

Professional use only

Description

Premium two component hi-solid, acrylic urethane clear. Provides deep gloss/brilliance and protection over different types of basecoats. Ideal clearcoat from spot repair to complete respray, providing excellent chemical resistance and UV protection over Nax E3 WB Basecoat System.

Suitable Substrates

Nax Premila 8000 series base coat
Nax E3

Notes: Follow recommended flash off and re-coating time of the basecoat.

Product and Additives

		Temperature range
Product	nax Multi Eco (3:1) GL Clear	
Hardeners	nax ULTRA HARDENER #10 <QUICK>	00-15
	nax ULTRA HARDENER #20 <STANDARD>	10-30
	nax ULTRA HARDENER #30 <SLOW>	25-40
Reducers	nax MULTI #5 SUPER QUICK URETHANE THINNER	<10
	nax MULTI #10 QUICK URETHANE THINNER	0-15
	nax MULTI #20 STANDARD URETHANE THINNER	10-30
	nax MULTI #30 SLOW URETHANE THINNER	25-40
	nax MULTI #40 SUPER SLOW URETHANE THINNER	>30
Additives	nax BUMPER USE HARDENER	---

Basic Raw Materials

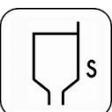
Product	Raw Material
nax Multi Eco (3:1) GL Clear	Polyacrylic clear
nax ULTRA / BUMPER USE HARDENER	Polyisocionate hardener

Mixing

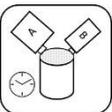
	Volume		Weight		Application
	Standard	Plastic	Standard	Plastic	
	3	4	100	100	Nax Multi Eco (3:1) GL Clear
	1	-	33	-	Nax Ultra Hardeners
	-	1	-	25	Nax Bumper Use Hardener
	1	1-2	20-40	30-50	Nax Multi Urethane Thinners

Notes: Stir after each added component

Viscosity (DIN 4 Cup)

	Application	20°C(70°F)
	▶ Standard	14-16 sec
▶ Plastic	14-16 sec	

Pot Life

	Application	20°C(70°F)	30°C(86°F)
	▶ Standard	2 hours	1 hour

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Spray gun set-up / application pressure



Spray-gun type	Spray-gun type	Nozzle size	Application pressure
▶ LVLP	Gravity	1.3-1.4 mm	1.7-2.2 bar at the spray gun air inlet
▶ HVLP	Gravity	1.3-1.4 mm	(HVLP: max 0.6-0.7 bar at the air cap)

Application



- Standard Application**
- ▶ Apply one medium coat, then allow to flash for 5-10 minutes.
 - ▶ Apply a 2nd wet coat.

Notes: Flash-off time depends on ambient temperature, applied layer thickness and airflow.

Drying



Allow for a minimum of 10 minutes flash off time at 20°C (70°F) before moving the car into a pre-heated 60°C (140°F) drying oven. All drying times relate to standard application and object temperature. *Consider the time required for the spraybooth to reach an acceptable air temperature to enable the heat transfer of 60°C (140°F) to the object.*

Dust dry	20°C(70°F)	60°C(140°F)
▶ Standard	5-10	-
▶ Plastic	5-10	-
Dry to handle*	20°C(70°F)	60°C(140°F)
▶ Standard	12 hrs.	15 min.
▶ Plastic	12 hrs.	-



- ▶ Allow 5 minutes flash off prior to infra-red curing
- ▶ Dry to handle after approximately 10 minutes.
- ▶ The panel must not reach a temperature above 100°C (210°F) while curing.

Notes: For additional infra-red drying information; see TDS
 * Following the drying cycle at 60°C (140°F) object temperature, allow product to completely cool down to ambient temperature.

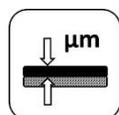
Polishing



Dust and minor imperfections can be polished out after 12 hours on air-dry times, or after a one hour cool down time following the full bake at 60°C object temperature. Carefully sand out dust particles and restore the surface according polishing recommendations.

Notes:

Film thickness



Application		
▶ All	Using the recommended application technique	45-60 µm

Coverage

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

- ▶ ± 5.5 m²/liter RTS mixture at 45-60 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

Solvent borne guncleaners

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Solvent Content	
VOC	<ul style="list-style-type: none"> The VOC content of this product in ready to use form is maximum 570 g/liter (lb/gallon)

Product storage			
Minimum storage temperature:	5°C (41°F)	Maximum storage temperature:	40°C (100°F)
<p>Notes: <i>Product shelf-life is determined when products are stored unopened at 20°C (70°F). Avoid extreme temperature fluctuation.</i></p>			

--- Local organization address with phone number ---

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