

NS2602 / NS2607

18.03.2015

NON-SANDING PRIMER-SURFACER

DESCRIPTION

2-component Low Emission Non-Sanding Primer-Surfacer.
Colour: off white, black.
Composition based on a special hydroxy functional acrylic.

PRODUCTS

NS2602	Non-Sanding Primer-Surfacer - off white
NS2607	Non-Sanding Primer-Surfacer - black
XK203	Low Emission Activator Fast
XK205	Low Emission Activator
XK206	Low Emission Activator Slow
256S	Activator Fast
XB383	Standard Thinner
XB387	High Temperature Thinner
AZ9600	Plastic Additive

PROPERTIES

- Provides good filling.
- No convertor required for non-sanding application.
- Can be applied direct to small metal areas.
- Requires no adhesion promoter and is suitable for all common plastics on vehicle exteriors.
- High elasticity.
- Sanding possible after bake or overnight dry.
- Superior topcoat hold-out.
- Part of ValueShade[®] concept.
- Only short flash time required before coating with all topcoats.
- VOC compliant, conform with directive 2004/42/EC.

SUBSTRATES

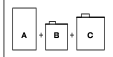








- OEM or cured repair finishes.
- E-coats.
- Bare metals: steel, aluminium and galvanised steel.
- All common plastic parts found on vehicle exteriors:
PP, PP/EPDM, ABS, SAN, PC, PA, PUR-RIM, R-TPU, TPO, PBTP, PUR, PUR flexible foam and UP-GF.
- Sanded polyester putties.
- Wash primers.
- Epoxy primers.

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PRODUCT PREPARATION

 	Mixing ratio ValueShade® M-6153 M-6154 Mixing ratio	ValueShade® 2 ValueShade® 3 ValueShade® 4 ValueShade® 5 ValueShade® 6 ValueShade® 7	NS2602		NS2607	
			100		0	
			95		5	
			85		15	
			55		45	
		20		80		
		0		100		
			Non-Sanding Primer-Surfacer			
			Standard		Large surface	
			Volume	Weight	Volume	Weight
		NS2602/NS2607	4	100	4	100
		XK203/XK205	1	17	-	-
		XK206	-	-	1	17
		XB383/XB387	1.5	20	1.5	20
	VOC	< 540 g/l				
	Pot life at 20°C	XK203 XK205 XK206	45 min 1 hr 1 hr 30 min			
	Spray viscosity at 20°C	DIN 4 FORD 4	16-18 s 16-18 s			
		It is strongly recommended to use appropriate personal protection equipment during application.				
	Spray equipment	Compliant guns Gravity feed Suction feed Pressure feed Conventional guns Gravity feed Suction feed Pressure feed	Fluid tip 1.3-1.5 mm 1.5-1.8 mm 1.0-1.2 mm	Distance 15 cm 15 cm 15 cm	Pressure According to supplier's specifications 3-4 bar 3-4 bar 3-4 bar	
	Number of coats	1-2 (non-sanding) 2 (sanding)				
	Flash time	Between coats till flat. 15 min (till 8 hr maximum) before recoating.				
	DFT	20-30 µm/coat				
	Dry to sand	at 20°C at 60°C	O.N. 25 min			

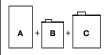








This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.

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PRODUCT PREPARATION

 Mixing ratio ValueShade®  M-6153 M-6154 Mixing ratio	ValueShade® 2	NS2602		NS2607	
	ValueShade® 3	100	0	0	0
	ValueShade® 4	95	5	5	5
	ValueShade® 5	85	15	15	15
	ValueShade® 6	55	45	45	45
	ValueShade® 7	20	80	80	80
	ValueShade® 7	0	100	100	100
		Non-Sanding Plastic Primer-Surfacer			
		Standard		Large surface	
		Volume	Weight	Volume	Weight
	NS2602/NS2607	5	100	5	100
	XK203/XK205	1	14	-	-
	XK206	-	-	1	14
	AZ9600	2.5	26	2.5	26
	VOC	< 540 g/l			
	Pot life at 20°C	XK203	45 min		
		XK205	1 hr		
		XK206	1 hr 30 min		
	Spray viscosity at 20°C	DIN 4	16-18 s		
		FORD 4	16-18 s		
		It is strongly recommended to use appropriate personal protection equipment during application.			
	Spray equipment		Fluid tip	Distance	Pressure
		Compliant guns			
		Gravity feed	1.3-1.5 mm	15 cm	2 – 2.5 bar
		Suction feed	1.5-1.8 mm	15 cm	2 – 2.5 bar
		Pressure feed	1.0-1.2 mm	15 cm	2 – 2.5 bar
		Conventional guns			
		Gravity feed	1.4-1.6 mm	20-25 cm	3-4 bar
		Suction feed	1.6-1.8 mm	20-25 cm	3-4 bar
		Pressure feed	1.0-1.2 mm	20-25 cm	3-4 bar
	Number of coats	1-2			
	Flash time	Between coats till flat. 15 min (till 8 hours maximum) before recoating.			
	DFT	20-30 µm/coat			
	Dry to sand	If required, the product can be lightly denibbed after:			
		at 20°C	2 h		
		at 60°C	30 min		
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SURFACE PREPARATION

OEM and cured repair finishes

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
3. Sand surface:
 - a. mechanical with P220 - P320
 - b. wet with P600
4. Remove all traces of sanding dust, blowing oil-free compressed air.
5. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.

Unsanded E-coat

NS2602/NS2607 can be applied over properly cleaned, unsanded genuine OEM new parts.

1. Carefully inspect all surfaces before overcoating to check for imperfections such as factory runs, sanding marks etc., which would not be filled or covered with w-o-w process.
2. Degrease with Axalta recommended final cleaner/degreaser. Wipe dry with a clean Sontara® cloth.

Bare metals (steel, galvanised steel, aluminium or surface treated aluminium)

1. Clean surface with a preparatory cleaner for bare metals. Wipe dry with a clean cloth.
2. Sand and eliminate all rust and corrosion.
3. Remove all traces of sanding dust, blowing oil-free compressed air.
4. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.
5. 1 coat of wash primer or epoxy primer is needed on large bare metal areas.

Plastics

1. Preheat 30 min at 60°C. (Depending on the type of plastic)
2. Allow to cool.
3. Clean surface with water and soap. Rinse and dry.
4. Clean with a preparatory cleaner for plastics. Wipe dry with a clean cloth.
5. Scuff sanding with sanding pad.
6. Remove all traces of sanding dust, blowing oil-free compressed air.
7. Optionally clean with preparatory cleaner for plastics. Wipe dry with a clean cloth.
8. Degrease with a correct cleaner/degreaser. Wipe and blow dry.

EQUIPMENT CLEANING

Use a correct solventborne gunwash.

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REMARKS

- Also suitable for use under polyester spray putty or polyester putty.
Advised mixing ratio is 3:1:0.8 by volume or 100:21:14 by weight with 256S.
The flash-off time before recoating with polyester products is minimum 30-40 minutes at 20°C.
- When using AZ9600 Plastic additive, drying will be accelerated. Use slower hardeners and thinners to adjust speed of drying.
Non-sanding plastic primer-surfacer setting can also be used on adjacent non plastic panels.
- Do not use activated NS2602/NS2607 beyond the pot life nor reduce it further to get viscosity down again.
- Do NOT exceed recommended film thickness to avoid film defects, poor film through cure and poor adhesion.
- Through cure of the total paint build-up will only be reached after the topcoat has been baked or cured overnight.
- Respect mixing ratios, flash times, spray pressure and DFT to guarantee good topcoat hold-outs.
- Activated material should not be returned to original can of non-activated material.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- Material has to be at room temperature (18-25°C) before use.

PRODUCT DATA

Package viscosity:	1300-1700 cp (at 20 rpm)
Theoretical coverage:	15.8 m ² /l at 25 µm DFT
Directive 2004/42/EC:	2004/42/IIB(c) (540)540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

SAFETY

This product is classified according to regulation (EC) 1272/2008 (CLP). Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

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All other products referred to in the paint system build-up are from Cromax[®]. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax[®], unless explicitly indicated otherwise.

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