

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			
Existing finishes	Plastic (except pure PP, PE)	Nax PP Primer	
Steel	Glass reinforced laminates	Nax polyester bodyfillers & putties	
OEM Electro-coat	Nax 1200 Etch Primer	Nax Epoxy Primer	
Notes:			

Product and Additives		
Product	nax Urethane Primer Surfacer Zitan (Black, Gray, White)	Temperature range
Hardeners	nax ULTRA HARDENER #10 <QUICK>	0-15
	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 Urethane Primer Surfacer Zitan	Polyacrylic paint
nax ULTRA / BUMPER USE HARDENER	Polyisocionate hardener

Suitable Substrates			
Existing finishes	Plastic (except pure PP, PE)	Nax PP Primer	
Steel	Glass reinforced laminates	Nax polyester bodyfillers & putties	
OEM Electro-coat	Nax 1200 Etch Primer	Nax Epoxy Primer	
Notes:			

Surface preparation	
	Prior to any surface preparation Remove oily contamination using Nax Silicone Off degreaser. <ul style="list-style-type: none"> ▶ 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
1	Sanding; final dry sanding step - feather edge: P220 - P320 <ul style="list-style-type: none"> ▶ Sound OEM electro (ED) coated parts; ONLY DEGREASE ▶ Nax polyester bodyfillers and putties; finished with: P120 - P220 ▶ Featheredge sanding for spot repair, finish outer area with: P400
2	
3	Prior to primer surfacer application degrease the surface using Nax Silicone Off degreaser. <ul style="list-style-type: none"> ▶ 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: For detailed surface preparation see TDS	

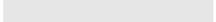
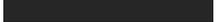
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Tinting

If necessary **Nax Urethane PS Zitan** can be tinted with up to **5%** with **2K Topcoat**

Notes: *Primer Surfacer mixtures with either a 2K topcoat color or grey combination must be stirred thoroughly before adding Hardener. Stir thoroughly once more before adding additional thinner.*

Gray Shade

Code	Impression	Tone	White	Gray	Black
W1		White	100	-	-
W2		Light Gray	50	50	-
W3		Medium Gray	-	100	-
W4		Gray	-	95	5
W5		Medium Dark Gray	-	85	15
W6		Dark Gray	-	70	30
W7		Extra Dark Gray	-	50	50

Notes: *Stir well after adding the different tones together*

Mixing



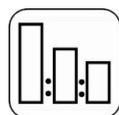
▶ Mixing Machine

For best performance, stir primer surfacer on mixing machine twice a day for 15 minutes



▶ Product Mix

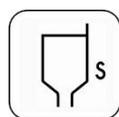
Stir well, after each added component.



Sanding	W-o-W	Sanding Plastic	W-o-W Plastic	◀ Product Mix
7	7	7	7	Nax Urethane Primer Surfacer Zitan
-	-	-	-	Nax Ultra Hardeners
1	1	1	1	Nax Bumper Use Hardener
1	3	1	3	Nax Multi Urethane Thinners

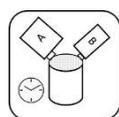
Notes:

Viscosity (DIN 4 Cup)



Application	20°C(70°F)
▶ Sanding	18-30 sec
▶ Wet on Wet	13-14 sec

Pot Life



Application	20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ Sanding	3 hours	1.5 hours	45 min.
▶ Wet on Wet	3 hours	1.5 hours	45 min.
▶ Plastic Part	1.5 hours	45 min.	30 min.

Spray gun set-up / application pressure



Application	Spray-gun type	Nozzle size	Application pressure
▶ Sanding	Gravity	1.6-1.8 mm	Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)
▶ Wet on Wet	Gravity	1.3-1.4 mm	1.7-2.2 bar at the spray gun air inlet

Application



Application	Number of coats
▶ Sanding	Depending on required film build
▶ Wet on Wet	2-3 coats
	1 coat

Sanding Apply one medium coat over the sanded repair area, then allow to flash for 5-10 minutes
Apply the 2nd and 3rd wet coat within each previous coats allowing 5-10 min between coats.

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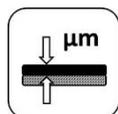
Wet on Wet

Where a full panel application is required apply 2-3 coats over the total panel.
Apply one flowing coat over the panel

Notes:

Allow each coat to flash-off naturally until the surface is completely matt, Do not force-dry by air support
Proper flash off helps achieving higher film build.
Flash-off time depends on ambient temperature, applied layer thickness and airflow.
For maximum build use large fluid tip and lower the application pressure.

Film thickness



Application

Using the recommended application technique

▶ Sanding	40-50 µm/coat
▶ Wet on Wet	25-30 µm/coat

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.

	20°C(70°F)	60°C(140°F)
Dust dry		
▶ Sanding	10 min.	NA
▶ Wet on Wet	5-10 min	NA
Dry to sand	20°C(70°F)	60°C(140°F)
▶ Sanding	2 hours	20 min.
Dry to recoat (Wet on Wet)	15-20 min.	NA

Notes:

*Dry to sand

Following the drying cycle at 60°C (140°F) object temperature, allow product to completely cool down to ambient temperature.



- ▶ Allow 5 minutes flash off prior to infra-red curing
- ▶ Dry to sand 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

Final surface preparation



- ▶ Finishing dry sanding steps: P400 – P500
- ▶ Initial sanding steps can be performed with: (by hand block or machine) P360 – P400



- ▶ Respect the 100 grit step difference in dry sanding process
- ▶ Finishing wet sanding step: P1000
- ▶ Initial wet sanding steps can be performed with: P600 – P800
- ▶ Respect the 200 grit step difference in wet sanding process



Prior to topcoat application degrease the surface using Nax Silicone Off degreaser.

- ▶ Wipe degreaser off before it can evaporate
- ▶ Always use clean rags or paper towels for degreasing, one for wetting one for drying.

Notes:

For detailed surface preparation see TDS:

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Re-coating



- ▶ All Nax Premila Topcoats
- ▶
- ▶
- ▶

Coverage

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

- ▶ ± 05 m²/liter RTS mixture at 3 coats
- ▶ ± 07 m²/liter RTS mixture at 2 coats
- ▶ ± 10 m²/liter RTS mixture at 1 coat, wet on wet

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

Solvent Content



- ▶ The VOC content of this product in ready to use form is max 697 g/liter (lb/gallon)

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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