# NAX PREMILA 9901 DAIMOND CLEAR 2K 2:1

NP AR

**Professional Use Only**

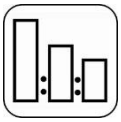
## Description

NAX PREMILA 9901 DAIMOND CLEAR 2K 2:1 is high solid grade with high performance clear. Provides excellent gloss and protection over different types of base coats. That can be used for small paint repairs as well as for re-sprays, providing excellent deep gloss, brilliance and easy to spray.

## 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 9901 DAIMOND CLEAR 2K 2:1 | 2 | 100 |
| NAX PREMILA 9901 DAIMOND HARDENER 2:1 | 1 | 50 |
| NAX PREMILA # 30S SUPERB GOLD 2K THINNER<br>NAX PREMILA # 20 MEDIUM THINNER | 0 - 5% | 0 - 7.5 |

Spray gun setup

Spray-gun setup:

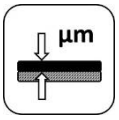
Nozzle size : 1.4 – 1.5 mm

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

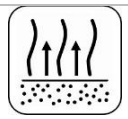
Application

Number of spray coats : 2 coats




50 – 60 micron

Flash-off time



Between coats:

10 minutes at 30°C, 86°F

Before 60°C (140°F) baking:

60 minutes at 30°C, 86°F

Drying times

| Drying 30°C (86°F) | NAX PREMILA 9901 DAIMOND HARDENER 2:1 |
|---|---|
| Dust dry | 1 hr |
| Dry to handle | 24 hrs |
| Dry to polish | 24 hrs |
| Dry to polish (60 C x 30 min.) | 6 hrs |

IR Drying

| Short wave | | Medium wave | |
|---|---|---|---|
| Distance | Drying time | Distance | Drying time |
| 50 - 70 cm | 5 - 8 minutes | 40 - 60 cm | 10 - 15 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*

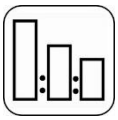
## Product and Additives

| | | *- Temperature range* |
|---|---|---|
| Product | NAX PREMILA 9901 DAIMOND CLEAR 2K 2:1 | |
| Hardeners | NAX PREMILA 9901 DAIMOND HARDENER 2:1 | |
| Reducers | NAX PREMILA # 30S SUPERB GOLD 2K THINNER | 35 – 45 °C |
| | NAX PREMILA # 20 MEDIUM THINNER | 20 – 35 °C |

## Basic Raw Materials

| | | *- Raw Material* |
|---|---|---|
| Product | NAX PREMILA 9901 DAIMOND CLEAR 2K 2:1 | Acrylic polyol resin |
| | NAX PREMILA 9901 DAIMOND HARDENER 2:1 | Poly-isocyanate resin |
| | NAX PREMILA # 30S SUPERB GOLD 2K THINNER | Blend of solvents |
| | NAX PREMILA # 20 MEDIUM THINNER | Blend of solvents |

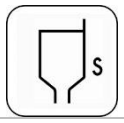
## Mixing



| | By Volume | By Weight |
|---|---|---|
| NAX PREMILA 9901 DAIMOND CLEAR 2K 2:1 | 2 | 2 |
| NAX PREMILA 9901 DAIMOND HARDENER 2:1 | 1 | 1 |
| NAX PREMILA # 30S SUPERB GOLD 2K THINNER<br>NAX PREMILA # 20 MEDIUM THINNER | 0 – 5% | 0 – 7.5 |

** Notes : Stir after each added component*

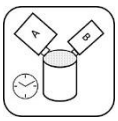
## Viscosity (DIN 4 / Ford 4 )



| Application | | *Notes : 30 °C (86°F)* |
|---|---|---|
| DIN 4 | 16 – 18 sec | |
| FORD 4 | 18 – 20 sec | |

*Pot Life : 1.30 hours after mixed with hardener @ 30°C*

## Pot Life



| Application | 30°C (86°F) |
|---|---|
| ▸ Standard | 1 hr 30 min |

## Spray gun set-up / application pressure

| Spray-gun type | Nozzle size | Application pressure |
|---|---|---|
| ▸ LVLP Gravity | 1.4 – 1.5 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 | 1.4 – 1.5 mm | |

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## Application

**Standard Application**
Apply one medium coat, then allow to flash for 10-15 minutes.
Apply the 2nd coats allowing 10-15 minutes between coats.

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

## Drying

Allow for a minimum of 60 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 | 60 min. |
| **Dry to Polishing** | | |
| ▶ | Standard | 24 hours |

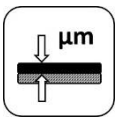
- ▶ Infrared 60 °C / distance 80 cm
- ▶ The panel must not reach a temperature above 100°C (210°F) while curing.

***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 24 hours 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** | |
|---|---|---|---|
| ▶ | All | Using the recommended application technique | 50 - 60 µm |

## Coverage

By using the recommended application, the theoretical material coverage is:
7 ± 1 m²/liter RTS at DFT 50 - 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 gun cleaners

## Solvent Content


The VOC content of this product in ready to use form is maximum 410 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.*