PROTEC AUTOMOTIVE PAINTS

TECHNICAL DATA SHEET

PARA GLAZE

PP-3860 PARAGLAZE PRIME & FILL

PRODUCT DESCRIPTION

Paraglaze Prime & Fill is a two pack acrylic urethane quick drying high build primer designed for use where a high build is required over repair areas.

It can also be used as a primer surfacer and offers excellent sanding and gloss holdout and can also be tinted with Paraglaze Gloss (PT-G) tinters.

It is recomended for use under Paraglaze Basecoat and Paraglaze Gloss.

PRODUCTS

Paraglaze Prime & Fill	PP-3860
Paraglaze Hardener Low Temp	PH-4100
Paraglaze Hardener Standard	PH-4200
Paraglaze Reducer Low Temp	PS-6100
Paraglaze Reducer Standard	PS-6200
Paraglaze Reducer High Temp	PS-6300
PROTEC® Flex Additive	AA-5656
Protec Heavy Duty Wax & Grease Remover	AA-6822

SUBSTRATES & PREPARATION

Paraglaze Prime & Fill can be applied over the following substrates once they have been prepared as follows:

SUBSTRATE	PREPARATION
Sound OEM finishes and sound, fully cured 2 pack refinish finishes	P240 - P320 (dry)
Small areas of bare steel	P240 - P320 (dry)
New electrocoated panels	P240 - P320 (dry)
GRP & Fibreglass	P240 - P320 (dry)
Plastics	*Protec* Plas Stik Primer - where recommended in the AP-4880 / AP-4990 Technical Data Sheet

Large areas of bare steel and areas 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 or AP-4441 Protec Etch Primer.

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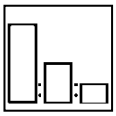
Substrates other than those stated above should be tested before use, to ensure that the performance of this product is suitable for its intended use.

CLEANING

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

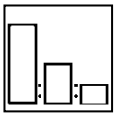
MIXING RATIO BY VOLUME



PRODUCT	PARTS	
PP-3860	4	
Paraglaze Hardener	1	
Paraglaze Reducer	10 - 30%	*(use 30% for wet-on-wet mode)*

If tinting: add up to 10% of Paraglaze Gloss (PT-G) tinter before adding hardener.

FLEXIBILISATION



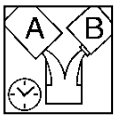
AA-5656 *Protec* Flex Additive must be used at the following ratios when applying PP-3860 over plastics or when the product is used at high film thickness, to ensure proper flexibility of the primer film:

PLASTIC TYPE	HARD PLASTICS	FLEXIBLE PLASTICS	HIGHLY FLEXIBLE PLASTICS
PRODUCT	**PARTS**		
Uncatalysed PP-3860	Not Required	5	2
AA-5656		1	1

Always add AA-5656 to PP-3860 first and thoroughly mix → Then add hardener and reducer as per the normal recommendation above.

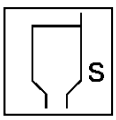
Note: Higher levels or AA-5656 will slow the drying time of PP-3860.

POTLIFE



Catalysed material is useable for up to 1 hour at 25°C.

SPRAY VISCOSITY



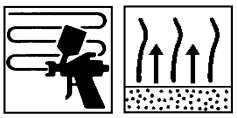
19 - 24 seconds (DIN 4) at 25°C.

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 one even medium coat followed by one or two even wet coats, as required. Do not exceed 4 coats.

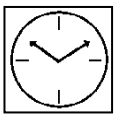
• FLASH OFF BETWEEN COATS: 5 minutes

DRYING TIME & TEMPERATURE

AIR DRY: Overnight at 25°C

BAKE: 40 minutes at 60°C

Note: Temperature shown is metal temperature



I.R.: 12 - 15 minutes (short wave)

Will vary depending upon equipment. Refer to equipment supplier

TOTAL DRY FILM BUILD

150 - 180 µm

OVERCOAT / RECOAT

TIME: Within 72 hours

The vehicle must be kept dry and free of moisture and contaminants during this period.

PREPARATION: P500 (dry) OR P800 (wet)

PP-3860 may be topcoated with the following, or as advised by the *Protec* Technical Team:

- Two pack polyurethane topcoats such as Paraglaze Gloss
- Basecoats such as Paraglaze Basecoat

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

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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