PROTEC AUTOMOTIVE PAINTS

TECHNICAL DATA SHEET

PARA GLAZE

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

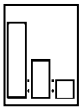
Substrates other than those stated above should be tested before use, to ensure that the performance of this product is suitable for its intended use.

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

PRODUCTS

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

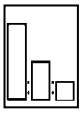
MIXING RATIO BY VOLUME



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

FLEXIBILISATION recommendation over page…

FLEXIBILISATION



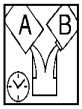
AA-5656 *Protec* Flex Additive must be used at the following ratios when applying PC-3900 over plastics, to ensure proper flexibility of the clearcoat film:

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

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

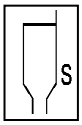
Note: Higher levels or AA-5656 will slow the drying time of PC-3900.

POTLIFE



1 hour at 25°C.

SPRAY VISCOSITY



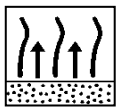
17 - 19 seconds (DIN 4) at 25°C.

SPRAYGUN SETTINGS *(GRAVITY)*

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 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

TIME: Minimum of 8 hours after bake

Air dry overnight at 25°C

PREPARATION: P500 (dry) OR 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

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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