Description

Two-pack fast drying light grey 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 Paint AR topcoats.

Suitable Substrates

Existing finishes	Glass reinforced laminates	nax polyester bodyfillers & putties
Steel	nax plastic primers	nax etching primers
OEM Electro-coat	nax epoxy primers	

4	nax 2400 Urethane Primer Grey
1	nax 240 Urethane 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 (1.6-1.8 mm spraygun)	▶	40-50 µm /coat (4:1:1)
2 - 3 coats (1.4mm spraygun)	▶	30-40 µm /coat (4:1:2)

Between coats:

5 - 7 minutes at | 20°C | 70°F

Before 60°C (140°F) baking:

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
2 hours	1½ hours	1 hour	30 minutes	4+8 minutes

Final dry sanding:

P400 - P500

Final wet sanding:

P800 - P1000

Re – coating

With itself and all nax Premila primers, primer fillers and surfacers

With nax Premila 8000 Basecoat and nax 7000 2K Solid Topcoat

nax 2400 Urethane Primer Grey	4 years
nax 240 Urethane Primer Hardener	4 years
nax Thinners	4 years

VOC

- The VOC content of this product in ready to use form is maximum 606 g/liter

Use suitable respiratory protection

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

For detailed information read entire TDS

Suitable Substrates

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 2400 Urethane Primer Grey	Acrylic resins	**Temperature range**
Hardeners	nax 240 Urethane Primer Hardener	Poly-isocyanate resin	
Thinners	nax 10 Fast 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 solventborne 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 solventborne 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 Premila primer surfacers / clearcoats	100	100	By volume
nax Softener	5%	10%	By volume

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

Tinting

nax 2400 Urethane Primer Grey can be tinted, up to 10% (by volume) with nax Premila Toners added to the primer prior to hardener and thinner. Once toner added, stir the primer well prior to adding the hardener.

Mixing



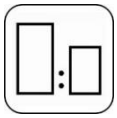
Mixing Machine

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



Product Mix

Stir well, after each added component.



HB	MB	
4	4	nax 2400 Urethane Primer Grey
1	1	nax 240 Urethane Primer Hardener
1	2	nax Thinners

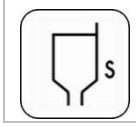
Thinner selection			
	5-20°C	**20-35°C**	**35-45°C**
1-2 panels/spot	10	20	30
3-5 panels	20	20	30
>5 panels	30	30	40

Notes: *Stir well after each added component.*

Mixing (by weight)

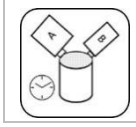
RFU (ml)	High Build (4 : 1 : 1)			Medium Build (4 : 1 : 2)		
	Primer	Hardener	Thinner	Primer	Hardener	Thinner
100	100	16	15	86	13	25
200	200	31	29	171	27	50
300	300	47	44	257	40	75
400	400	63	59	343	54	101
500	500	78	73	429	67	126
700	700	110	103	600	94	176
1000	1000	157	147	857	134	251

Viscosity (DIN 4 Cup)



	20°C(70°F)	30°C(86°F)	40°C(100°F)
▸ High Build	19-23 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	2 hours	30 min.	30 min.
▸ Medium build	3 hours	1.5 hours	45 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		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.

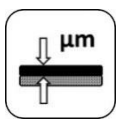
Notes: *Allow each coat to flash-off naturally until the surface is completely matt, Do not force-dry by air support. Proper flash off helps achieving higher film build. Flash-off time depends on ambient temperature, applied layer thickness and airflow. For maximum build use large fluid tip and lower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

Drying time



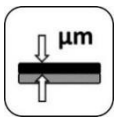
	20°C(70°F)	30°C(86°F)	>40°C(100°F)	60°C(140°F)	IR DRYING
▸ Dust dry	10 min.	5 min.	5 min.	-	n/a
▸ Dry to sand	2 hours	1½ hours	1 hour	30 min.	n/a
▸ Flexible use	3 hours	2 hours	1½ hours	40 min.	4+8 min.

Film thickness



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

Coverage



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

07 - 10	m²/liter RTS mixture at	30-60 µm
80 - 100	ft²/liter RTS mixture at	30-60 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 solventborne 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 Premilla primers, primer fillers and surfacers
With nax Premila 8000 Basecoat and nax 7000 2K Solid Topcoat

Notes:

Equipment cleaning

Solvent borne guncleaners

Shelf life & Storage



nax 2400 Urethane Primer Grey		4 years	
nax 240 Urethane 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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Nippon Paint Group AR Office: 148, Sector – 7, IMT Manesar, Gurgaon Haryana – 122050, India
www.nipponpaint-autorefinishes.com