PRODUCT DESCRIPTION

604 Factory pack Gloss, Satin and Matt products are designed with the durability to withstand the harsh Australian conditions.

The world-class technology offers easy application that delivers excellent coverage and even Satin, Matt and Gloss finishes off the gun.

PRODUCTS

<table>
<thead>
<tr>
<th>Product Name</th>
<th>Code</th>
</tr>
</thead>
<tbody>
<tr>
<td>604 Factory Pack Satin Black</td>
<td>604-7021</td>
</tr>
<tr>
<td>604 Factory Pack Matt Black</td>
<td>604-7219</td>
</tr>
<tr>
<td>604 Factory Pack Clear 30% Gloss</td>
<td>604-9135</td>
</tr>
<tr>
<td>604 Factory Pack Gloss Clear</td>
<td>604-9113</td>
</tr>
<tr>
<td>604 Factory Pack Jet Black</td>
<td>604-7104</td>
</tr>
<tr>
<td>604 Factory Pack Hi Opacity White</td>
<td>604-8035</td>
</tr>
<tr>
<td>Standard Hardener</td>
<td>604-9101</td>
</tr>
<tr>
<td>Slow Hardener</td>
<td>604-9033</td>
</tr>
<tr>
<td>604 Acrylic Urethane Reducer</td>
<td>R125</td>
</tr>
<tr>
<td>Paraglaze Reducer Standard</td>
<td>PS-6200 Slower drying (For HOT conditions)</td>
</tr>
<tr>
<td>Protec Heavy Duty Wax &amp; Grease Remover</td>
<td>AA-6822</td>
</tr>
</tbody>
</table>

SUBSTRATES & PREPARATION

604 Factory packs can be applied over:

- Sound OEM finishes that have been degreased and sanded
- Sound, fully cured 2 pack refinish finishes that have been degreased and sanded
- Paraglaze 2 pack primers that have been degreased and sanded

Substrates other than those stated above should be tested before use, to ensure that the performance of this product is suitable for its intended use.

The use of a clean tack rag is recommended to remove dust from the surface before topcoating.
### Reducer and Hardener Selection Guide

<table>
<thead>
<tr>
<th>Temperature Range</th>
<th>Products to Use</th>
</tr>
</thead>
<tbody>
<tr>
<td>20°C to 30°C (most common choice)</td>
<td>R125</td>
</tr>
<tr>
<td>30°C to 40°C (also for large areas)</td>
<td>PS-6200</td>
</tr>
</tbody>
</table>

### Mixing Ratio by Volume

<table>
<thead>
<tr>
<th>Product</th>
<th>Parts</th>
</tr>
</thead>
<tbody>
<tr>
<td>604 Factory pack</td>
<td>4</td>
</tr>
<tr>
<td>604 Hardener</td>
<td>1</td>
</tr>
<tr>
<td>604 Reducer</td>
<td>25%</td>
</tr>
</tbody>
</table>

### Potlife

3 hours at 25°C

### Spray Viscosity

15 - 19 seconds (DIN 4) at 25°C.

### Spraygun Settings (Gravity)

- **Setup**: 1.3 - 1.4 mm
- **Spray Pressure**:
  - HVLP / RP: 1.8 - 2.2 bar
  - Conventional: 3.0 - 3.5 bar

### Application & Flash Off (at 25°C)

- Coats: Apply 2 - 3 medium, wet, even coats
- Flash Off Between Coats: 2 - 5 minutes
Protec hardeners and activated products contain isocyanate and therefore particular safety precautions must be taken; please refer to SDS for full health and safety details.

If rectifying, allow 16 hours air dry at 25°C or bake first
Recoatable with itself within 1-2 hours
STARTLINE® P500 (dry) or P800 (wet) abrasive, after bake

DE-NIBBING & POLISHING
Remove dirt if required using wet Startline abrasive, no more than P1500 grit, then cut and polish.

EQUIPMENT CLEANING
After use, clean all equipment thoroughly with cleaning solvent or thinner.

OVERCOAT / RECOAT
PREPARATION: STARTLINE® P500 (dry) or P800 (wet) abrasive, after bake
TIME: Recoatable with itself within 1-2 hours
If rectifying, allow 16 hours air dry at 25°C or bake first

TOTAL DRY FILM BUILD 40 - 60 µm with 2 - 3 coats

HEALTH AND SAFETY
Refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.
Protec hardeners and activated products contain isocyanate and therefore particular safety precautions must be taken; please refer to SDS for full health and safety details.

This product is for professional use only.
The information given in this sheet is for guidance only. 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 or her 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. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.
Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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