

# **TECHNICAL DATA SHEET**

# **NIPPON ULTIMA U-750 EPOXY PRIMER GREY**

Updated Aug'18

Two-pack chromate free, fast drying anti-corrosive primer for pre-treatment for light metals and alloys.

Can be used over abrasive blasted steel to provide optimal corrosion protection and adhesion to the subsequently applied coatings.

#### **Product Features:**

- Excellent adehsion on steel, galvazined steel, stainless and aluminum substances
- · Good corrosion and chemical resistance
- Good filling and hiding properties
- Fast drying

Paint Type	Product Type	Recommended Substrate	Pack Size
Solvent based	Automotive	OEM Electro-coat, Glass reinforced laminates	3.4L Litres primer with
			1.7 Litres hardener

### **Mixing Ratio**

Nax Ultima U-750 Epoxy Primer

Nax UltimaU-750 Epoxy Primer

: 1 part

: 2 parts

Hardener

Re-coating

**Between Coats** 

Nippon Nikko Thinner : 10-20%

### **Technical Data**

**Recoating Time** 30°C(86°F) 40°C(100°F) 60°C(122°F) : 20°C(70°F) **Spraying** 4-5 hours 8-10 hours 5-6 hours 45 minutes

: 10 hours 6 hours 5 hours 45 minutes Brushing : P320-P400 Final Wet Sanding: P600-P800 **Final Dry Sanding** :With all Nax Premila primers, primers fillers and surfacers

With Nax E<sup>3</sup> WB basecoat and premila topcoat system

:10-15 minutes at 20°C, 70°F

Dry Film Thickness : 40-50 µm/ coat

: 2 coats (spraying) 2-3 coats (brushing) No. of Coats

**Theoretical Coverage** : 7 m<sup>2</sup>/liter RTS mixture at 45 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.

Shelf Life : Nax Ultima U-750 Epoxy Primer Grey 2 years

Nax UltimaU-750 Epoxy Primer Hardener 2 years Nippon Nikko Thinner 2 years

Mininum storage temperature: 5°C (41°F), Maximum storage temperature: 35°C (95°F)

Pot Life 40°C(100°F) : 20°C(70°F) 30°C(86°F)

> 3 hours 2 hours 1 ½ hours (spraying) 3 hours 2 hours 1 ½ hours (brushing)

Solvent Content :The VOC content of this product in ready to use form is max 564 g/liter

# **Application Method**

Spraying : Spray-gun type Nozzle size Application pressure

> 1.4-1.6 mm Max 0.6-0.7 bar at the air cap (1.7-2.1 at inlet) Gravity (HVLP, LVLP)

Viscosity (F# 4 cup) : 20°C(70°F) 30°C(86°F) 40°C(100°F)



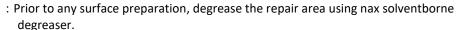
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### **Surface Preparation**









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 for primer/surfacer for spot repairs, (ED) coated parts 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

Apply sufficient degreaser to keep the surface wet and wipe degreaser off before it can evaporate.

#### Cleaning

Clean up equipment with solvent borne guncleaners

### **Safety Precautions**

- Keep container tightly closed and keep out of reach children or away from food and drink.
- Ensure good Ventilation during application and drying.
- When applying paint, it is advisable to wear eye protection.
- In case of contact with eye, rinse with plenty of water immediately and seek medical advice.
- Remove splashes from skin by using soap or water.
- Paint must always be stored in a cool place.
- When transporting paint, care must be taken. Always keep container in a secure upright position.
- Dispose off any paint waste in accordance with the appropriate Environment Quality Regulations.