

## PARAGLAZE GLOSS COLOUR

### PRODUCT DESCRIPTION

Paraglaze Gloss is a premium two pack acrylic urethane single layer topcoat developed specifically to give solid and 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          |
| Paraglaze Maxiglaze Accelerator Thinner       | PS-6080          |
| PROTEC® Flex Additive                         | AA-5656          |
| Paraglaze Gloss Matting Base                  | PT-G132          |
| <i>Protec</i> Heavy Duty Wax & Grease Remover | 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

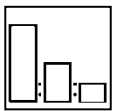
*Substrates other than those stated above should be tested before use, to ensure that the performance of this product is suitable for its intended use.*

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<br>PS-6100 |
| 20°C to 30°C ( <i>most common choice</i> )   | PH-4200<br>PS-6200 |
| 30°C to 40°C ( <i>also for large areas</i> ) | PH-4300<br>PS-6300 |
| Over 40°C ( <i>also for large areas</i> )    | PH-4300<br>PS-6400 |

## MIXING RATIO BY VOLUME



### PRODUCT

### PARTS

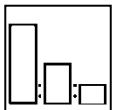
#### 2:1 MODE

|                        |   |
|------------------------|---|
| Paraglaze Gloss Colour | 2   |
| Paraglaze Hardener     | 1   |
| Paraglaze Reducer      | 5 - 20% - If using PS-6080 substitute full amount |

#### 4:1 MODE

|                        |  |
|------------------------|--|
| Paraglaze Gloss Colour | 4  |
| PH-2000                | 1  |
| Paraglaze Reducer      | 30% - If using PS-6080 use 50% Reducer + 50% PS-6080 |

## FLEXIBILISATION



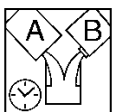
AA-5656 *Protec* Flex Additive must be used at the following ratios when applying PM-GMIX over plastics, to ensure proper flexibility of the clearcoat film:

| PLASTIC TYPE        | HARD PLASTICS | FLEXIBLE PLASTICS | HIGHLY FLEXIBLE PLASTICS |
|---------------------|---------------|-------------------|--------------------------|
| <b>PRODUCT</b>      | <b>PARTS</b>  |                   |                          |
| 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.*

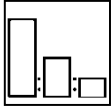
## POTLIFE



**2:1 MODE** 4 hours at 25°C or 1 hour when using PS-6080 Accelerator Thinner

**4:1 MODE** 3 hours at 25°C

## GLOSS ADJUSTMENT GUIDE



To allow for normal variations in the gloss level, depending on the colour, model, position of repair on vehicle etc., it is possible to mix PM-GMIX and PT-G132 in any ratio to match the required gloss for a particular repair.

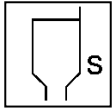
The mixing ratios quoted below give the best starting point:

| GLOSS EFFECT | Matt                           | Low Gloss  | Semi-Gloss |
|--------------|--------------------------------|------------|------------|
| GLOSS RANGE  | 0 - 10%                        | 20.1 - 30% | 45.1 - 60% |
| INGREDIENT   | Mixing Ratio - Parts by Weight |            |            |
| PM-GMIX      | 100                            | 100        | 100        |
| PT-G132      | 100                            | 75         | 60         |

Activate and reduce the resulting mix as above.

*Note: Test panels MUST be sprayed out using the intended hardener/reducer ratio and spraygun combination to check for colour and gloss level against the vehicle to be repaired.*

## SPRAY VISCOSITY



17 - 19 seconds (DIN 4) at 25°C.

## SPRAYGUN SETTINGS (GRAVITY)

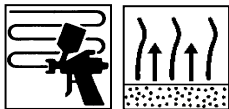


**SETUP** 1.3 - 1.4 mm

**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:** Recoatable 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.

**PPG Industries Australia Pty Ltd, 14 McNaughton Rd  
Clayton, V.I.C. 3168 Australia**

**EMERGENCY RESPONSE NUMBER, Australia: 1800 883 254**

**PPG Industries New Zealand Pty Ltd, 5 Vestey Dr, Mt Wellington  
Auckland, New Zealand**

**EMERGENCY RESPONSE NUMBER, New Zealand: 0800 000 096**

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