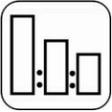


## Description

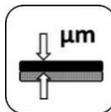
Two-pack fast drying light grey sanding primer filler with excellent application and sanding properties. Due to its fast ambient drying, it helps to reduce process time and provides exceptional enamel hold-out with all Nippon Paint nax topcoats.

## Suitable Substrates

Existing finishes	Glass reinforced laminates	nax polyester bodyfillers & putties
Steel	nax plastic primers	nax etching primers
OEM Electro-coat	nax epoxy primers	

	4 nax 2400 Urethane Primer Grey
	1 nax 240 Urethane Primer Hardener
	1-2 nax Premila Thinners

	<b>Spray-gun setup:</b>	<b>Application Pressure:</b>
	Gravity fed   1.4 - 1.8 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 - 3 coats		40-50 µm /coat (4:1:1)
			30-40 µm /coat (4:1:2)

	<b>Between coats:</b>	<b>Before 60°C (140°F) baking:</b>
	5 - 7 minutes at   20°C   70°F	10 minutes at   20°C   70°F

	Dry to sand	20°C (70°F)	30°C (86°F)	40°C (100°F)	60°C(140°F)	Infra-Red 4+8 minutes
		2 hours	1½ hours	1½ hours	30 minutes	

	<b>Final dry sanding:</b>		<b>Final wet sanding:</b>
	P400 - P500		P800 - P1000

	<b>Re – coating</b>
	With itself and all nax Premila primers, primer fillers and surfacers
	With nax E-Cube WB Basecoat, nax Premila 8000 Basecoat and nax Premila 7000 2K Solid Topcoat

	nax 2400 Urethane Primer Grey	2 years
	nax 240 Urethane Primer Hardener	2 years
	nax Premila Thinners	2 years

	VOC	▶ The VOC content of this product in ready to use form is maximum	606 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

Two-pack fast drying light grey sanding primer filler with excellent application and sanding properties. Due to its fast ambient drying, it helps to reduce process time and provides exceptional enamel hold-out.

## Suitable Substrates

Existing finishes	Glass reinforced laminates	nax epoxy primers
Steel	nax plastic primers	nax etching primers
OEM Electro-coat (ED)	nax polyester bodyfillers & putties	

**Notes:** In the following cases the use etch primer is advised:  
 a. When the system is required to meet the highest quality standard  
 b. Repairs that requires an extensive primer surface application, such as complete panel

## Product and Additives

<b>Product</b>	nax 2400 Urethane Primer Grey	Acrylic resins	<b>Temperature range</b>
<b>Hardeners</b>	nax 240 Urethane Primer Hardener	Poly-isocyanate resin	
<b>Thinners</b>	nax Premila 10 Fast Thinner (aka 502)	Blend of solvents	5-20°C
	nax Premila 20 Medium Thinner (aka 500)	Blend of solvents	20-35°C
	nax Premila 30 Slow Thinner (aka 501)	Blend of solvents	35-45°C
	nax Premila 40 Extra Slow Thinner (aka 503)	Blend of solvents	35-50°C
<b>Additives</b>	nax Softener		

## Surface preparation



- ▶ Prior to any surface preparation, degrease the repair area using nax solventborne 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 and wipe degreaser off before it can evaporate



- ▶ Removal of existing finish and initial sanding of polyester bodyfiller/putty P120
- ▶ Feather edge before polyester/putty and finish, sanding for complete panel priming P220
- ▶ Feather edge and final step before spraying primer/surfacers for spot repairs P320
- ▶ Sound OEM electro (ED) coated parts: P320



- ▶ Prior to primer surfacer application degrease the application area using nax solventborne 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 and wipe degreaser off before it can evaporate

**Notes:** Respect 100 grit maximum jump in dry sanding steps.

## Mixing



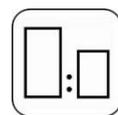
### Mixing Machine

For best performance, stir primer on mixing machine twice a day for 15 minutes



### Product Mix

Stir well, after each added component.



HB	MB	
4	4	nax 2400 Urethane Primer Grey
1	1	nax 240 Urethane Primer Hardener
1	2	nax Premila 10/20/30/40 thinners (aka 502/500/501/503)

	Thinner selection		
	Fast	Medium	Slow
	5-20°C	20-35°C	35-45°C
1-2 panels/spot	Fast	Medium	Slow
3-5 panels	Medium	medium	Slow
>5 panels	Slow	Slow	Slow

**Notes:** Stir after each added component

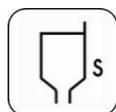
## Flexible Parts

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

**Notes:** Hard plastic requires no softener.

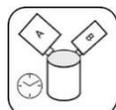
*Stir well after adding the additive*

## Viscosity (DIN 4 Cup)



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ High Build	19-23 sec	19-23 sec	19-23 sec
▶ Medium Build	14-18 sec	14-18 sec	14-18 sec

## Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ High build	2 hours	30 min.	30 min.
▶ Medium build	3 hours	1.5 hours	45 min.

## Spray gun set-up / application pressure



	Spray-gun type	Nozzle size	Application pressure
▶ High build	Gravity	1.6-1.8 mm	Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)
▶ Med. build	Gravity	1.4-1.6 mm	1.7-2.2 bar at the spray gun air inlet

## Application



		Number of coats
▶ High build	Depending on desired film build	2-3 coats
▶ Medium build		2-3 coats
▶ Apply one medium coat over the sanded repair area, then allow to flash for 5-7 minutes		
▶ Apply the 2 <sup>nd</sup> and 3 <sup>rd</sup> wet coat within each previous coats allowing 5-7 min. between coats.		

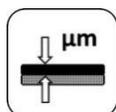
**Notes:** Allow each coat to flash-off naturally until the surface is completely matt, Do not force-dry by air support. Proper flash off helps achieving higher film build. Flash-off time depends on ambient temperature, applied layer thickness and airflow. For maximum build use large fluid tip and lower the application pressure.

## Drying time



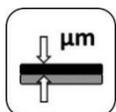
	20°C(70°F)	30°C(86°F)	>40°C(100°F)	60°C(140°F)	IR DRYING
▶ Dust dry	10 min.	5 min.	5 min.	-	n/a
▶ Dry to sand	2 hours	1½ hours	1½ hour	30 min.	n/a
▶ Flexible use	3 hours	2 hours	2 hours	40 min.	4+8 min.

## Film thickness



▶ High build	Using the recommended application technique	50-60 µm/coat
▶ Medium build	Using the recommended application technique	30-40 µm/coat

## Coverage



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

07 - 10	m <sup>2</sup> /liter RTS mixture at	30-60 µm
80-100	ft <sup>2</sup> /liter RTS mixture at	30-60 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.

## Finishing surface preparation



- |   |           |
|---|-----------|
| ▶ Finishing dry sanding steps: 2K Topcoat / Basecoat            | P400/P500 |
| ▶ Initial dry sanding step may be executed with a coarser grit: | P320      |
| ▶ For spot repair, finish the blending area with:               | P500      |
| ▶   |           |



- |   |            |
|---|------------|
| ▶ Finishing wet sanding steps: 2K Topcoat / Basecoat                                  | 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: 2K Topcoat / Basecoat | P600/P800  |
| ▶ For spot repair, finish the blending area with:                                     | P1000      |



- ▶ Prior to SB topcoat application degrease the surface using nax solventborne degreaser.
- ▶ Prior to WB basecoat application degrease the surface using nax E-Cube WB Degreaser.
- ▶ Use clean quality rags or wiping towels, one for wetting and one for drying.
- ▶ Apply sufficient degreaser to keep the surface wet and wipe degreaser off before it can evaporate.

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

## Re-coating



- With itself and all nax Premila primers, primer fillers and surfacers
- With nax E-Cube WB basecoat, nax Premila 8000 Basecoat and nax Premila 7000 2K Solid Topcoat

**Notes:**

## Equipment cleaning

Solvent borne guncleaners

## Solvent Content



- ▶ The VOC content of this product in ready to use form is max 606 g/liter

## Shelflife



nax 2400 Urethane Primer Grey	2 years
nax 240 Urethane Primer Hardener	2 years
nax Premila 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.

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**NP Australia Coatings**

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