


**Description**

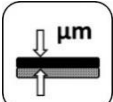
High quality extra solid two component acrylic urethane clear. Provides excellent gloss and protection over Solvent and water borne basecoats. Ideal clearcoat from spot repair to complete respray, providing excellent chemical resistance and UV protection.


**Suitable Substrates**


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

	2	nax Premila 9600
	1	nax Premila 210 Hardeners
	0-10%	nax Premila 500 Thinners


	<b>Spray-gun setup:</b>	<b>Application Pressure:</b>
	Gravity fed   1.3-1.4 mm	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		40-60 µm
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	<b>Between coats:</b>	<b>Before 60°C (140°F) baking:</b>
	5 - 10 minutes at   20°C   70°F	5 - 10 minutes at   20°C   70°F

		20°C (70°F)	30°C (70°F)	40°C (70°F)	60°C (140°F)	Infra-Red
	Dust dry	15 min.	10 min.	10 min.	-	4+8 minutes
	Dry to handle	8-6 hours	6-4 hrs.	4-3 hrs.	20-30 min.	
Dry to polish	8-6 hours	6-4 hrs.	4-3 hrs.	1 hr. after cooldown		

	nax Premila 9600	4 years
	nax Premila 210 Hardeners	2 years
	nax Premila 500 Thinners	2 years

	▶ The VOC content of this product in ready to use form is maximum	550 g/liter
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	<b>Use suitable respiratory protection</b>
	Nippon Paint Automotive Refinishes recommends the use of fresh air supply respirator.

For detailed information read entire TDS

## Description

High quality extra solid two component acrylic urethane clear. Provides excellent gloss and protection over solvent and water borne 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 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 9600 Clear 2K Extra Solid 2:1		
<b>Hardener</b>	nax Premila 210 2K Hardener nax Premila 210 Hardener Rapid		
<b>Reducers</b>	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
<b>Additives</b>	nax Softener		

## Basic Raw Materials

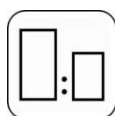
nax Premila 9600 Clear 2K Extra Solid 2:1	Acrylic Polyol
nax Premila 210 Hardeners	Poly-isocyanate resin
nax Premila 500 Thinners	Blend of solvents

## Flexible Parts

Type of Plastic	Clearcoat	nax Softener
Flexible/Soft	100	5%
Soft	100	10%

**Notes:** Hard plastic requires no softener. For plastic type information check nax Softener TDS (LAR.08.012)  
Stir well after adding the additive

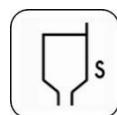
## Mixing



Std.	Fast		Hardener/Thinner Selection			
			5-20°C	20-35°C	35-45°C	
2	2	nax Premila 9600 Clear 2K Extra Solid 2:1				
1	-	nax Premila 210 2K Hardener	1-2 panels	Rapid/Fast	Rapid/Med.	Std/Slow
-	1	nax Premila 210 Hardener Rapid	3-5 panels	Rapid/Med.	Std/Med	Std/Slow
0-10%	0-10%	nax 500 / 501 / 502 / 503 Thinners(optional)	>5 panels	Std/Slow	Std/Slow	Std/Slow

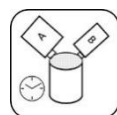
**Notes:** Above ratio is for both normal and flexible system  
Stir after each added component  
nax Matt Clear is very flexible clear and hence does not require nax softener

## Viscosity (DIN 4 Cup)



	20°C(70°F)	30°C(86°F)
▶ Standard	17-18 sec	14-17 sec
▶ Fast	17-18 sec	14-17 sec

## Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ Standard	2 hrs	1½ hrs	1 hr
▶ Fast	1½ hrs	45 min	30 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	

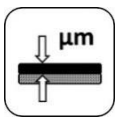
**Application**



- Standard Application**
- ▶ Apply one medium coat, then allow to flash for 5-10 minutes.
  - ▶ Apply the 2<sup>nd</sup> and if required a 3<sup>rd</sup> wet coats allowing 5-10 minutes between coats.

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

**Film thickness**



▶ All	Using the recommended application technique	40-60 µm
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**Drying time**



Dust dry	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C(140°F)	Infra-Red
▶ Standard	10-20 min.	10-20 min.	10 min.	-	n/a
▶ Fast	10 min.	5-10 min.	5 min.	-	n/a
Dry to handle and polish					
▶ Standard	8 hrs.	6 hrs.	4 hrs.	30 min.	4+8 min.
▶ Fast	6 hrs.	4 hrs.	3 hrs.	20 min.	n/a

**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.

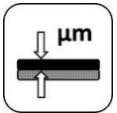
**Polishing**



Dust and minor imperfections can be polished out after 6 hours with Standard hardener and 2 hours with Fast hardener 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:

- ▶ ±7 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 550 g/liter

**Shelflife**



nax Premila 9600	4 years
nax Premila 210 Hardeners	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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