Paraglaze CT 2K HP Primer-Filler is a high build, easy sanding, two pack acrylic urethane primer filler that can be used in primer mode or in filler (high build) mode.

It has the flexibility of being able to be topcoated with Paraglaze Basecoat or Paraglaze Gloss.

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

**SUBSTRATE**
- Bare Steel
- Blasted Steel
- Bare Steel - Rusted
- Galvanised Steel
- Stainless Steel
- Aluminium
- Aged painted surfaces
- Plastics

**PREPARATION**
- PP-3979 Paraglaze CT 1K Etch Primer - Grey
- STARTLINE® P240 - P320 (dry)
- Protec Plas Stik Primer - where recommended in the AP-4880 / AP-4990 Technical Data Sheet

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 Wax & Grease Remover.

MIXING RATIO BY VOLUME

<table>
<thead>
<tr>
<th>PRODUCT</th>
<th>PARTS</th>
</tr>
</thead>
<tbody>
<tr>
<td>PP-5580</td>
<td>4</td>
</tr>
<tr>
<td>Paraglaze Hardener</td>
<td>1</td>
</tr>
<tr>
<td>Paraglaze Reducer</td>
<td>5 - 10 % (Filler Mode)</td>
</tr>
<tr>
<td></td>
<td>15 - 30 % (Primer Mode)</td>
</tr>
</tbody>
</table>

FLEXIBILISATION

AA-5656 Protec Flex Additive must be used at the following ratios when applying PP-5580 over plastics, to ensure proper flexibility of the primer 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 PP-5580</td>
<td>Not Required</td>
<td>5</td>
<td>2</td>
</tr>
<tr>
<td>AA-5656</td>
<td>1</td>
<td>1</td>
<td></td>
</tr>
</tbody>
</table>

Always add AA-5656 to PP-5580 first and thoroughly mix → Then add hardener and reducer as per the normal 2:1 or 4:1 recommendations.

Note: Higher levels or AA-5656 will slow the drying time of PP-5580.

POTLIFE
Catalysed material is usable for up to 1 - 2 hours at 25°C.

SPRAY VISCOSITY

| FILLER               | 30 - 40 seconds (DIN 4) at 25°C |
| SURFACER             | 18 - 25 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 - 4 full wet, even coats
• FLASH OFF BETWEEN COATS: 5 - 10 minutes
**DRYING TIMES - primer only**

<table>
<thead>
<tr>
<th>Room Temp. (25°C)</th>
<th>4 - 8 hours</th>
</tr>
</thead>
</table>
| **BAKE:**         | • Using PH-4100: 25 minutes at 60°C  
|                   | • Using PH-4100: 30 minutes at 60°C |

**TOTAL DRY FILM BUILD**  
60 - 150 µm

**TOPCOAT / RECOAT**

| TIME: | 15 minutes minimum, wet-on-wet, at 25°C  
|       | *Must be topcoated within 24 hours, otherwise will require sanding and recoating with itself in primer mode.* |

PP-5580 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.*

PP-5580 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.