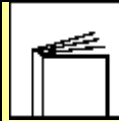




Automotive System

# Nax Premila 9800 HP Velocity Clear 2K 2:1



Technical  
Information

Version 1, 02/2013

## PRODUCT DESCRIPTION

NAX Premila 9800 HP 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 30 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 5 minutes @50 °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.



### Paint system

- Extra fast time. Quick repair to help the task finished in one day.
- Save energy. Preserve environment.
- Best quality over the normal clear in both color and paint film.

### Suitable Substrates

- Nax Premila 8000 series base coats  
(after a minimum flash-off time of 10 minutes @ 30°C)



### Substrate preparation

- Must be applied on top of a clean, dry, dust free base coat surface (use of tack rag is suggested to remove dirt & dust particles from the base coat surface).

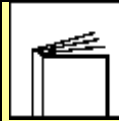
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## Application Guide



### Mixing ratio

2 to 1

100 parts by volume – NAX Premila 9800 HP Velocity  
Clear 2K 2:1

50 parts by volume – NAX Premila 980 2K Hardener

Thinner – Not required (5% Nax Premila Reducer 500 or 503  
can be used for handling ease if necessary)

### Pot Life

2 hours @ 20°C

1.5 hours @ 25°C

1 hours @ 30°C

### Application window

Temperature 15°C to 38°C & Relative Humidity – 20% to 85%  
(Lower temperatures may slow down the curing rate),



### Spraying viscosity

Viscosity/sec	@ 20°C	@ 25°C	@ 30°C
NK #2	13 to 14	12 to 13	11 to 12
Ford Cup # 4	15 to 16	14 to 15	13" to 14



### Spray gun Set-up

Gravity Feed  
full pattern, flow – 3 turns  
from fully closed set-up,

### Nozzle size & Spray pressure

1.3 – 1.4 mm,  
1.5 – 2.0 bar (20-30 psi)

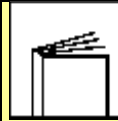
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
# Nax Premila 9800 HP Velocity Clear 2K 2:1



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## Application

	Number of spray coats	2 single coats <ul style="list-style-type: none"> <li>• Light to medium first coat</li> <li>• Full wet second coat             <ul style="list-style-type: none"> <li>○ Recommended dry film thickness – 45 to 60µ</li> <li>○ Clean the spray gun immediately after use</li> </ul> </li> </ul>
	Flash-off time	<ul style="list-style-type: none"> <li>• Between coats - 0 to 2 minutes @ 30°C / 60% R.H.</li> </ul> <p><i>* The specified flash times may vary with temperature &amp; air velocity in the spray booth.</i></p>



### Drying times

#### Air dry conditions

Climate conditions\*

Dirt free time (minutes)

@ 25°C

@ 30°C

~ 8

~ 7

Dry to handle (minutes)

~ 20

~ 15

Dry to polish (minutes)

~ 30

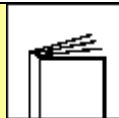
~ 25

### Recoatable time

Recoatable with itself after complete drying cycle however, sanding is necessary after 24 hours to ensure good adhesion – P500 (dry) or P800 (wet).

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**Product Handling & Safety (for professional use only)**

						<p><i>Please refer to Material Safety Data Sheets for full health &amp; safety details and product can labels. Safety &amp; Risk Phrases: Hardeners contains polyisocyanates and therefore safety precautions must be taken while use</i></p>
	Respiratory Mask	Safety Goggles	Protective Clothing	Protective Gloves	Safety Shoes	



Waning

- Flammable liquid and vapor
- Harmful, if swallowed
- Toxic, if inhaled (vapor)
- Causes skin irritation
- Causes serious eye irritation
- May causes allergy or asthma symptoms or breathing difficulties if inhaled
- Toxic to aquatic life
- Store in a closed container.
- Avoid release to the environment.
- Keep away from heat/sparks/open flames/hot surfaces.
- Keep container tightly closed.
- Do not allow to get in eyes, on skin, or on clothing.
- Wear protective gloves/protective clothing/eye protection/face protection.
- IF INHALED: if breathing is difficult, remove victim to fresh air and keep at rest in a position comfortable for breathing.
- IF COMES IN CONTACT WITH EYES: Rinse cautiously with excess water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing.

For further information please contact:

TECHNICAL SERVICES DEPARTMENT, NIPPON PAINT AUTOMOTIVE REFINISH BUSINESS UNIT

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