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.

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

<table>
<thead>
<tr>
<th>PRODUCT</th>
<th>PARTS</th>
</tr>
</thead>
<tbody>
<tr>
<td>PC-4780</td>
<td>3</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

AA-5656 Protex Flex Additive must be used at the following ratios when applying PC-4780 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>PARTS</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Uncatalysed PC-4780</td>
<td>Not Required</td>
<td>5</td>
<td>2</td>
</tr>
<tr>
<td>AA-5656</td>
<td>1</td>
<td>1</td>
<td>1</td>
</tr>
</tbody>
</table>

Always add AA-5656 to PC-4780 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-4780.

POTLIFE

3 hours at 25°C.

SPRAY VISCOSITY

17 - 20 seconds (DIN 4) at 25°C.

SPRAYGUN SETTINGS (GRAVITY)

<table>
<thead>
<tr>
<th>SETUP</th>
<th>1.3 - 1.4 mm</th>
</tr>
</thead>
</table>
| 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 even **full** coats, to achieve film build
• FLASH OFF BETWEEN COATS: 3 - 5 minutes
BAKE TIME & TEMPERATURE

<table>
<thead>
<tr>
<th>BAKE:</th>
<th>20 minutes at 60°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>I.R.:</td>
<td>10 - 15 minutes (short wave)</td>
</tr>
</tbody>
</table>

*Note: Temperature shown is metal temperature*

Will vary depending upon equipment. Refer to equipment supplier.

TOTAL DRY FILM BUILD

40 - 50 µm

TOPCOAT / RECOAT

<table>
<thead>
<tr>
<th>TIME:</th>
<th>Minimum 1 hour after cool-down, after bake</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Air dry overnight at 25°C, minimum of 8 hours</td>
</tr>
</tbody>
</table>

PREPARATION:

STARTLINE® P500 (dry) OR Startline 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.

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
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EMERGENCY RESPONSE NUMBER, New Zealand: 0800 000 096

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