



POLISHED ALLOY RESTORATION KIT

Application Information

Warning: Please read and understand these instructions Thoroughly, failure to do so can result in premature coating failure and/or a big mess!

You have purchased the finest products available for coating polished metal surfaces. Please read and follow our directions carefully and you will be rewarded with a perfect job. The components of this kit are designed to work together or individually, depending on the condition of the surface to be coated. The following is a brief description of each product.

IDEAL USES FOR GLISTEN PC

As a protective coating on aluminium wheels, chrome bumpers; marine railings; chrome or aluminium covers; grills; handles; ornaments; lights; aluminium bumpers, alloy boats, alloy panels etc.

KIT COMPONENTS:

- **AP120:** AP120 is a water soluble alkaline cleaner / brightener.
- **POR 15 Solvent** is compatible with all POR 15 coatings, and is to be used for thinning the Glisten PC and for prepping the surface.
- **Polish:** To polish the surface to be coated.
- **Gloves & Brushes:** Always wear gloves when using these products. Give the brush a good flick or two before using.
- **Glisten PC:** Is a high-gloss, rock hard, water-clear topcoat designed for spray or brush application over all metal surfaces, including *highly polished aluminium and chrome surfaces*.

Your Glisten PC consists of two items:

- 1 can of clear coat formulation, Glisten PC
- 1 smaller can labelled Hardener/Activator.

Mix the two products together by blending in a separate resealable clean container, a clean glass jar works best. Stir the combined contents thoroughly. This will allow the two components to blend and the molecules to link together properly.

- **Mix: 1 part Hardener/Activator with 3 parts GlistenPC**
Glisten PC can remain useable for up to 2 – 3 hours if the lid is kept on the mixed batch when not in use.

Partial Mixes:

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:

Warning:

Your can of Hardener/Activator is sealed tightly. Remove lid carefully, cover with a paper towel while prying it off to avoid accidental spillage or splash.

- Your Hardener/Activator is very sensitive to moisture and humidity, so try to open it in a dry area. Keep your resin and hardener tightly capped when not in use – this is very important.

Glisten PC will not leave brush marks, but avoid bubbles when brushing and will dry in less than 1 hour, but will take 3 or 4 days to reach maximum hardness.

When Glisten PC is first dry to the touch, it will appear very soft. Avoid touching it for several days until the surface 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. It won't crack, chip, peel or yellow and is flexible.

SURFACE PREPARATION:

- **Freshly Polished Surface:** If the surface to be coated is freshly polished - (ie. just a few hours old), then go straight to the directions for polished metals.
- **Damaged Surface:** If the existing clear coat is badly damaged and oxidising eg. coating is flaky, yellowing, and generally braking down the best method is to remove all old coatings and repolish to desired lustre.
- **Existing Coating:** 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 paper or pad (1200 grade) or rubbing compound, which is available at most automotive paint stores. The surface can now be treated the same as a freshly polished surface.

AP 120 APPLICATION:

- If the item is chemically cleaned with AP 120 there will be a much higher adhesion level. (Generally 30%–40% improvement.). **AP 120** is a ready to use formulation, simply apply to aluminium surfaces either polished or new extruded for 1 minute.
- **Do not allow AP 120 to dry on. Rinse well with plenty of clean water.** This is important. Avoid hard water where possible. **Buff with dry clean cloth**
- Surfaces to be coated must be bone dry before painting. Use of a heat gun on castings is advisable and in colder climates to speed up the drying times. *Moisture left in pores will come back as corrosive bubbles.*
- AP120 can be applied by brush or sprayer.
- **Aluminium** and other metals must be at room temperature, eg. do not use outside in hot weather or in direct sunlight.
- **Testing:** It is advisable to test a small area first.

POLISHED METALS, INCLUDING ALUMINIUM, BRASS, COPPER, CHROME, NICKLE AND SILVER.

- This method is recommended in high abrasion / impact areas like Wheels, Bullbars, Fuel Tanks, Motorcycle covers and the like.
- If the surface has not been polished within the last few hours it should have a quick buff or polish to remove any surface oxidation that 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.
- Wipe surface down to be coated with POR 15 Solvent. This will remove 90% of surface contamination.

NEW / UNPOLISHED EXTRUDED ALUMINIUM:

- The use of **AP120** is ideal here, simply follow the instructions for **AP120** and apply Glisten PC.

OLD/ HEAVILY OXIDED ALUMINIUM / STAINLESS STEEL:

- Again the trick here is to remove the oxides from the surface.
- Best method is an acid wash or repolish.
- Rinse well with water. Generally the use of acid wash is for experienced/professional users only. This method is also recommended where very high level of adhesion is required, eg. **Stainless Steel**. It can then be solvent wiped and painted or acid washed for higher adhesion.



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POLISHED BRASS:

- Surfaces should be freshly polished.
- Then wiped down with **POR 15 Solvent**, and painted. This method is generally fine for taps, hand rail, fixtures and fittings. For items requiring high adhesion the use of **AP120** is recommended.

PAINTED SURFACES:

- Clean surfaces with good quality wax and grease remover or **Marine Clean**.
- Key surface to be painted with 1200 wet dry or rubbing compound. Remove all compounds, dust and contaminants with new tack cloth or **VERY** clean rag.

WOOD SURFACES

- Because of Glisten PC's low surface tension some soft woods will need a sanding sealer applied first.
- Then lightly sand the sealer.
- Apply **Glisten PC**.
- **General applications:** 3-4 coats minimum.
- **Marine Applications :** 4-7 coats minimum.

BRUSHING AND ROLLING:

- **Glisten PC** may be applied with any type of brush. It can also be rolled. It will flow out immediately, eliminating brush marks. Avoid brush bubbles.
- Lay down a medium covering coat, but be careful to avoid runs.
- A **second coat** may be applied when touch dry, usually 15 - 25 minutes later at 20deg C.
- The **second or subsequent coats** may be left up to 2 days before recoating without sanding.
- **Thinning:**
- Thin only with **POR 15 Solvent**, if required. .
- You can thin up to 30%, though you will need more coats to retain dry film thickness.
- Note, when applying a second or third coat there can be alot of surface tension between coats. Some solvent maybe needed to be added to reduce the coating surface tension to allow it to drop and flow out.
- For best results apply at 18-24°C and less than 70% humidity.
- POR 15 Solvent or lacquer thinners may be used for clean up

CURING:

- **IMPORTANT NOTE:** Though your finish may be dry to the touch in an hour or two. It will not be fully cured. After 72 hours you may begin to handle it gently with care.
- **Note:** it is vital that you cover your freshly sprayed piece after spraying to keep dust and moisture from the surface. Clean plastic sheeting is good for this job – do not allow sheeting to touch your painted surface!
- Remember Glisten PC will not perform as specified until it has cured for a minimum of 4 days, at an average temperature of no less than 18°C, eg. do not put alloy wheels, engine parts and the like into service before the 4 day cure time.

Elevated temperatures will not speed up cure.

SPRAY PAINTING:

- Your spraying area should be dust free and clean with the appropriate exhaust equipment in place were applicable.
- High Pressure Guns 50 - 70 psi, HVLP guns 30 - 40 psi, but your own experience will quickly lead you to the proper adjustment.
- A Moisture and Oils disposable filter should be used when spraying Glisten, as trace oils or moisture through your spray gun can ruin your job.
- **Thinning:** 20–50% if required.
- Avoid temperatures over 28°C were possible.

Humidity Control when spraying Glisten PC.

- 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, thus resulting in a wavy appearance. This is especially true in high-humidity northern climates in summertime. Whenever possible, spray in a humidity-controlled (air conditioned) environment. Best temperature 18°C - 24°C. If this is not possible apply Glisten PC in the morning when temperatures are at their lowest. Glisten PC can be applied successfully in higher humidity, but temperatures must be below 25°C. In temperatures over 30°C the humidity must be low. Avoid high humidity and high temperatures.

Spray Booth: Best temperature 22°C, 50% humidity, low air flow. Remember thinning rates are a guide only, consider also the type of gun, air temperature and humidity.

CUTTING:

- Glisten PC can be cut with regular compounds if you have a run or imperfections, though it is best if you leave it for a week or 2 before cutting to make sure coating is hard (runs may take longer to fully cure due to added thickness).

If you are unfamiliar with Glisten PC or spraying clear coats, do not try to paint a large item first, we strongly recommend that you mix up a small amount and test what you are trying to achieve in a small area first

**REMEMBER POOR PREPARATION = POOR ADHESION
DO IT ONCE - DO IT RIGHT!**

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