

Description

Premium quality, high build multi grey shade fast drying, 2K sanding primer filler with excellent application and sanding properties. Due to its fast ambient drying, it helps to reduce process time. Provides exceptional enamel hold-out with all Nippon topcoats. Due to its versatility, it can be used for spot, block and overall repair.

Suitable Substrates

Existing finishes	Glass reinforced laminates	nax polyester bodyfillers & putties
Steel	nax PP Primer	nax 1200 Etch Primer
OEM Electro-coat	nax epoxy primers	

	4 nax 2600 2K Premium Primer
	1 nax 260 Premium Primer Hardener
	1-2 nax Premila 500 Thinners

	Spray-gun setup:	Application Pressure:
	Gravity fed 1.4 - 1.8 mm	1.7 - 2.2 bar 28-30 psi At spray-gun air inlet HVLP max 0.6-0.7 bar (8-10 psi) at the air cap

	2 - 3 coats		120-180 µm High build (4:1:1)
			80-120 µm Medium build (4:1:2)

	Between coats:	Before 60°C (140°F) baking:
	3 - 8 minutes at 20°C 70°F	5 - 10 minutes at 20°C 70°F

	Dry to sand	20°C (70°F)	30°C (86°F)	40°C (100°F)	60°C (140°F)	Infra-Red 4+8 minutes
		2 hours	1½ hours	1½ hours	30 minutes	

	Final dry sanding:		Final wet sanding:
	P400- P500		P800-P1000

	Re – coating
	With all nax Premilla primers, fillers and surfacers
	With all nax E ³ WB basecoat, and Premila topcoat system

	nax 2600 2K Premium Primer	2 years
	nax 260 Premium Primer Hardener	2 years
	nax Premila 500 Thinners	1 year

	▶ The VOC content of this product in ready to use form is maximum	636 g/liter
	VOC	

	Use suitable respiratory protection
	Nippon Paint Automotive Refinishes recommends the use of fresh air supply respirator.

For detailed information read entire TDS

Description

Premium quality, multi grey shade fast drying, 2K sanding primer filler with excellent application and sanding properties. Due to its fast ambient drying, it helps to reduce process time and provides exceptional enamel hold-out with all Nippon topcoats. Due to its versatility, it can be used for spot, block and overall repair.

Suitable Substrates

Existing finishes	OEM Electro-coat (ED)	nax PP Primer
Steel	Glass reinforced laminates	nax polyester bodyfillers & putties
	nax 1200 Etch Primer	nax epoxy primers

Notes: In the following cases the use etch primer is advised:
a. When the system is required to meet the highest quality standard
b. Repairs that requires an extensive primer surface application, such as complete panel

Product and Additives

Product	nax 2600 2K Premium Primer	Temperature range	
Hardeners	nax 260 2K Premium Primer Hardener		
Reducers	nax Premila 500 Thinner		20-35°C
	nax Premila 501 Thinner		35-45°C
	nax Premila 502 Thinner		5-20°C
	nax Premila 503 Thinner		35-50°C
Additives	nax Softener		

Basic Raw Materials

Product	Raw Material
nax 2600 2K Premium Primer	Acrylic resin
nax 260 2K Premium Primer Hardener	Poly-isocyanate resin
nax Premila 500 Thinners	Blend of solvents

Surface preparation



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



- ▶ Removal of existing finish and initial sanding of polyester bodyfiller/putty P120
- ▶ Feather edge before polyester/putty and finish, sanding for complete panel priming P220
- ▶ Feather edge and final step before spraying primer/surfacer for spot repairs P320
- ▶ OEM electro (ED) coated parts: P320



- ▶ Prior to primer surfacer application degrease the application area using nax Silicone Off Degreaser.
- ▶ Use clean quality rags or wiping towels, one for wetting and one for drying the surface.
- ▶ 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. For detailed surface preparation see TDS

Grey Shades (by volume)

Shades	Impression	Name	White (S1)	Gray (S4)	Black (S7)
S1		White	100	-	-
S2		Extra Light Gray	90	-	10
S3		Light Gray	70	-	30
S4		Medium Gray	50	*	50
S5		Dark Gray	30	-	70
S6		Extra Dark Gray	90	-	10
S7		Black	-	-	100

Notes: Stir well after adding the different tones together
*nax 2600 2K Premium Primer Gray (S4) is similar to shade S4 and can be used as a standalone quick gray solution.

Flexible Parts

Type of Plastic	Primer Surfacer	Softener	Mixture	Hardener	Thinner
Flexible/Soft	100	5%	4	1	1-2
Soft	100	10%	4	1	1-2

Notes: Hard plastic requires no softener. Stir well after adding the additive

Mixing



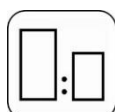
Mixing Machine

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



Product Mix

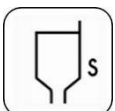
Stir well, after each added component.



HB	MB		Thinner Selection			
			5-20°C	20-35°C	35-45°C	
4	4	nax 2600 Premium Primer				
1	1	nax 260 Premium Primer Hardener	1-2 panels/spot	Fast	Medium	Slow
1	2	nax Premila 500 Thinners	3-5 panels	Medium	medium	Slow
			>5 panels	Slow	Slow	Slow

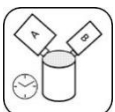
Notes: Stir after each added component

Viscosity (DIN 4 Cup)



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ High Build	17-23 sec	19-23 sec	19-23 sec
▶ Medium Build	14-18 sec	14-18 sec	14-18 sec

Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▶ High build	40 min.	30 min.	20 min.
▶ Medium build	1½ hrs.	60 min.	30 min.

Spray gun set-up / application pressure



	Spray-gun type	Nozzle size	Application pressure
▶ High build	Gravity	1.6-1.8 mm	Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)
▶ Med. build	Gravity	1.4-1.6 mm	1.7-2.2 bar at the spray gun air inlet

Application



		Number of coats
▶ High build	Depending on desired film build	2-3 coats
▶ Medium build	Depending on desired film build	2-3 coats
▶	Apply one medium coat over the sanded repair area, then allow to flash for 5-7 minutes	
▶	Apply the 2 nd and 3 rd wet coat within each previous coats allowing 5-7 min. between coats.	

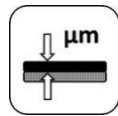
Notes: Allow each coat to flash-off naturally until the surface is completely matt. Do not force-dry by air support. Proper flash off helps achieving higher film build. Flash-off time depends on ambient temperature, applied layer thickness and airflow. For maximum build use large fluid tip and lower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

Drying time



	20°C(70°F)	30°C(86°F)	40°C(100°F)	60°C (140°F)	IR Drying
▶ Dust dry	10 min.	5 min.	5 min.	-	n/a
▶ Dry to sand (Standard)	2 hours	1½ hours	1½ hours	30 min.	n/a
▶ Dry to sand (Flexible)	3 hours	2 hours	1 hour	30 min.	4+8 min

Film thickness



- | | | |
|----------------|---|---------------|
| ▶ High build | Using the recommended application technique | 50-60 μm/coat |
| ▶ Medium build | Using the recommended application technique | 30-40 μm/coat |

Final surface preparation



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



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



- ▶ Prior to topcoat application degrease the surface using nax Silicone Off Degreaser.
- ▶ Prior to WB basecoat application degrease the surface using nax E³ WB Degreaser.
- ▶ Use clean quality rags or wiping towels, one for wetting and one for drying.
- ▶ Apply sufficient degreaser to keep the surface wet and 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

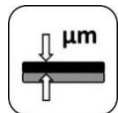
Re-coating



With all nax Premilla primers, fillers and surfacers
With all nax E³ WB basecoat and Premila topcoat systems

Notes:

Coverage



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

8-12	m ² /liter RTS mixture at	30-60μm
85-120	ft ² /liter RTS mixture at	30-60μm

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 636 g/liter

Shelflife



nax 2600 2K Premium Primer	2 years
nax 260 Premium Primer Hardener	2 years
nax Premila 500 Thinners	1 year
Minimum storage temperature:	5°C (41°F) Maximum storage temperature: 35°C (35°F)

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 ---

Brand names and Logos mentioned in this data sheet are trademarks of or are licensed to NIPPON PAINT.

This product is for professional use only and not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, or as a warranty, nor the suitability of the products for a specific purpose. Standard drying times quoted are average times at 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only. In the light of experience and our policy of continuous product development, they may change without prior information and do not constitute the agreed contractual quality of the products (product specification).

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.

Nippon Paint Group AR Office:

148, Sector – 7, IMT Manesar, Gurgaon Haryana – 122050, India

www.nipponpaint-autorefinishes.com