



# TECHNICAL DATA SHEET

**PP-3860**

**PARAGLAZE  
PRIME & FILL**

## PRODUCTS

Paraglaze Prime & Fill	PP-3860
Paraglaze Hardeners	PH-4100 or PH-4200
Paraglaze Reducers	PS-6100 or PS-6200 or PS-6300

## PRODUCT DESCRIPTION

Paraglaze Prime & Fill is a two pack acrylic urethane quick drying high build primer designed for use where a high build is required over repair areas. It is recommended for use under Protec 606 line acrylic urethane enamels & 706 line Paraglaze basecoat. Prime & Fill can also be used as a primer surfacer, it offers excellent film build, sanding and gloss holdout. For large areas of bare metal use Protec Etch or Epoxy Primer under Prime & Fill. This product can be tinted with 606 line solid colour tinters up to a maximum of 10%.

## SUBSTRATES & PREPARATION



Fully cured 2 pack refinish coatings that have been degreased and sanded.

Sound Automotive OEM coatings that have been degreased and sanded.

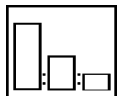
Small areas of bare metal that have been degreased and sanded.

Electrocoated new panels that have been degreased and sanded.

GRP Fibreglass that has been degreased and sanded.

**Large areas of bare metal and areas where polyester body filler will be applied should be coated first with Protec Epoxy Primer AP-4110.**

## MIXING RATIO BY VOLUME

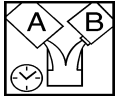


PRODUCT	PARTS
PP-3860	4
PH-4100 or PH-4200	1
PS-6100 or PS-6200 or PS-6300	10-30%

**If tinting: Add up to 10% of 606 line tinter before adding hardener**

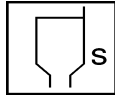
**If using as a primer surfacer thin at 30%**

## POTLIFE



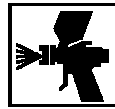
1 hour at 20°C

## SPRAY VISCOSITY @ 20°C



19-24 Seconds (DIN4)

## SPRAYGUN SETUP



1.6mm - 1.8mm

## SPRAY PRESSURE

HVLP / RP

2 – 3 bar

CONVENTIONAL

45 – 55 PSI / 300-380 KPA

## NUMBER OF COATS & FLASH OFF

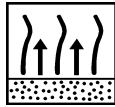


**1st coat**

Flash off

**Apply an even medium coat**

5 Minutes at 20c



**2nd coat**

Flash off

**Apply an even wet coat**

5 Minutes at 20c

**3rd coat**

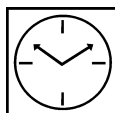
**Apply an even wet coat**

## DRYING TIMES



**Bake Temperature**

65°C



**Bake Time**

40 Minutes

**IR Time**

12-15 Minutes (short wave)

**Air Dry Time**

Air dry overnight at 20c

Temperature shown is metal temperature

## TOTAL DRY FILM BUILD

150 - 180 um

## SANDING DRY



Finish with no coarser than P500 Dry

## SANDING WET

Finish with no coarser than P800 Wet

## OVERCOAT WITH

Paraglaze Prime & Fill can be topcoated with Protec 606 line acrylic urethane enamels & 706 line Paraglaze basecoat. **Note: This product must be topcoated within 72 hours. The vehicle must be kept dry and free of moisture and contaminants during this period.**

## EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

## HEALTH AND SAFETY

**Please refer to Material Safety Data Sheets for full Health and Safety details.**

Paraglaze Hardeners and activated products contain isocyanate and therefore particular safety precautions must be taken.

Goggles must be worn when mixing and using to prevent accidental splashing into the eye. If contact occurs with eyes give prolonged irrigation with water and get medical attention immediately.

Good ventilation and extraction must be provided in the working environment.

Wear suitable protective equipment to prevent skin contact with this material.

When spraying this product the operator (and persons in vicinity) must wear suitable air-fed breathing apparatus. Do not smoke whilst using this material.

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 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 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times.

Before using refer to Material Safety Data Sheet obtainable from Protec Pty Ltd.

Follow all directions and warnings fully and carefully. Otherwise do not use this product

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