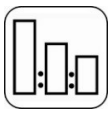
Description

Two component quality acrylic urethane primer surfacer for automotive refinishes with excellent application and sanding properties. Designed for all spray application from spot repair to overall repair. Provides excellent filling and gloss hold out.

Suitable Substrates

Existing finishes	OEM Electro-coat	nax PP Primer
Steel	Glass reinforced laminates	nax polyester bodyfillers & putties
nax Epoxy Primers		



4	nax 2200 2K Primer Grey
1	nax 2200 2K Primer Hardener
1-2	nax Thinners

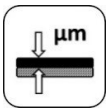


Spray-gun setup:
Gravity fed | 1.4 - 1.8 mm

Application Pressure:
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

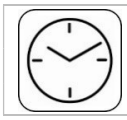


40-50 µm /coat (4:1:1)
30-40 µm /coat (4:1:2)



Between coats:
5 - 10 minutes at | 20°C | 70°F

Before 60°C (140°F) baking:
15 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
2 hours	1½ hours	1 hours	30 minutes	4+8 minutes



Final dry sanding:
P400 - P500



Final wet sanding:
P800 - P1000



Re – coating
nax Superio 300 Basecoat System
nax Superio 400 2K Solid System



nax 2200 2K Primer Grey	4 years
nax 2200 2K Primer Hardener	4 years
nax Thinners	4 years



- The VOC content of this product in ready to use form is maximum 690 g/liter



Use suitable respiratory protection

Nippon Paint Automotive Refinishes recommends the use of fresh air supply respirator.

For detailed information read entire TDS

Description

Two component quality acrylic urethane primer surfacer for automotive refinishes with excellent application and sanding properties. Designed for all spray application from spot repair to overall repair. Provides excellent filling and gloss hold out.

Suitable Substrates

Existing finishes	OEM Electro-coat	nax PP Primer
Steel	Glass reinforced laminates	nax polyester bodyfillers & putties
nax Epoxy Primers		

Notes: *In the following cases the use of 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 2200 2K Primer Grey	Acrylic resins	**Temperature range**
Hardeners	nax 2200 2K Primer Hardener	Poly-isocyanate resin	
Thinners	nax 10 Low Temp Thinner	Blend of solvents	5-20°C
	nax 20 Medium Thinner	Blend of solvents	20-35°C
	nax 30 Slow Thinner	Blend of solvents	35-45°C
	nax 40 Extra Slow Thinner	Blend of solvents	35-50°C
Additives	nax Softener		

Surface preparation



- Prior to any surface preparation, degrease the repair area using nax solvent borne 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 and 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
▸ Sound OEM electro (ED) coated parts:	P320



- Prior to primer surfacer application degrease the application area using nax solvent borne 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 and wipe degreaser off before it can evaporate

Notes: *Respect 100 grit maximum jump in dry sanding steps.*

Flexible Parts

Type of Plastic	Flexible	Soft	
nax 2200 2K Primer Grey	100	100	By volume
nax Softener	10	5	By volume

Notes: *Hard plastic requires no softener. Stir well after adding the additive*
For plastic type information check nax Softener (LAR.08.012)

Mixing



Mixing

For best performance, stir primer well in the can



Product Mix

Stir well, after each added component.



HB	MB	
4	4	nax 2200 2K Primer Grey
1	1	nax 2200 2K Primer Hardener
1	2	nax Thinners

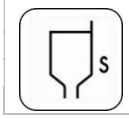
Thinner selection			
	5-20°C	**20-35°C**	**35-45°C**
1-2 panels/spot	10	20	30
3-5 panels	20	20	30
>5 panels	30	30	40

Notes: *Stir well after each added component.*

Mixing (by weight)	(4 : 1 : 1)		
RFU (ml)	nax 2200 2K Primer Grey (gr)	nax 2200 2K Primer Hardener (gr)	nax Thinners (gr)
100	95	16	15
150	143	24	22
200	191	31	29
250	238	39	37
300	286	47	44
400	381	63	59
500	477	78	73
700	572	94	88
1000	667	110	103

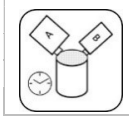
Mixing (by weight)	(4 : 1 : 2)		
RFU (ml)	nax 2200 2K Primer Grey (gr)	nax 2200 2K Primer Hardener (gr)	nax Thinners (gr)
100	82	13	25
150	123	20	38
200	163	27	50
250	204	34	63
300	245	40	75
400	327	54	101
500	409	67	126
700	490	81	151
1000	572	94	176

Viscosity (DIN 4 Cup)



	20°C(70°F)	30°C(86°F)	40°C(100°F)
4:1:1	19-22 sec	16-19 sec	12-15 sec
4:1:2	17-20 sec	14-17 sec	10-13 sec

Pot Life



	20°C(70°F)	30°C(86°F)	40°C(100°F)
4:1:1	1½ hours	30 min	30 min.
4:1:2	2 hours	40 min	35 min.

Spray gun set-up / application pressure



Spray-gun type	Nozzle size	Application pressure
Gravity	1.4-1.8 mm	Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)

Application



	Number of coats
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 2nd and 3rd wet coat within each previous coats allowing 5-7 min. between coats.

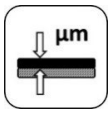
Notes: *Allow each coat to flash-off naturally until the surface is completely matt, Do not force-dry by air support. Proper flash off helps achieving higher film build. Flash-off time depends on ambient temperature, applied layer thickness and airflow. For maximum build use large fluid tip and lower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

Drying time



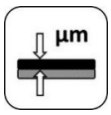
	20°C(70°F)	30°C(86°F)	>40°C(100°F)	60°C(140°F)	IR DRYING
Dust dry	10 min.	5 min.	5 min.	-	n/a
Dry to sand	2 hours	1½ hours	1 hour	30 min.	4+8 min
Flexible use	3 hours	2½ hours	2 hours	40 min.	4+8 min.

Film thickness



Medium Build	Using the recommended application technique	30-40 µm/coat
High Build	Using the recommended application technique	40-50 µm/coat

Coverage



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

07 m²/liter RTS mixture at 50 µm

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.*

Finishing surface preparation



- Finishing dry sanding steps: 2K Topcoat / Basecoat — P400/P500
- 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: 2K Topcoat / Basecoat — 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: 2K Topcoat / Basecoat — P600/P800
- For spot repair, finish the blending area with: — P1000



- Prior to SB topcoat application degrease the surface using nax solvent borne 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.*

Re-coating



With itself and all nax Superio Topcoat

Notes:

Equipment cleaning

Solvent borne gun cleaners

Solvent Content



- The VOC content of this product in ready to use form is max 690 g/liter

Shelf life



nax 2200 2K Primer Grey		4 years	
nax 2200 2K Primer Hardener		4 years	
nax Thinners		4 years	
Minimum storage temperature:	5°C (41°F)	Maximum storage temperature:	35°C (95°F)

Notes: *Product shelf-life is determined when products are stored unopened at 20°C (70°F).Avoid extreme temperature fluctuation.*

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