

CARMASTER DG COLOUR

PRODUCT DESCRIPTION

Camaster DG Colours are two pack acrylic urethane single layer topcoats that provide easy application and deliver good coverage with a high gloss finish off the gun.

While Carmaster products have been tried and tested to be suitable for use in the harsh Australian conditions, they do not benefit from inclusion in the Protec Autoguard Warranty program. If you require the assurance of a warranted product system, products from the Paraglaze range should be selected.

SUBSTRATES & PREPARATION



Carmaster DG Colour 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
- Carmaster 2 pack primers that have been degreased and sanded
- Plastics that have been prepared and coated with a Protec plastics primer

Carmaster DG Colour can NOT be applied:

- Directly over acid etch primers

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

The use of a clean tack rag is recommended to remove dust from the surface before topcoating.

PRODUCTS

Carmaster DG Colour	CM-XXXX
Carmaster Fast Hardener	CH-5100
Carmaster Normal Hardener	CH-5200
Carmaster Slow Hardener	CH-5300
Carmaster GP 2 Pack Reducer	CS-3800
Protec Flex Additive	AA-5656

REDUCER AND HARDENER SELECTION GUIDE

TEMPERATURE RANGE

PRODUCTS TO USE

Up to 20°C (mainly air dry use)

CH-5100
CS-3800

Carmaster Fast Hardener
Carmaster GP 2 Pack Reducer

20°C to 30°C (most common choice)

CH-5200
CS-3800

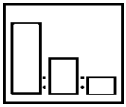
Carmaster Normal Hardener
Carmaster GP 2 Pack Reducer

30°C to 40°C (also for use on large areas)

CH-5300
CS-3800

Carmaster Slow Hardener
Carmaster GP 2 Pack Reducer

MIXING RATIO BY VOLUME



2:1 MODE

PRODUCT	PARTS
Carmaster DG Colour	2
Carmaster Hardener	1
Carmaster GP 2 Pack Reducer	10%

FLEXIBILISATION

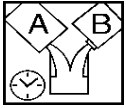
• AA-5656 Protec Flex Additive must be used at the following ratios when applying Carmaster DG Colour over plastics, to ensure proper flexibility of the clearcoat film:

PRODUCT	HARD	FLEXIBLE	HIGHLY FLEXIBLE
	PLASTICS	PLASTICS	PLASTICS
Uncatalysed Carmaster DG Colour	-	5	2
AA-5656	Not Required	1	1

Always add AA-5656 to Carmaster DG Colour first and thoroughly mix → Then add hardener and reducer as per the normal recommendation above.

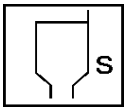
Note: Higher levels of AA-5656 will slow the drying time of Carmaster DG Colour.

POTLIFE



4 hours at 25°C.

SPRAY VISCOSITY



17 - 19 seconds (DIN 4) at 25°C.

SPRAYGUN SETTINGS (GRAVITY)

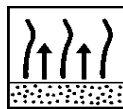


SETUP	1.3 - 1.4 mm
SPRAY PRESSURE	
• HVLP / RP	1.8 - 2.2 bar
• CONVENTIONAL	3.0 - 3.5 bar

APPLICATION & FLASH OFF



Apply 2 - 3 medium, wet, even coats



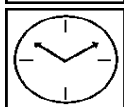
Allow 5 minutes flash off between coats at 25°C

DRYING TIMES & TEMPERATURE



BAKE:

40 minutes at 65°C



I.R.:

Will vary depending upon equipment. Refer to equipment supplier

AIR DRY:

Handle after 12 hours at 25°C

Polish after 24 hours at 25°C

Note: Drying times will need to be extended under cooler conditions. Seek further advice before spraying. Temperature shown is metal temperature.

TOTAL DRY FILM BUILD

40 - 60 µm with 2 - 3 coats

OVERCOAT / RECOAT



PREPARATION:

Startline® P500 (dry) or P800 (wet) abrasive, after baking

TIME:

Recoat with itself within 1-2 hours

If rectifying, allow 16 hours air dry at 25°C or bake first

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.

HEALTH AND SAFETY

Please refer to Material Safety Data Sheets (MSDS) 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 MSDS 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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