

## PARAGLAZE GLOSS COLOUR

### PRODUCT DESCRIPTION

Paraglaze Gloss is a premium two pack acrylic urethane single layer topcoat developed specifically to give solid metallic colours the durability to withstand the harsh Australian conditions.

The world-class technology offers easy application that delivers excellent coverage and a high gloss finish off the gun.

### PRODUCTS

Paraglaze Gloss Colour	PM-GMIX, PM-GXXX
Paraglaze CT 4:1 Quick Dry Hardener	PH-2000
Paraglaze Hardener Low Temp	PH-4100
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 Gloss can be applied over:

- Sound OEM finishes that have been degreased and sanded
- Sound, fully cured 2 pack refinish finishes that have been degreased and sanded
- Paraglaze 2 pack primers that have been degreased and sanded
- Plastics that have been prepared and coated with a *Protec* plastics primer



Paraglaze Gloss can NOT be applied:

- Directly over acid etch primers

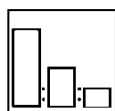
*Substrates other than those stated above should be tested before use, to ensure that the performance of this product is suitable for it's intended use.*

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

## REDUCER AND HARDENER SELECTION GUIDE

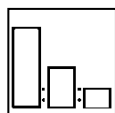
TEMPERATURE RANGE	PRODUCTS TO USE
Up to 20°C ( <i>mainly air dry use</i> )	PH-4100 PS-6100
20°C to 30°C ( <i>most common choice</i> )	PH-4200 PS-6200
30°C to 40°C ( <i>also for large areas</i> )	PH-4300 PS-6300
Over 40°C ( <i>also for large areas</i> )	PH-4300 PS-6400

## MIXING RATIO BY VOLUME



PRODUCT	PARTS
<b>2:1 MODE</b>	
Paraglaze Gloss Colour	2
Paraglaze Hardener	1
Paraglaze Reducer	5 - 20%
<b>4:1 MODE</b>	
Paraglaze Gloss Colour	4
PH-2000	1
Paraglaze Reducer	30%

## FLEXIBILISATION



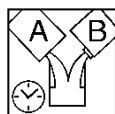
AA-5656 *Protec Flex* Additive must be used at the following ratios when applying PM-GMIX over plastics, to ensure proper flexibility of the clearcoat film:

PLASTIC TYPE	HARD PLASTICS	FLEXIBLE PLASTICS	HIGHLY FLEXIBLE PLASTICS
PRODUCT	PARTS		
Uncatalysed PM-GMIX	Not Required	5	2
AA-5656		1	1

Always add AA-5656 to PM-GMIX first and thoroughly mix → Then add hardener and reducer as per the normal 2:1 or 4:1 recommendations.

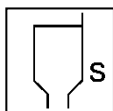
*Note: Higher levels of AA-5656 will slow the drying time of PM-GMIX.*

## POTLIFE



<b>2:1 MODE</b>	4 hours at 25°C
<b>4:1 MODE</b>	3 hours at 25°C

## SPRAY VISCOSITY



17 - 19 seconds (DIN 4) at 25°C.

## SPRAYGUN SETTINGS (*GRAVITY*)



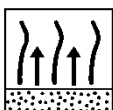
### SETUP

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 2 - 3 medium, wet, even coats
- FLASH OFF BETWEEN COATS: 3 - 5 minutes

## DRYING TIMES & TEMPERATURE



### BAKE:

40 minutes at 60°C

### INFRA RED (I.R.):

Will vary depending upon equipment. Refer to equipment supplier



### AIR DRY:

Handle after 12 hours at 25°C

Polish after 24 hours at 25°C

Note: Drying times will need to be extended under cooler conditions. Seek further advice before spraying. Temperature shown is metal temperature.

**TOTAL DRY FILM BUILD** 40 - 60 µm with 2 - 3 coats

## OVERCOAT / RECOAT



### PREPARATION:

STARTLINE® P500 (dry) or P800 (wet) abrasive, after bake

### TIME:

Recoat with itself within 1-2 hours

If rectifying, allow 16 hours air dry at 25°C or bake first

## DE-NIBBING & POLISHING

Remove dirt if required using wet *Startline* abrasive, no more than P1500 grit, then cut and polish.

## 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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