

PC-3900

PARAGLAZE EXTRA FLOW CLEARCOAT

PRODUCT DESCRIPTION

Paraglaze Extra Flow Clearcoat is a two pack acrylic urethane clearcoat designed for high flow and high clarity.

It is formulated to give optimum gloss and durability when used over *Paraglaze* Basecoat.

Paraglaze Extra Flow Clearcoat is designed to be used for multi panel and overall repainting.

SUBSTRATES & PREPARATION



Paraglaze Extra Flow Clearcoat must be applied over:

- Clean and dust-free *Paraglaze* Basecoat
- Fully cured 2 pack refinish clearcoats that have been degreased and sanded
- Sound OEM clearcoats that have been degreased and sanded

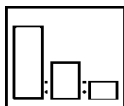
Substrates other than those stated above should be tested before use, to ensure that the performance of this product is suitable for its intended use.

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

PRODUCTS

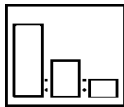
<i>Paraglaze</i> Extra Flow Clearcoat	PC-3900
<i>Paraglaze</i> Hardener Standard	PH-4200
<i>Paraglaze</i> Hardener High Temp	PH-4300
<i>Paraglaze</i> Reducer Low Temp	PS-6100
<i>Paraglaze</i> Reducer Standard	PS-6200
<i>Paraglaze</i> Reducer High Temp	PS-6300
<i>Paraglaze</i> Reducer Extra High Temp	PS-6400
PROTEC® Flex Additive	AA-5656

MIXING RATIO BY VOLUME



PRODUCT	PARTS
PC-3900	2
PH-4200 or PH-4300	1
Paraglaze Reducer	0 - 10%

FLEXIBILISATION



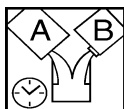
• AA-5656 *Protec Flex Additive* must be used at the following ratios when applying PC-3900 over plastics, to ensure proper flexibility of the clearcoat film:

PRODUCT	HARD	FLEXIBLE	HIGHLY FLEXIBLE
	PLASTICS	PLASTICS	PLASTICS
Uncatalysed PC-3900	-	5 PARTS	2 PARTS
AA-5656	Not Required	1 PARTS	1 PARTS

Always add AA-5656 to PC-3900 first and thoroughly mix → Then add hardener and reducer as per the normal recommendations.

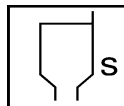
Note: Higher levels of AA-5656 will slow the drying time of PC-3900.

POTLIFE



1 hour at 25°C.

SPRAY VISCOSITY



17 - 19 seconds (DIN 4) at 25°C.

SPRAYGUN SETTINGS (GRAVITY)

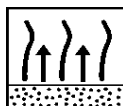


SETUP	1.3 - 1.4 mm
SPRAY PRESSURE	
• HVLP / RP	1.8 - 2.2 bar
• CONVENTIONAL	3.0 - 3.5 bar

APPLICATION & FLASH OFF



Apply two even **full** coats



Allow 5 - 7 minutes flash off between coats at 25°C

BAKING TIME & TEMPERATURE



BAKE:

40 minutes at 60°C

Note: Temperature shown is metal temperature

I.R.:

14 - 18 minutes (short wave)

Will vary depending upon equipment. Refer to equipment supplier

TOTAL DRY FILM BUILD

50 - 60 µm

TOPCOAT / RECOAT



TIME:

Minimum of 8 hours after bake

Air dry overnight at 25°C

PREPARATION:

STARTLINE® P500 (dry) OR
Startline P800 (wet)

DE-NIBBING & POLISHING

Remove dirt if required using *Startline* P1500 grit (wet) abrasive, then cut & polish using your preferred products.

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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