

**PC-4780**

**PARAGLAZE FAST FLOW CLEARCOAT**

**PRODUCT DESCRIPTION**

Paraglaze Fast Flow Clearcoat is a versatile two pack clearcoat that combines the speed you expect from a fast clearcoat with the appearance of a gloss clearcoat.

Paraglaze Fast Flow Clearcoat enables faster process speed, with a very short setup time (i.e. quick flash off between coats) and the ability to polish soon after bake.

It is formulated to give optimum gloss and durability when used over Paraglaze Basecoat. Paraglaze Fast Flow Clearcoat is designed to be used for multi panel work or small areas.

**PRODUCTS**

Paraglaze Fast Flow Clearcoat	PC-4780
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

**SUBSTRATES & PREPARATION**



Paraglaze Fast Flow Clearcoat must be applied over:

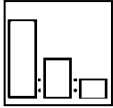
- Clean and dust-free Paraglaze Basecoat
- Fully cured 2 pack refinish clearcoats that have been degreased and sanded
- Sound OEM clearcoats that have been degreased and sanded



*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.*

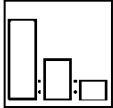
The use of a clean tack rag is recommended to remove dust from the surface before topcoating.

## MIXING RATIO BY VOLUME



PRODUCT	PARTS
PC-4780	3
PH-4200 or PH-4300	1
Paraglaze Reducer	0 - 10%

## FLEXIBILISATION



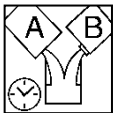
AA-5656 *Protec Flex Additive* must be used at the following ratios when applying PC-4780 over plastics, to ensure proper flexibility of the clearcoat film:

PLASTIC TYPE	HARD PLASTICS	FLEXIBLE PLASTICS	HIGHLY FLEXIBLE PLASTICS
<b>PRODUCT</b>	<b>PARTS</b>		
Uncatalysed PC-4780	Not Required	5	2
AA-5656		1	1

Always add AA-5656 to PC-4780 first and thoroughly mix → Then add hardener and reducer as per the normal recommendations.

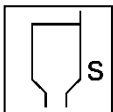
*Note: Higher levels of AA-5656 will slow the drying time of PC-4780.*

## POTLIFE



3 hours at 25°C.

## SPRAY VISCOSITY



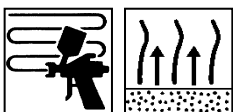
17 - 20 seconds (DIN 4) at 25°C.

## SPRAYGUN SETTINGS (*GRAVITY*)



<b>SETUP</b>	1.3 - 1.4 mm
<b>SPRAY PRESSURE</b>	<ul style="list-style-type: none"> <li>• HVLP / RP: 1.8 - 2.2 bar</li> <li>• CONVENTIONAL: 3.0 - 3.5 bar</li> </ul>

## APPLICATION & FLASH OFF (*at 25°C*)



- COATS: Apply 2 - 3 even **full** coats, to achieve film build
- FLASH OFF BETWEEN COATS: 3 - 5 minutes

## BAKE TIME & TEMPERATURE



<b>BAKE:</b>	20 minutes at 60°C <i>Note: Temperature shown is metal temperature</i>
<b>I.R.:</b>	10 - 15 minutes (short wave) <i>Will vary depending upon equipment. Refer to equipment supplier</i>

**TOTAL DRY FILM BUILD** 40 - 50 µm

## TOPCOAT / RECOAT



<b>TIME:</b>	Minimum 1 hour after cool-down, after bake Air dry overnight at 25°C, minimum of 8 hours
<b>PREPARATION:</b>	STARTLINE® P500 (dry) OR <i>Startline</i> P800 (wet)

## DE-NIBBING & POLISHING

Can de-nib and polish minimum of 1 hour after cool-down.  
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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