Carmaster 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.

**PRODUCTS**

<table>
<thead>
<tr>
<th>Product</th>
<th>Code</th>
</tr>
</thead>
<tbody>
<tr>
<td>Carmaster DG Colour</td>
<td>CM-XXX</td>
</tr>
<tr>
<td>Carmaster Fast Hardener</td>
<td>CH-5100</td>
</tr>
<tr>
<td>Carmaster Normal Hardener</td>
<td>CH-5200</td>
</tr>
<tr>
<td>Carmaster Slow Hardener</td>
<td>CH-5300</td>
</tr>
<tr>
<td>Carmaster GP 2 Pack Reducer</td>
<td>CS-3800</td>
</tr>
<tr>
<td>Protec Flex Additive</td>
<td>AA-5656</td>
</tr>
<tr>
<td>Protec Heavy Duty Degreaser</td>
<td>AA-6822</td>
</tr>
</tbody>
</table>

**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 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>Up to 20°C (mainly air dry use)</td>
<td>CH-5100&lt;br&gt;CS-3800</td>
</tr>
<tr>
<td>20°C to 30°C (most common choice)</td>
<td>CH-5200&lt;br&gt;CS-3800</td>
</tr>
<tr>
<td>30°C to 40°C (also for large areas)</td>
<td>CH-5300&lt;br&gt;CS-3800</td>
</tr>
</tbody>
</table>

MIXING RATIO BY VOLUME

<table>
<thead>
<tr>
<th>PRODUCT</th>
<th>PARTS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Carmaster DG Colour</td>
<td>2</td>
</tr>
<tr>
<td>Carmaster Hardener</td>
<td>1</td>
</tr>
<tr>
<td>CS-3800</td>
<td>10%</td>
</tr>
</tbody>
</table>

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:

<table>
<thead>
<tr>
<th>PLASTIC TYPE</th>
<th>HARD PLASTICS</th>
<th>FLEXIBLE PLASTICS</th>
<th>HIGHLY FLEXIBLE PLASTICS</th>
</tr>
</thead>
<tbody>
<tr>
<td>PRODUCT</td>
<td>PARTS</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Uncatalysed CM-XXXX</td>
<td>Not Required</td>
<td>5</td>
<td>2</td>
</tr>
<tr>
<td>AA-5656</td>
<td>1</td>
<td>1</td>
<td>1</td>
</tr>
</tbody>
</table>

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 or 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)

<table>
<thead>
<tr>
<th>SETUP</th>
<th>1.3 - 1.4 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>SPRAY PRESSURE</td>
<td>• HVLP / RP: 1.8 - 2.2 bar&lt;br&gt;• CONVENTIONAL: 3.0 - 3.5 bar</td>
</tr>
</tbody>
</table>
APPLICATION & FLASH OFF (at 25°C)

- COATS: Apply 2 - 3 medium, wet, even coats
- FLASH OFF BETWEEN COATS: 5 minutes

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: Recoatable 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

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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