Commercial Performance Coatings

TECHNICAL DATA SHEET

PAR PARALOC

PRODUCT DESCRIPTION

A single pack fast drying beige etch primer which has outstanding adhesion to all metal surfaces including aluminium. Unlike conventional etch primers which can only be applied in extremely thin coats, PAR Paraloc can be applied in heavier coats like a normal primer and exhibits good build and holdout.

PRODUCTS

Primer		PAR Paraloc Beige RFU	PAR-5535
		PAR Paraloc Beige	PAR-5439
		PAR Paraloc HP Black	PAR-N61
Reducers	(If Necessary)	EPR20 Etch Primer Reducer Normal	
Cleaners		AA-6822 PROTEC® Heavy Duty Wax & Grease Remover	

SUBSTRATES & PREPARATION

Commercial Performance Coatings PAR Paraloc can be applied over the following substrates once they have been prepared as follows:

SUBSTRATE	PREPARATION
Bare Steel	STARTLINE® P150 - dry
Phosphated Steel	*Startline* Scourer
Galvanized Steel	*Startline* Scourer
Stainless Steel	*Startline* P280-P320 - dry
Brass	*Startline* P280-P320 - dry
Aluminium	*Startline* Scourer

Bare Aluminium surfaces should be thoroughly cleaned using AA-6822 *Protec* Heavy Duty Wax & Grease Remover before sanding. Use a high grade scouring pad to remove heavy areas of grease and imperfections in a wipe on, wipe off motion using clean rags.

Once dry, thoroughly abrade the surface using *Startline* P240 or P320.

Once sanded, the aluminium should be blown down and cleaned with SWX250 One choice Water Methylated Spirits, using a wipe on, wipe off motion. This must be repeated until no residue shows on the cleaning cloths.

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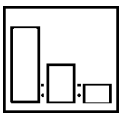
NOTE: The prepared aluminium must be primed within six hours of the preparation process. Failure to do so will allow the aluminium to re-oxidise.

Not recommended for use on abrasively blasted surfaces.

Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Wax & Grease Remover to remove all traces of dirt, oil, grease, silicone, wax etc.

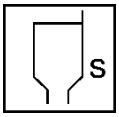
Substrates other than those stated above should be tested before use, to ensure that the performance of this product is suitable for its intended use.

MIXING RATIO BY VOLUME



PRODUCT	PARTS	
PAR Paraloc	100 parts	
Reducer	Up to 30%	*Thinning PAR-5535 RFU is not necessary*

SPRAY VISCOSITY



20 - 25 seconds (DIN 4) at 25°C

SPRAYGUN

CONVENTIONAL, HVLP

SETUP

• GRAVITY	1.4 mm - 1.8 mm
• SUCTION	1.4 mm - 1.6 mm

SPRAY PRESSURE

• CONVENTIONAL	3.5 - 4.5 bar (350 - 450 kPa, 45 - 65 psi)
• HVLP / RP	2 - 3 bar

APPLICATION & FLASH OFF

Apply 1 - 2 wet, even coats

Allow 3 - 10 minutes flash off between coats at 25°C

Note: Do not apply at temperatures less than 10°C, when the relative humidity exceeds 80%, or if the surface temperature is within 3°C of the dew point.

DRYING TIMES

AIR DRY (25°C)

- TOUCH DRY: 5-10 minutes
- DRY TO HANDLE: 30 minutes

Note: Drying times can vary dependent on temperature, flash off between coats, film builds and number of coats applied.

RECOAT

Allow 30 minutes drying time before recoating, longer periods apply for colder temperatures.
Can be re-coated in both 1K and 2K CPC Topcoats.

TOTAL DRY FILM BUILD

15 - 20 µm

TECHNICAL PARAMETERS

VOLUME SOLIDS (RFU)	17%
COVERAGE	8.5 m²/L @ 20µm Dry film thickness

EQUIPMENT CLEANING

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

HEALTH AND SAFETY

Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

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.

PPG Industries Australia Pty Ltd, 14 McNaughton Rd
Clayton, VIC 3168 Australia

EMERGENCY RESPONSE NUMBER, Australia: 1800 883 254

PPG Industries New Zealand Pty Ltd, 5 Vestey Dr, Mt Wellington
Auckland, New Zealand

EMERGENCY RESPONSE NUMBER, New Zealand: 0800 000 096