PROTEC COMMERCIAL TRANSPORT

TECHNICAL DATA SHEET

PARA GLAZE CT

PP-3450 PARAGLAZE CT 2K HP EPOXY PRIMER - GREY

PRODUCT DESCRIPTION

Paraglaze CT 2K HP Epoxy Primer is an adhesion promoting, wet on wet and sandable primer recommended for commercial transport vehicle coating.

It combines good filling and sanding properties with excellent flow, appearance and topcoat gloss hold out.

Paraglaze CT 2K HP Epoxy Primer has outstanding durability, solvent, chemical and corrosion resistance when combined with 2K topcoat systems.

PRODUCTS

Paraglaze CT 2K HP Epoxy Primer Grey			PP-3450
Paraglaze CT 2K HP Epoxy Primer Hardener			PH-2500
Paraglaze CT 2K HP Epoxy Primer Accelerator			PH-2600
Paraglaze Reducer Low Temp	PS-6100		
Paraglaze Reducer Standard	PS-6200	or	EXR20 Epoxy Reducer Normal
Paraglaze Reducer High Temp	PS-6300	or	EXR30 Epoxy Reducer Slow
Paraglaze Reducer Extra High Temp	PS-6400	or	EXR40 Epoxy Reducer Extra Slow
PROTEC® Heavy Duty Degreaser			AA-6822
Metal Conditioner			971-9119 or SX520
SWX250 Water-Methylated Spirits Cleaner			SWX250

SUBSTRATES & PREPARATION

Paraglaze CT 2K HP Epoxy Primer can be applied over the following substrates once they have been prepared as follows:

SUBSTRATE	PREPARATION
Bare Steel	P240 - P320 (dry)
Blasted Steel	Prime within 4 hours of blasting
Bare Steel - Rusted	*Startline* Scourer with 971-9119 *or SX520* Metal Conditioner. When fully dry, follow with P120 - P180 (dry)
Galvanised Steel	*Startline* Scourer with 971-9119 or SX250 Metal Conditioner OR P400 (dry) followed by 971-9119 or SX250 Metal Conditioner
Stainless Steel	P240 - P320 (dry)

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Aluminium	P240 - P320 (dry), then use SWX250 Methylated Spirits mix with one rag to wipe on and another clean rag to wipe off. Prime within 6 hours
GRP & Fibreglass	P240 - P320 (dry)
Aged Painted Surfaces	P240 - P320 (dry)

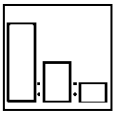
Areas of bare steel where polyester body filler will be applied should be coated first with AP-4110 Protec Epoxy Primer (faster option) or PP-3450 Paraglaze CT 2K HP Epoxy Primer - Grey.

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.

CLEANING

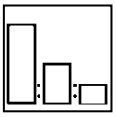
Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Degreaser.

MIXING RATIO BY VOLUME



PRODUCT	PARTS
PP-3450	4
PH-2500	1
Paraglaze Reducer	1 - 1.5

PH-2600 EPOXY PRIMER ACCELERATOR



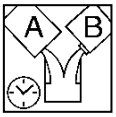
Used to speed up the rate of through cure in low temperature conditions and to improve sanding properties after bake.

If required, add PH-2600 as follows:

- 3% to the above ready for use mix OR
- 5% to PH-3450 before adding hardener and reducer

Note: PH-2600 does not have a significant effect on drying time.

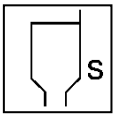
POTLIFE



Catalysed material is useable for up to 5-6 hours at 25°C, without the addition of PH-2600.

When PH-2600 is added, the potlife is shortened to 3 hours at 25°C.

SPRAY VISCOSITY



18 - 21 seconds (DIN 4) at 25°C.

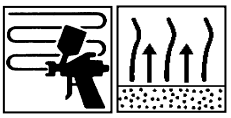
SPRAYGUN SETTINGS *(GRAVITY)*

SETUP 1.6 - 1.8 mm *(1.3 - 1.4 mm, with wet-on-wet application)*

SPRAY PRESSURE

- HVLP / RP: 1.6 - 2.0 bar *(1.6 - 1.8 bar, with wet-on-wet application)*
- CONVENTIONAL: 2.0 - 3.0 bar *(2.0- 2.5 bar, with wet-on-wet application)*

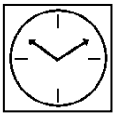
APPLICATION & FLASH OFF *(at 25°C)*



- COATS: Apply 2 even, medium, wet coats
- FLASH OFF BETWEEN COATS: 15 minutes

DRYING TIMES - *primer only*

ROOM TEMP. (25°C)
- DUST FREE: 15 minutes
- THROUGH DRY: Overnight



BAKE: 60 minutes at 60°C

Note: Drying times will need to be extended under cooler conditions. Seek further advice before spraying. Temperature shown is metal temperature. PH-2600 does not have a significant effect on drying time.

TOTAL DRY FILM BUILD

40 - 75 µm

TOPCOAT / RECOAT

TIME AT 25°C: 30 minutes minimum, wet-on-wet

Must be topcoated within 48 hours, otherwise will require sanding

PP-3450 may be topcoated with the following, or as advised by the *Protec* Technical Team:

- Two pack polyurethane topcoats such as Paraglaze Gloss, Carmaster DG, PPT and 625 Polythane
- Basecoats such as Paraglaze Basecoat
- Two pack primers in the Paraglaze and Paraglaze CT ranges

Refer to the relevant topcoat Technical Data Sheet for further details.

Paraglaze CT 2K HP Epoxy Primer may NOT be topcoated with the following:

- Alkyd or Enamel topcoats

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.	**PPG Industries Pty Ltd 14 McNaughton Road** **Clayton, VIC. 3168 Australia** **EMERGENCY RESPONSE NUMBER, Australia: 1800 883 254** **PPG Industries. 5 Monahan Rd, Mt Wellington** **Auckland, New Zealand** **EMERGENCY RESPONSE NUMBER, New Zealand: 0800 000 096**