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.

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.

Paraglaze Extra Flow Clearcoat PC-3900
Paraglaze Hardener Standard PH-4200
Paraglaze Hardener High Temp PH-4300
Paraglaze Reducer Low Temp PS-6100
Paraglaze Reducer Standard PS-6200
Paraglaze Reducer High Temp PS-6300
Paraglaze Reducer Extra High Temp PS-6400
PROTEC® Flex Additive AA-5656
Protec Heavy Duty Degreaser AA-6822

Mixing Ratio by Volume

<table>
<thead>
<tr>
<th>PRODUCT</th>
<th>PARTS</th>
</tr>
</thead>
<tbody>
<tr>
<td>PC-3900</td>
<td>2</td>
</tr>
<tr>
<td>PH-4200 or PH-4300</td>
<td>1</td>
</tr>
<tr>
<td>Paraglaze Reducer</td>
<td>0 - 10%</td>
</tr>
</tbody>
</table>

FLEXIBILISATION recommendation over page...
**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:

<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></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Uncatalysed PC-3900</td>
<td>Not Required</td>
<td>5</td>
<td>2</td>
</tr>
<tr>
<td>AA-5656</td>
<td></td>
<td>1</td>
<td>1</td>
</tr>
</tbody>
</table>

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

*Note: Higher levels or 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)**

<table>
<thead>
<tr>
<th>SETUP</th>
<th>1.3 - 1.4 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>SPRAY PRESSURE</td>
<td></td>
</tr>
<tr>
<td>• HVLP / RP:</td>
<td>1.8 - 2.2 bar</td>
</tr>
<tr>
<td>• CONVENTIONAL:</td>
<td>3.0 - 3.5 bar</td>
</tr>
</tbody>
</table>

**APPLICATION & FLASH OFF (at 25°C)**

• COATS: Apply two even full coats, to achieve film build
• FLASH OFF BETWEEN COATS: 5 - 7 minutes

**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

<table>
<thead>
<tr>
<th>TIME:</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum of 8 hours after bake</td>
</tr>
<tr>
<td>Air dry overnight at 25°C</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>PREPARATION:</th>
</tr>
</thead>
<tbody>
<tr>
<td>STARTLINE® P500 (dry) OR Startline P800 (wet)</td>
</tr>
</tbody>
</table>

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

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.

Protec Pty Ltd. 97–105 Bedford Street
Gillman, S.A. 5013 Australia

EMERGENCY RESPONSE NUMBER, Australia: 1800 883 254

Protec Pty Ltd. 5 Monahan Rd, Mt Wellington
Auckland, New Zealand

EMERGENCY RESPONSE NUMBER, New Zealand: 0800 000 096

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