

Clear Coat – Mixing and Application (Commercial Kit 3.75L “Mixed product”)

Mixing of Clear Coat (below guidelines to be strictly adhered to):

- a) **Part A (Base) containing 2.55Ltr:**
 - Remove the lid of the can and stir well (ensure homogeneous texture)
- b) **Part B (hardner) containing 0.7Ltr:**
 - Remove the lid of the can and pour the hardner into the base
- c) Stir thoroughly and until homogeneous using the mechanical mixing tool (or stirring stick) provided

Roller and brush application:

Add approx. 15% (500 ml) of clean water in three steps.

- d) Add approximately one-third (165ml) of the water at a time, stirring for approximately 30 seconds between each addition. (Total of 500 ml “Do not exceed recommended total water addition”)
- e) Mixture must be fully homogeneous, without streaks or separation
- f) Let it rest for two minutes before application

Spray application:

Add approx. 20% (650 ml) of clean water in three steps.

- g) Add approximately one-third (215ml) of the water at a time, stirring for approximately 30 seconds between each addition. (Total of 650 ml “Do not exceed recommended total water addition”)
- h) Mixture must be fully homogeneous, without streaks or separation
- i) Let it rest for two minutes before application

Note - Mixing less than the full kit:

- Mixing ratio by volume 3.65 : 1 (3.65 parts A-base, to 1 part B-hardner) using a paint mixing cup or similar for mixing
- Mixing ratio by weight 77.5 : 22.5 (77.5 parts A-base, to 22.5 part B-hardner)
- Add Water:
 - For roller and brush application: add approx. 10-15% of clean water in three steps (follow step d-f)
 - For spray application: add 15-20% of clean water in three steps (follow step g-i)

Important before application:

Surface/metal temperature must be at least 3 °C above dew point

Relative humidity (RH): 40–85% is acceptable

(For guidance regarding application conditions and methods, please consult the PGX-Best-Practice-guide, section 1 thru 6.)

Application by Roller:

Clear coat: apply 1 layer of approx. WFT 3.9-4.3 mils (100-110µm)

- Roll in thin, even coats and avoid excessive back-rolling

Application by Brush:

Clear coat: apply 1 layer of approx. WFT 3.9-4.3 mils (100-110µm)

- Brush in thin, even coats and avoid excessive back-rolling

Application by Spray:

Clear coat: apply 1 layer of approx. WFT 3.9-4.3 mils (100-110µm)

- Apply in cross-coats where possible to ensure even film build

Note: If time permits, apply a second Clear coat for maximum durability, following the steps above.

Overcoating interval between coats:

@ 25–30 °C and 40–85 % relative humidity the following guidance is appropriate and conservative for professional use.

Minimum drying/recoat time between coats: 2-4 hours (Ideal 4 hours)

The underlying coat must be:

- ✓ Surface dry
- ✓ Non-tacky to the touch
- ✓ Able to withstand light finger pressure without marking

Maximum Recoat Window is Typically 24 hours (@ 20°C)

If exceeded: Light sanding (e.g. P240–P320) is recommended before recoating

Once the Clear Coat (finishing layer) has been applied, the coating will be sufficiently cured for water immersion after approximately 24-36 hours (ideal 48 hours) under normal application conditions. **For guidance regarding application conditions and methods, please consult the PGX-Best-Practice-sheet, section 1 thru 6.** At this stage, the coating has achieved adequate film formation and adhesion to allow safe launching into the water. Full chemical cure continues under water and is typically achieved after 7 days, depending on temperature and environmental conditions.

During the first 24 hours, the coating must be protected from mechanical damage, standing water, and condensation. Once immersed, normal service exposure is permitted while final cure progresses.