use of fresh air supply respirator. Further information in SDS
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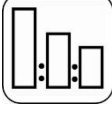
Product and Additives

		<i>Temperature range</i>
Product	NAX PREMILA 9600HP VELOCITY CLEAR 2K 2:1	
Hardeners	NAX PREMILA 960HP 2K HARDENER	
Reducers	NAX PREMILA # 20 MEDIUM THINNER	20 - 35 °C
	NAX PREMILA # 30 SLOW THINNER	35 - 40 °C

Basic Raw Materials

		<i>Raw Material</i>
Product	NAX PREMILA 9600HP VELOCITY CLEAR 2K 2:1	Acrylic polyol resin
	NAX PREMILA 960HP 2K HARDENER	Poly-isocyanate resin
	NAX PREMILA # 20 MEDIUM THINNER	Blend of solvents
	NAX PREMILA # 30 SLOW THINNER	Blend of solvents

Mixing

		By Volume	By Weight
	NAX PREMILA 9600HP VELOCITY CLEAR 2K 2:1	2	100
	NAX PREMILA 960HP 2K HARDENER	1	50
	NAX PREMILA # 20 MEDIUM THINNER	5 - 10 %	7.5 - 15.0
	NAX PREMILA # 30 SLOW THINNER		

** Notes : Stir after each added component*

Viscosity (DIN 4 / Ford 4)

	Application		<i>Notes : 30 °C (86°F)</i>
	DIN 4	14 - 16 sec	
	FORD 4	14 - 16 sec	

Pot Life : 1 hours after mixed with hardener @ 30°C

Pot Life

	Application		30°C (86°F)
	▶ Standard		1 hr

Spray gun set-up / application pressure



Spray-gun type	Nozzle size	Application pressure
▶ LVLP Gravity	1.3 – 1.5 mm	1.7-2.2 bar at the spray gun air inlet (HVLP: max 0.7 bar, 10psi at the air cap)
▶ HVLP Gravity	1.3 – 1.5 mm	

Application



Standard Application

Apply one medium coat, then allow to flash for 2 – 3 minutes.
Apply the 2nd coats (full coat)

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

Drying



Allow for a minimum of 10 minutes flash off time at 25-40 °C before moving the car into a pre-heated 60°C (140°F) drying oven. All drying times relate to standard application and object temperature.
Consider the time required for the spray booth to reach an acceptable air temperature to enable the heat transfer of 60°C (140°F) to the object.

Dust dry		30°C (86°F)
▶	Standard	10 - 15 min.

Dry to Polishing		45 min.
▶	Standard	



- ▶ Infrared 60 °C / distance 80 cm
- ▶ The panel must not reach a temperature above 100°C (210°F) while curing.

Notes : For additional infra-red drying information; see TDS

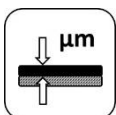
* Following the drying cycle at 60°C (140°F) object temperature, allow product to completely cool down to ambient temperature.

Polishing



Dust and minor imperfections can be polished out after 45 min with Standard hardener, 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.

Film thickness



Application

- ▶ Using the recommended application technique 40 - 60 µm

Coverage

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

7 ± 1 m²/liter RTS at DFT 40 - 60 μ m

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 gun cleaners

Solvent Content

The VOC content of this product in ready to use form is maximum 540-560 g/liter (lb/gallon)

Product storage

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.