CARMASTER

TECHNICAL DATA SHEET

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.

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
Protec Heavy Duty Degreaser	AA-6822

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

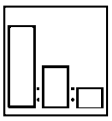
Substrates other than those stated above should be tested before use, to ensure that the performance of this product is suitable for it's intended use.

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

REDUCER AND HARDENER SELECTION GUIDE

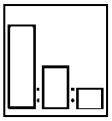
TEMPERATURE RANGE	PRODUCTS TO USE
Up to 20°C *(mainly air dry use)*	CH-5100 CS-3800
20°C to 30°C *(most common choice)*	CH-5200 CS-3800
30°C to 40°C *(also for large areas)*	CH-5300 CS-3800

MIXING RATIO BY VOLUME



PRODUCT	PARTS
Carmaster DG Colour	2
Carmaster Hardener	1
CS-3800	10%

FLEXIBILISATION



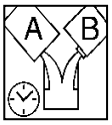
AA-5656 *Protec* Flex Additive must be used at the following ratios when applying Carmaster DG Colour over plastics, to ensure proper flexibility of the clearcoat film:

PLASTIC TYPE	HARD PLASTICS	FLEXIBLE PLASTICS	HIGHLY FLEXIBLE PLASTICS
PRODUCT	**PARTS**		
Uncatalysed CM-XXXX	Not Required	5	2
AA-5656		1	1

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

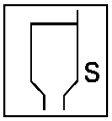
Note: Higher levels or AA-5656 will slow the drying time of Carmaster DG Colour.

POTLIFE



4 hours at 25°C.

SPRAY VISCOSITY



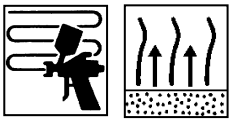
17 - 19 seconds (DIN 4) at 25°C.

SPRAYGUN SETTINGS *(GRAVITY)*

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: 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: 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 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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Protec Pty Ltd. 5 Monahan Rd, Mt Wellington
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EMERGENCY RESPONSE NUMBER, New Zealand: 0800 000 096

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