

PC-3320 PARAGLAZE MAXIGLAZE HS CLEARCOAT

PRODUCT DESCRIPTION

Maxiglaze HS Clearcoat is a high performance, two pack acrylic urethane clearcoat that is specifically formulated to give superior gloss and durability.

It is formulated to give optimum gloss and durability when used over Paraglaze Basecoat and Maxmeyer water bourne basecoat.

PRODUCTS

Maxiglaze HS Clearcoat	PC-3320
Maxiglaze Hardener	PH-4271
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
Protec Heavy Duty Degreaser	AA-6822

SUBSTRATES & PREPARATION



Paraglaze Maxiglaze HS Clearcoat must be applied over:

- Clean and dust-free Maxmeyer waterborne or Paraglaze Basecoat
- Fully cured 2 pack refinish clearcoats that have been degreased and sanded
- Sound OEM clearcoats that have been degreased and sanded



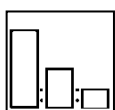
Substrates other than those stated above should be tested before use, to ensure that the performance of this product is suitable for its intended use.

The use of a clean tack rag is recommended to remove dust from the surface before topcoating.

MIXING RATIO BY VOLUME

STD MODE

SINGLE VISIT MODE



PRODUCT

PARTS

PARTS

PC-3320

2

2

PH-4271 hardener

1

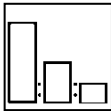
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Reducer

0 - 15%

0 - 10%

FLEXIBILISATION



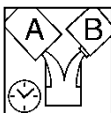
AA-5656 *Protec Flex Additive* must be used at the following ratios when applying PC-3320 over plastics, to ensure proper flexibility of the clearcoat film:

PLASTIC TYPE	HARD PLASTICS	FLEXIBLE PLASTICS	HIGHLY FLEXIBLE PLASTICS
PRODUCT	PARTS		
Uncatalysed PC-3320	Not Required	5	2
AA-5656		1	1

Always add AA-5656 to PC-3320 first and mix thoroughly → then add hardener and reducer as per the normal recommendation.

Note: Higher levels of AA-5656 will slow the drying time of PC-3320.

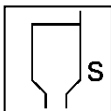
POTLIFE



3 hour at 25°C.

1 hour at 25°C. (when using PS-6080 Maxiglaze Accelerator Thinner)

SPRAY VISCOSITY



16 - 18 seconds (DIN 4) at 25°C.

SPRAYGUN SETTINGS (*GRAVITY*)



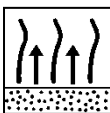
SETUP

1.2 - 1.4 mm

SPRAY PRESSURE

- HVLP / RP: 2-3 bar
- CONVENTIONAL: 30-45 PSI / 200-300 KPA

APPLICATION & FLASH OFF (*at 25°C*)



- COATS: Apply 1 medium followed by 1 full wet coat
- FLASH OFF BETWEEN COATS: 5 - 10 minutes
- SINGLE VISIT MODE - Apply 1 light coat followed directly by 1 full wet coat

BAKING TIME & TEMPERATURE



BAKE:

45 minutes at 60°C - Standard Mode

20 minutes at 60°C - Accelerated Mode

Note: Temperature shown is metal temperature

I.R.:

10 - 15 minutes - short wave (Slow Thinner Recommended)

Will vary depending upon equipment. Refer to equipment supplier

**NOTE: DO NOT use IR when using Accelerated mode*

TOTAL DRY FILM BUILD

50 - 60 µm

TOPCOAT / RECOAT

**TIME:**

Minimum of 8 hours after bake
Air dry overnight at 25°C

PREPARATION:

STARTLINE® P500 (dry) OR *Startline* P800 (wet)

DE-NIBBING & POLISHING (Recommended 1 hour cool down after bake)

Remove dirt if required using *Startline* P1500 grit (wet) abrasive, then cut & polish using your preferred products.

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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