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## 606 PARAGLAZE ACRYLIC URETHANE ENAMEL

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**DESCRIPTION** 606 PARAGLAZE ACRYLIC URETHANE ENAMEL is a premium quality two pack acrylic urethane enamel specifically designed for low bake oven curing, although it will air dry satisfactorily under normal conditions. It has been developed in Australia for maximum performance under Australian conditions with outstanding resistance to outdoor weathering and U.V. degradation.

606 PARAGLAZE ACRYLIC URETHANE ENAMEL is ideally suited for the repair and refinishing of all road transport vehicles including cars, trucks and buses, whenever a high quality finish is desired.

### **606 PARAGLAZE TINTING SYSTEM (SOLID COLOURS ONLY)**

This consists of a range of tinters based on the highest quality, light fast, automotive grade pigments. These tinters are carefully standardised and controlled to ensure uniformity in both tint strength and tone.

Colour mixing formulations for most vehicle manufacturer's solid colours encountered in Australia are available, dating back to 1965. The colour formulae range is consistently updated as new model colours are introduced.

606 CLEAR, MEDIUM SOLIDS CLEAR and HIGH SOLIDS CLEAR are available for the overcoating of 706 PARAGLAZE BASECOAT

**FEATURES** 606 PARAGLAZE ACRYLIC URETHANE ENAMEL exhibits the following outstanding properties:

- Ease of application
- Exceptionally high gloss and clarity of image
- Superior gloss retention
- Non yellowing
- Superior colour retention
- Outstanding resistance to weathering
- Excellent hardness and abrasion resistance
- Excellent solvent and chemical resistance
- Excellent water and humidity resistance

**SUITABLE SUBSTRATES** 606 PARAGLAZE ACRYLIC URETHANE ENAMEL is ideally suited for use over the following primers:

- 408 EPOTEC PRIMER
- 429 PARAPHOS PRIMER
- 443 PARAFILL PRIMER/FILLER
- 466 PARABUILD ICF PRIMER FILLER
- 472 RAPID EPOXY PRIMER SURFACER
- It can also be used over degreased and sanded baked enamel and 2 Pack enamel.



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### DRYING

#### AIR DRY

At normal ambient temperatures of 20 -25°C 606 PARAGLAZE ACRYLIC URETHANE ENAMEL (using Standard Hardener) will be:

- DUST FREE 30 minutes
- TOUCH DRY 2-3 hours
- HARD DRY 16 hours

Full cure will not be attained for at least 7 days.

**LOW BAKE:** Temperature referred to below is not booth air temperature but body metal temperature and using Standard Hardener.

	40°C	60°C
DUST FREE	10 minutes	5 minutes
TOUCH DRY	30 minutes	15 minutes
HARD DRY	60 minutes	30 minutes

### MIXING RATIO

Mix 2 parts by volume of 606 PARAGLAZE ACRYLIC URETHANE ENAMEL PACK A with 1 part by volume of 606 ACRYLIC URETHANE ENAMEL HARDENER PACK B

606 ACRYLIC URETHANE ENAMEL HARDENER PACK B may be any of the following and their specific ambient temperature use is detailed in the following table:

TEMP. °C	HARDENER	COMMENTS
< 10	606-9053 RAPID	PANEL REPAIR USE ONLY
10 - 15	606-9022 FAST	GENERAL PURPOSE USAGE
15 - 30	606-9309 STANDARD	GENERAL PURPOSE USAGE
15 - 30	606-9042 MEDIUM	USE ON LARGER AREAS e.g. BUSES
> 30	606-9220 SLOW	USE IN WARM CONDITIONS AND LARGE AREAS

- As a general rule, the larger the area to spray the slower the hardener to be used to improve overspray melt in.

### POT LIFE

Once 606 PARAGLAZE ACRYLIC URETHANE ENAMEL PACK A has been mixed with 606 PARAGLAZE ACRYLIC URETHANE ENAMEL HARDENER PACK B, the useable life of the mixed material is approximately 4-6 hours @ 25°C. Higher ambient temperatures may considerably reduce the pot life. If using RAPID HARDENER do not mix more paint than you will use in one hour. After that time do not use the mixed material.

### THINNING

For normal spray application,(clear and solid colours), thin the mixed material (2 parts by volume of Pack A and 1 part by volume of Pack B) with up to 15% by volume of R199 PARAGLAZE ACRYLIC URETHANE ENAMEL REDUCER. Optimum spraying viscosity is 18-21 seconds BS4 @ 25°C. 606 PARAGLAZE ACRYLIC URETHANE ENAMEL - HIGH SOLIDS CLEAR is ready for use after mixing with Hardener. Up to 5% R199 REDUCER may be added if required.



# TECHNICAL DATA SHEET

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**APPLICATION** Apply one mist coat followed by two medium full coats allowing 10 minutes flash off between coats.  
Spray gun setup:

CONVENTIONAL	Fluid Tip	Spray Pressure
Gravity Feed	1.4-1.6 mm	300 - 400 kPa
Suction Feed	1.5-1.8 mm	300 - 400 kPa

### HVLP – DeVILBISS - Gravity

Mixing Ratio	2 : 1 V/V
Thinner Ratio / Reducer	15%
Air Cap Number	105
Fluid Tip (mm)	1.4 – 1.6
Pressure at Air Cap	2 Bar / 29 psi
Paint Visc Flow Cup 25°C	16 – 18 sec
Distance from Object	180 – 210 mm

**SPREADING RATE** • 8 - 9 m<sup>2</sup>/Litre when applied as two medium full coats. A total dry film thickness of a minimum of 50 microns is recommended for maximum durability.

**POLISHING** • Defective areas may be sanded lightly and polished after 30 minutes low baking @ 60°C or 16 hours drying under normal ambient conditions.  
• Do NOT use coarse abrasive compounds.

**PACK SIZES** 606 PARAGLAZE PACK A MIXED COLOURS

- 4 Litres, 3 Litres, 2 Litres, 1 Litre

606 PARAGLAZE TINTERS

- 4 Litres, 1 Litre

606 PARAGLAZE HARDENER

- 1 Litre, 500 mL

### PRECAUTIONS

Avoid breathing vapour and contact with skin. Ensure all mixing and handling of hardener and paint containing hardener is carried out under working conditions that prevent skin contact or inhalation of vapour. Wear impervious gloves in a ventilated booth filled with an effective filtered exhaust system. Do NOT smoke whilst handling this material. Breathing of fumes or spray mist can cause sensitisation and asthma like reaction. Persons suffering from chronic respiratory problems should not use this product. Hardener is extremely sensitive to moisture and should be used as soon as possible after opening. Keep all containers thoroughly closed when not in use.



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### HEALTH AND SAFETY

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606 PARAGLAZE ACRYLIC URETHANE ENAMEL contains flammable solvents and must be kept away from heat and open flames. Do not smoke whilst handling this product. 606 PARAGLAZE ACRYLIC URETHANE HARDENER - PACK B also contains a maximum content of 0.3% volatile free Isocyanate. Avoid breathing the vapour and unnecessary skin contact. Breathing vapour, spray mist or dust from sanding is harmful and may cause lung irritation and asthma-like respiratory reaction. Keep containers thoroughly sealed when not in use. When spraying mixed material (Pack A to which Pack B has been added) the operator must wear a positive pressure air supplied full face respirator. The spray area must be isolated from other people whilst spraying is in progress and until all spray mist has been effectively dispersed. Spray in a booth fitted with an effective filtered exhaust system and comply to local regulations regarding spray painting.

### FIRST AID

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<b>Eyes</b>	If splashed in eyes, irrigate with copious amounts of clean water for 15 minutes. Seek medical aid if irritation persists.
<b>Skin</b>	If splashed on skin, wash affected area thoroughly with soap and water. If irritation persists seek medical aid. Remove all contaminated clothing and launder before re-use.
<b>Inhalation</b>	If affected by exposure to vapours, remove from area, keep at rest and seek medical aid if symptoms persist.
<b>Ingestion</b>	If swallowed, give glass of water to drink and seek medical assistance. <b>DO NOT</b> induce vomiting.

*Consult separate Material Safety Data Sheet for more detailed Health and Safety information.*