

Description

E3 WB is the super innovative single-component waterborne base coat system designed to duplicate OEM colours in automotive refinishes. E3 WB has 3 basic concepts Easy /Exciting /Ecology. Which delivers single visit application with wet bed spray process. Provides excellent hiding power with easy application. Complies with the European VOC (420g/l) regulation.

Suitable Substrates

Existing finishes with the exception of thermoplastic acrylic finishes
All Nax Premila preparatory products, with the exception of acid containing etch primer.

Notes: Follow recommended flash off and re-coating time of the wet-on-wet primer.

Product and Additives

Product	Nax E3 WB Toners	
	Nax E3 WB 911 S-Binder	For solid colors
	Nax E3 WB 911 M-Binder	For effect colors
Reducers	Nax E3 WB 950 Metal Fix	For effect colors
	Nax E3 WB R20 Standard Diluent	See diluent selection table
	Nax E3 WB R30 Slow Diluent	See diluent selection table
	Nax E3 WB R40 Extra Slow Diluent	See diluent selection table
Additives	Nax E3 WB R90 Retarder	For extreme conditions
	Nax E3 WB 280 Adjusting Clear	Blending undercoat
	Nax E3 WB Flip Controller	Flip tone controller
Others	Nax E3 WB Hardener	Basecoat hardener
	Nax E3 WB Silicone Off	Surface cleaner
	Nax E3 WB Gun Cleaner	Gun wash liquid

Basic Raw Materials

Product	Raw Material
Nax E3 WB Toners	Polyacrylic polyurethane paint
Nax E3 WB R Diluents	Polyacrylic polyurethane liquid
Nax E3 WB 280 Adjusting Clear	Polyacrylic polyurethane liquid
Nax E3 WB Flip Controller	Polyacrylic polyurethane liquid
Nax E3 WB Hardener	Polyisocinate hardener
Nax E3 WB Silicone Off	Solvent mixture liquid
Nax E3 WB Gun Cleaner	Solvent mixture liquid

Surface preparation (Nax Pro Sanding System)



- ▶ Prior to primer surfacer sanding, degrease the sanding area using Nax Silicone Off degreaser.
- ▶ Use clean quality rags or wiping towels, one for wetting and one for drying.
- ▶ Apply sufficient degreaser to keep the surface wet.
- ▶ Wipe degreaser off before it can evaporate.



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



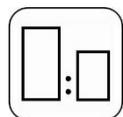
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| ▶ Finishing wet sanding steps: | P800/P1000 |
| ▶ Initial dry sanding step may be executed with a coarser grit: | P320 |
| ▶ Initial wet sanding step may be executed with a coarser grit: | P600/P800 |
| ▶ For spot repair, finish the blending area with: | P1000 |



- ▶ Prior to topcoat application degrease the surface using Nax E3 WB Silicone Off degreaser.
- ▶ Use clean quality rags or wiping towels, one for wetting and one for drying.
- ▶ Apply sufficient degreaser to keep the surface wet
- ▶ 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.
For detailed surface preparation see TDS

Diluent Selection



RH	< 35°C	> 35°C
20 – 60%	R30	R40
< 20%	R30	R40
> 60%	R20	R30

Notes: Flash off speed of the paint depends on the type of air accelerator in use.

Mixing



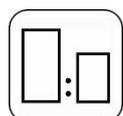
▶ Toner Use

For optimum pour viscosity gently agitate toners before adding to formula mixing.



▶ Color Mix

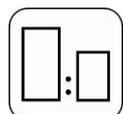
Must be stirred thoroughly directly after mixing the formula.



Solid Colors		Effect Colors		Indicated mixing ratios are by volume
Standard	White	Pearl	Metallic	
100	100	100	100	Nax E3 WB (mixed formula)
20* - 30	10	30	40	Nax E3 WB R Diluents

*low hiding colors

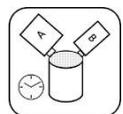
Under clear



100	Nax E3 WB 280 Adjusting Clear
40	Nax E3 WB R Diluents

Notes: The mix can be used as an underclear for color fade out.

Pot Life



Application	20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ With added binders only	90 days		
▶ With added diluents	24 hours		

Spray gun set-up / application pressure



Spray-gun type	Spray-gun type	Nozzle size	Application pressure
▶ LVLP	Gravity	1.2-1.4 mm	1.5-2.0 bar at the spray gun air inlet
▶ HVLP	Gravity	1.2-1.4 mm	(HVLP: max 0.6-0.7 bar at the air cap)

Application

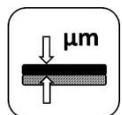


- Solid colors**
 - ▶ Apply 2 medium coats, then flash off till matt using air accelerator
 - ▶ In case of low hiding colors may apply a 3rd coat, then flash off till matt using air accelerator
- Metallic Pearl colors**
 - ▶ Apply a closed wet coat directly followed by a medium coat, then flash off till matt using air accelerator
 - ▶ Apply a final drop-coat for optimal metallic orientation using 1.2 - 1.4 bar (17-20psi) at the gun inlet. Apply the drop coat with full trigger and increase the distance to 30 cm (12 in).
 - ▶ When required, for pearl colours apply a 3rd coat, then flash off till matt using air accelerator. Then apply a drop coat.
- Spot Repair**
 - ▶ Apply one coat of underclear in to the fade out area, staying ±10 cm away from the farther edge of the panel.
 - ▶ Directly after, apply medium coats of color until reaching opacity using lower pressure with application extending into the underclear area, then allow to flash-off till matt.
 - ▶ In case of effect colors apply a final drop coat (metallic orientation coat) by increasing the spray gun distance at a 1.0-1.4 bar application pressure.

Notes: Dry for a minimum of 10 minutes (max. 24 hours) at 25°C (75°F) prior to clearcoat application. Airflow and humidity influences the flash off of waterborne basecoat and can be minimized by using air accelerator equipment.

When heat is used for flash off, prior to proceeding application do allow the object to cool back to application temperature.

Film thickness



Colors

Using the recommended application technique

- | | |
|---|----------|
| ▶ Solid | 20-25 μm |
| ▶ Effect | 15-25 μm |
| ▶ The total dry layer thickness should never exceed 30μm. | |

Denibbing



Following a 20 minutes flash off at 25°C (75°F) the waterborne basecoat can be denibbed for minor defects (e.g. dust) using P800 or P1000 sanding paper, with light pressure while applying air to the surface.

Taping

Following a 20 minutes flash off at 25°C (75°F) the waterborne basecoat can be taped for multi-color application. Temperature increase in combination with air acceleration helps the ability for masking, then allow the object cool down to ambient temperature before masking.

Re-coating time



Following a 20 minutes flash off at 25°C (75°F) the waterborne basecoat can be taped for multi-color application. Temperature increase in combination with air acceleration helps the ability for masking, then allow the object cool down to ambient temperature before masking.

Re-coatable



- ▶ Nax Premila Clearcoats
- ▶ Nax Multi Eco (3+1) GL Clear
- ▶ Nax Crystal 9905 Mirror Image Clear

Coverage

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

- ▶ 6-15 m²/liter RTS mixture at 12 -20 μm DFT

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

Water borne guncleaners (dry spray gun after cleaning)

Solvent Content



- ▶ The VOC content of this product in ready to use form is maximum 420 g/liter

Product storage

Minimum storage temperature:	5°C (41°F)	Maximum storage temperature:	40°C (100°F)
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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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It is always the responsibility of the recipient of our products to ensure that any proprietary rights, existing laws, legislation are observed and to take all necessary steps to fulfill the demands set out in the local rules and legislation. The latest version of TDS supersedes all previous versions.

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