

604 FACTORY PACKS

PRODUCT DESCRIPTION

604 Factory pack Gloss, Satin and Matt products are designed with the durability to withstand the harsh Australian conditions.

The world-class technology offers easy application that delivers excellent coverage and even Satin, Matt and Gloss finishes off the gun.

PRODUCTS

604 Factory Pack Satin Black	604-7021	
604 Factory Pack Matt Black	604-7219	
604 Factory Pack Clear 30% Gloss	604-9135	
604 Factory Pack Gloss Clear	604-9113	
604 Factory Pack Jet Black	604-7104	
604 Factory Pack Hi Opacity White	604-8035	
Standard Hardener	604-9101	
Slow Hardener	604-9033	
604 Acrylic Urethane Reducer	R125	
Paraglaze Reducer Standard	PS-6200	Slower drying (For HOT conditions)
<i>Protec Heavy Duty Wax & Grease Remover</i>	AA-6822	

SUBSTRATES & PREPARATION



604 Factory packs 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



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

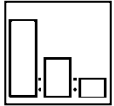
20°C to 30°C (*most common choice*)

R125

30°C to 40°C (*also for large areas*)

PS-6200

MIXING RATIO BY VOLUME



PRODUCT

604 Factory pack

604 Hardener

604 Reducer

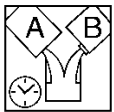
PARTS

4

1

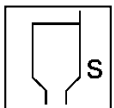
25%

POTLIFE



3 hours at 25°C

SPRAY VISCOSITY



15 - 19 seconds (DIN 4) at 25°C.

SPRAYGUN SETTINGS (*GRAVITY*)



SETUP

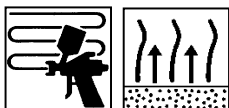
1.3 - 1.4 mm

SPRAY PRESSURE

• HVLP / RP: 1.8 - 2.2 bar

• CONVENTIONAL: 3.0 - 3.5 bar

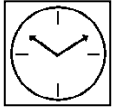
APPLICATION & FLASH OFF (*at 25°C*)



• COATS: Apply 2 - 3 medium, wet, even coats

• FLASH OFF BETWEEN COATS: 2 - 5 minutes

DRYING TIMES & TEMPERATURE



BAKE:	40 minutes at 60°C
AIR DRY:	Handle after 4 hours at 25°C Polish after 16 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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