



TECHNICAL DATA SHEET

606 PARAGLAZE ACRYLIC URETHANE HARDENER STANDARD - GLASS ADDITIVE

Page 1/3
Revised: April 2008

DESCRIPTION

606 PARAGLAZE URETHANE HARDENER – STANDARD – GLASS ADDITIVE is a modified conventional 606 STANDARD hardener to which has been added a special “linking” additive that greatly increases the adhesion of the coating to glass surfaces, particularly when the coated glass is used under humid or damp conditions. The glass additive is incorporated by Protec during the hardener manufacturing process.

The hardener can be added to any 606 PARAGLAZE ACRYLIC URETHANE – PACK A colour in the 2:1 mixing ratio.

SUITABLE SUBSTRATES

Clean glass surfaces, firstly by use of a hard surface cleaner eg Ajax Spray and Wipe followed by a specialty glass cleaner eg Windex. Glass that is known to be surface treated will need to have the coating removed by chemical means. The success of the coating in field use is fully dependent on the thorough cleaning of the glass substrate. 606 PARAGLAZE ACRYLIC URETHANE HARDENER – STANDARD - GLASS ADDITIVE

Protec recommends that the air side of the glass be painted only. Painting the tin side can lead to system failures.

DRYING

AIR DRY: At normal ambient temperatures of 20 -25°C using 606 PARAGLAZE ACRYLIC URETHANE HARDENER – STANDARD - GLASS ADDITIVE 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.

	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 PARAGLAZE ACRYLIC URETHANE HARDENER – STANDARD - GLASS ADDITIVE.

POT LIFE

- Once 606 PARAGLAZE ACRYLIC URETHANE ENAMEL – PACK A has been mixed with 606 PARAGLAZE ACRYLIC URETHANE HARDENER – STANDARD - GLASS ADDITIVE the useable life of the mixed material is approximately 3 - 4 hours @ 25°C.
- Higher ambient temperatures may considerably reduce the pot life.



TECHNICAL DATA SHEET

606 PARAGLAZE ACRYLIC URETHANE HARDENER STANDARD - GLASS ADDITIVE

Page 2/3
Revised: April 2008

THINNING For normal spray application, thin the mixed material (2 parts by volume of Pack A and 1 part by volume of Pack B) with up to 20% by volume of R199 ACRYLIC URETHANE ENAMEL REDUCER. Optimum spraying viscosity is 16-18 seconds BS4 @ 25°C.

APPLICATION Apply one mist coat followed by two medium full coats allowing 10 minutes flash off between coats.

Spray gun setup:

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

SPREADING RATE 8 - 9 m²/Litre when applied as two medium full coats.

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 HARDENER – STANDARD – PACK B - 1 Litre

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.

HEALTH AND SAFETY

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 - STANDARD - 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.



TECHNICAL DATA SHEET

606 PARAGLAZE ACRYLIC URETHANE HARDENER STANDARD - GLASS ADDITIVE

Page 3/3
Revised: April 2008

FIRST AID

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

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