POR-15® Restoration Products

POR-15 GLISTEN PC CLEAR COAT

Application Information

Please read and understand these instructions thoroughly. Failure to do so can result in premature coating failure.

PRODUCT DESCRIPTION
Glisten PC is a high performance, high-gloss, rock-hard, water-clear topcoat, designed for spray or brush application over most metal and painted surfaces, including highly polished aluminum and chrome surfaces. Glisten PC will not leave brushmarks when properly applied and will take 3 to 4 days to reach maximum hardness. When Glisten PC is first dry to the touch, it appears very soft. Avoid touching it for several days until it becomes hard and tough. Accidental contact could damage the surface before full cure has taken place. Like many other POR-15 coatings, Glisten PC is a moisture-cured coating, which means it is strengthened by exposure to moisture.

PRODUCT COMPOSITION
Your Glisten PC purchase consists of 2 items: 1) A paint can, labeled Glisten PC, which is the basic clearcoat formulation, and 2) A smaller can, labeled Hardener/Activator. Mix the two products together, following directions on the can, by blending them in a separate, resealable clean container. A clean glass jar works best. Stir the combined contents thoroughly to get a complete mix, which will allow the two components to blend and the molecules to link together properly.

WARNING: your can of Hardener/Activator is sealed tightly. Remove lid carefully,and cover it with a paper towel while prying it off to avoid accidental spillage or splash. Your Hardener/Activator and resin is very sensitive to moisture and humidity, so try to open it in a dry area. Keep your resin and hardener tightly capped as soon as you have finished mixing; this is very important.

PARTIAL MIXED
You may mix partial quantities of Glisten PC for small jobs, and you may use any measuring device you happen to have around (coffee scoop, measuring spoons, cups, etc.). All you have to do is follow this formula: mix 1 part Hardener/Activator with 3 parts Glisten PC. You may use it as soon as it is thoroughly mixed with the Hardener/Activator. Glisten PC can remain usable for up to 3 to 4 hours if the lid is kept on the mixed batch when not in use. Mix only what you need for the job, and if you need more, just repeat the mixing procedure.

SURFACE PREPARATION
If the surface to be coated is freshly polished, that is to say, just a few hours old, then go straight to the directions for polished metals. If the existing clear coat is badly damaged and is oxidizing (coating is flaky, yellowing, and generally breaking down), the best method is to remove all old coatings and re-polish to the desired luster. If the existing coating is largely intact, not yellowing or breaking down, polish the damaged area and burnish the rest of the coating with fine sandpaper or pad (1200 grade), or a rubbing compound, which is available at most automotive paint stores. The surface can now be treated the same as a freshly polished surface. To coat polished metals, such as aluminum, brass, copper, chrome, nickel, and silver, if the surface has not been polished within 24 hours, it should be buffed or polished to remove any surface oxidation which may have occurred. The use of a polishing compound is advisable, not just a quick wipe with a clean rag. NOTE: if this step is missed, coating adhesion will be substantially less.

AP 120 METAL PREP: THE KEY TO PERFECT ADHESION
Now that you've prepared and cleaned the surface, one step remains to ensure you'll achieve perfect adhesion. That involves using AP 120 Metal Prep, essential when attempting to coat a highly polished surface with Glisten PC. You may use a brush or sprayer or foaming gun. All metals should be at room temperature. Never attempt to use AP 120 outside in hot weather or in direct sunlight. AP 120 is a ready-to-use liquid. Apply it to metal surfaces for exactly 2 minutes no longer, using a non abrasive cleaning pad, then rinse well with water and dry. Avoid hard water where possible. Surface to be coated must be bone-dry before painting. Use of a heat gun on castings is advisable, especially in colder climates, to dry out the pores in the metal and insure the elimination of all moisture before painting.

WOODEN SURFACES
Wooden surfaces should be smooth and dry with the wood having a low moisture content. All existing failed coatings should be removed. Apply a single covering coat to seal the wood and allow to dry (24hours).The wood will generally need to be sanded smooth again because wood tends to pickle (small pieces of wood lifting up in contact with coatings) with the first coat. Sand smooth with fine grade of sand paper (280-320). Apply a further 2-3 coats for general applications, marine applications, and industrial users.

PAINTED SURFACES
Generally requires little preparation simply clean with one part Marine Clean to 10 parts of water for light contamination and cut with fine finishing compound, clean and paint.

OTHER METALLIC AND NON METALLIC SURFACES
Including Steel, Cast Iron, Tin, Zinc, Lead, Plastics and Rubber. In many instances these surfaces can be painted, but special surface preparation may be needed. You may need to call for advice on how to proceed.

APPLICATION

Apply 2-3 medium coats for general, automotive, and marine use. Note, one medium coat is approx 1.5 mills (40um). Glisten PC may be applied with any type of brush. It can also be rolled. It will flow out immediately, eliminating brush marks. Lay down a medium covering coat. Be careful to avoid runs. Second coat of Glisten PC can be applied at a minimum of 6 to 8 hours and maximum 24 hours. After 24 hours Glisten should be lightly sanded with 320 grit sand paper or red Scotch Brite pad. Glisten PC will need aprox. 3 days to fully cure.

Thin 10-20% only with Xylene (Xylol), if required. Xylene or lacquer thinner may be used for cleanup. You can thin Glisten PC up to 30%, though if you do you'll need to apply more coats to retain dry film thickness. **NOTE**: when brushing a 2nd or 3rd coat, there may be surface tension created between coats which could cause an irregular surface. Thinning the 2nd or 3rd coat slightly reduces surface tension and allows Glisten PC to drop and flow out well. For best results, apply in temps of 65^{0}F to 75^{0}F (18^{0}C - 24^{0}C) with less than 70% humidity.

IMPORTANT NOTE: Though your finish may be dry to the touch in an hour or two, it will not be fully cured for at least 72 to 96 hours (3 to 4 days). Consequently, you should plan in advance on how to protect the surface from dust. Clean plastic sheeting is good for this job, but don't allow the sheeting to touch your painted surface.

SPRAY PAINTING / SPRAY BOOTHS: Your spraying area should be dust free and clean, with the appropriate exhaust equipment in place where applicable. Recommended pressures; High pressure guns 50 - 70 psi (344-482 Kpa), and HVLP guns 30 - 40 psi (206-275 Kpa), but your own experience will quickly lead you to the proper adjustment. A POR-15 Moisture and Oils disposable filter should be used when spraying Glisten PC, as trace oils or moisture through your spraygun can ruin your job. Thin 10% to 20% if required. Avoid temperatures over 83^{0}F (28^{0}C) where possible. The best recommended spray booth temperature is 72^{0}F (22^{0}C) with 50% humidity, low air flow. Remember, thinning rates are a guide only; you must also consider the type of gun, the air temperature, and humidity.

Glisten PC can be cut with regular compounds if you have a run or imperfections, but it is best to leave it for a week or two before cutting to make sure the coating is hard (runs may take longer to fully cure due to their added thickness). **Note:** if you are unfamiliar with Glisten PC or spraying clearcoats, do not attempt to spray a large item first, but rather mix up a small amount and test what you are trying to achieve in a small area first.

Always remember that Glisten PC will not perform as specified until it has cured for a minimum of four (4) days at an average temperature of no less than 65^{0}F (18^{0}C). Do not put alloy wheels, engine parts, or the like into service before the four (4) day cure time is up. Raising temperatures will not speed up the cure time.

HUMIDITY CONTROL

Humidity should be 60% or lower when spraying Glisten PC because the higher humidity may cause it to set up too quickly before it has a chance to flow out evenly, and this could result in a wavy appearance. This is especially true in high-humidity southern climates during the summer. Whenever possible, spray in a humidity-controlled (air conditioned) environment. Best temperature range is 65^{0}F - 75^{0}F (18^{0}C - 24^{0}C). If this is not possible, apply Glisten PC in the morning when temperatures are at their lowest. Glisten can be successfully applied in higher humidity, but temperatures must be below 77^{0}F (25^{0}C). In temperatures over 86^{0}F (30^{0}C), the humidity must be low. Avoid high humidity and high temperatures.

WARNINGS / CAUTIONS

Before opening cans (Glisten PC and Hardener/Activator), please read all warning labels and precautions, including those on the separate sheet. If you are unfamiliar with Glisten PC or spraying clearcoats, don't attempt to spray a large area first, but rather mix up a small amount and test what you are trying to achieve in a small area first. Avoid prolonged contact with skin and breathing of vapor mist.

Use only with adequate ventilation. Use an organic vapor particulate respirator, NIOSH/MSHA approved, when brushing, and a positive pressure air-supplied respirator (TC 23C NIOSH/MSHA) when spraying and until vapors have cleared from work area. Do not breathe vapor mist. Do not get into eyes or on skin. Use of protective goggles is recommended. Individuals with chronic respiratory problems or prior respiratory reactions to isocyanates must not be exposed to mists or vapors containing isocyanates. **FLAMMABLE: KEEP AWAY FROM OPEN FLAME**. Do not take internally. FIRST AID: if affected by inhalation of vapor or mist, remove to fresh air. If breathing difficulty persists, consult physician and have label information available. **EYE CONTACT**: flush with water for 15 minutes and call physician. **SKIN CONTACT**: wash with soap and water. If swallowed, **DO NOT INDUCE VOMITING. KEEP OUT OF THE REACH OF CHILDREN.**

IDEAL USES FOR GLISTEN PC: As a protective coating on aluminum wheels, chrome bumpers, marine railings, chrome or aluminum covers, grills, handles, ornaments, lights, aluminum wood, bumpers, alloy boats, alloy panels,Industral uses include areas of chemical attack, UV protection and abrasion protection etc.

Please remember these instructions are general guide lines only and cannot and do not cover every application and environment. If you remain unsure as how to proceed, please call toll-free for technical advice at 800-457-6715.