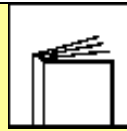




Automotive System

NAX SUPERIO 221 2K CLEAR



Technical
Information

Version 1, 09/2015

PRODUCT DESCRIPTION

NAX SUPERIO 221 2K CLEAR is the good quality 2K acrylic urethane clear 2:1. It is applied on metallic or mica colour to providing excellent gloss hold out and appearance. It is ideal for all spray applications from spot repair to overall refinishing.



Paint system

- High gloss finish
- Fast drying
- It can be applied on NC lacquer, Acrylic lacquer and 2K polyurethane paint.

Suitable Substrates

- Nax Premila 8000 series base coats
(after a minimum flash-off time of 10 minutes @ 30°C)
- Nax Superio base coat system
- Pylac 4000 base coats
- NAX Acrylic 320
- Pylac 3000 base coat



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).

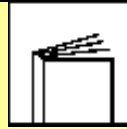
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Nippon Paints (Thailand) Co. Ltd.,
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Application Guide



Mixing ratio	General Use	By Volume
	NAX SUPERIO 221 2K CLEAR	2 parts
	NAX SUPERIO 221 Hardener	1 part
	NAX SUPERIO STANDARD THINNER	20-30 %

Pot Life 2 hours @ 30°C for mixing ratio

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	@30°C
NK # 2	9 to 11
Ford Cup # 4	13 to 15



Spray gun Gravity Feed
Set-up full pattern, flow – 3 turns from fully closed set-up,
Nozzle size & 1.3 – 1.5 mm,
Spray pressure 1.5 – 2.0 bar

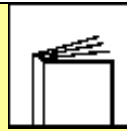
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

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Application

	Number of spray coats	<p>2 single coats</p> <ul style="list-style-type: none"> • Medium for first coat • Full wet second coat <ul style="list-style-type: none"> ○ Recommended dry film thickness – 40 to 60µm ○ Clean the spray gun immediately after use
	Flash-off time	<ul style="list-style-type: none"> • Between coats 2 minutes @ 30°C / 60% R.H. • Set time prior to force drying @ 60°C – 5 to 10 minutes <p><i>* The specified flash times may vary with temperature & air ventilation in the spray booth.</i></p>
	Drying times	<p>Flash-off time 5-10 minutes prior to moving the car or car part into a pre-heated drying oven booth @ 60°C.</p> <p>All drying times listed below relate to standard application and object temperature.</p> <p>The time required for the spray booth to reach an acceptable air temperature to enable the heat transfer of 60°C to the object needs to be considered.</p>

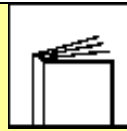
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Drying times

Air dry conditions*

Surface Dry 8 minutes

Hard Dry 6 hours

Dry to spot repair >1 hour

Dry to polish 6 hours

*@ 30°C, Relative Humidity ~ 60%

Baking conditions*

60 °C X 30 minutes

Dry to polish after cool
down 2 hours

Infrared conditions*

Infrared 60°C medium
power/distance 80 cm

Dry to polish after cool
down 30 minutes

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