Technical data sheet

PROTECT 366

Anti-corrosion epoxy primer

Thick epoxy anti-corrosion primer hardened with amine adduct

RELATED PRODUCTS

H5966	Epoxy primer hardener
THIN 60	Epoxy thinner

USE:

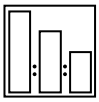
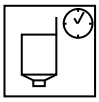
- Means of transport
- Machines and equipment
- Outer surfaces of tanks
- Steel structures

PROPERTIES

- Perfect insulation properties
- Possibility of the application up to 300 µm wet in a single layer
- Application of thick layers is possible
- Perfect hiding power and flowability
- Very good chemical resistance
- Very good mechanical resistance

PROTECT 366

Technical data sheet
2018/10/31

SUBSTRATES				
Steel	Clean steel surfaces until reaching Sa 21/2 (wet blasting) or St3 (manual cleaning or using a power tool) in accordance with the PN-ISO 12944-4 standard; the surface after the treatment must be free from oil, grease, dust, loose old paint coating, mill scale, rust and foreign contaminants; the surface should exhibit the gloss of the metal substrate.			
Old paint coatings	Degrease and dry sand paper P220 – 360.			
Polyester putties	Dry sand, for final sanding P240 ÷ P320.			
Galvanised steel, Aluminium	In order to produce a coarse substrate, use light abrasive blasting with round non-metallic abrasive grains or sand with P240 to P320 and then degrease.			
Stainless steel	Degrease and mat with sand paper P240 – 320. Degrease again.			
Polyester laminates	Dry sand P280, degrease again.			
MIXING RATIO				
		Volume ratio	Weight ratio	
	PROTECT 366 H5966 THIN 60	4 1 10% (20%)	100 15 6 (12)	
	Apply the thinner in the amount calculated for the primer.			
VISCOSITY				
	DIN 4/20 °C	4 + 1 + 10% 4 + 1 + 20%	45 – 55s 20 – 30s	
APPLICATION				
 **CAUTION:** Instructions of the equipment manufacturer must be followed.		Nozzle	Pressure	Distance
	Pneumatic spraying	1.6 ÷ 2.0 mm	3 ÷ 4 bar	15 ÷ 20 cm
	Airless spraying in air jacket	0.33 ÷ 0.38 mm (0.013" ÷ 0.015 ")	100 ÷ 140 bar Air jacket 2 bar	10 ÷ 15 cm
	Number of layers	1 – 2		
	CAUTION: The minimum epoxy primer thickness is 80 µm on steel substrates.			
	Single dry layer thickness.	80 µm		
	Yield of the ready to apply mixture for a dry layer thickness in the provided range	approx. 7.8 m^2/l 0.13 l/ m^2 at 80 µm PROTECT 366 + H5966 (4+1)		
	The actual yield depends on the surface shape, roughness and application parameters.			

PROTECT 366

Technical data sheet
2018/10/31

	Mixture life at 20°C	2 hours
	Flash off between layers	10 ÷ 15 min.

CURING TIME

	Time to sand. For the max. dry coating thickness of 130 µm.	10°C	20°C	60°C
		48 hours	24 hours	45 min.

SANDING

	Dry sanding	P240 ÷ P500

COATABILITY

Topcoat application time for a 80 µm thick primer.	10°C	20°C	60°C
	4 hours	45 min.	30 min.

Coatable by all NOVOL topcoats. The maximum coating time without mating is 48 h.

TECHNICAL DATA

Product	Solids content by weight	Solids content by volume	Density	Fineness of grind
PROTECT 366	≈ 78 %	≈ 59 %	≈ 1.68 g/cm^3	< 25µm
H5966	≈ 68%	≈ 66%	≈ 0.92 g/cm^3	——
PROTECT 366 + H5966 (4+1)	≈ 77,5%	≈ 62%	≈ 1.53 g/cm^3	< 25µm

CONTENT OF VOLATILE ORGANIC COMPOUNDS

VOC II/B/c limit*	540 g/l
Actual VOC content	380 g/l (for 4+1) 470 g/l (for 4+1 + 20% THIN 60)

* For the ready to apply mixture compliant with Directive UE 2004/42/CE

COLOUR MATCHING

Not recommended.

APPLICATION CONDITIONS

The coated surface should be dry. The temperature of the coat, coated surface and environment should be between +10°C and +35°C at a maximum relative humidity of 80%.
The coated surface temperature should exceed the dew point by a minimum of 3°C.

TEMPERATURE RESISTANCE	
The operating temperature of the applied primer is between -60ºC and +80ºC. Transient temperatures up to +120°C maximum are permitted.	
COLOUR	
Grey.	
EQUIPMENT CLEANING	
THIN 60 epoxy thinner.	
STORAGE CONDITIONS	
Store in a dry room, away from sources of flame and heat. Avoid direct exposure to sunlight. Recommended storage temperature: +5°C to +35°C.	
SHELF LIFE	
PROTECT 366	24 months/20 °C
H5966	24 months/20 °C
THIN 60	24 months/20 °C
SAFETY	
See Safety Data Sheet.	
OTHER INFORMATIONS	
Registration number: 000024104. The effectiveness of our systems results from laboratory research and many years of experience. The data contained herein meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to do a test application of the product due to its potentially different reaction with different materials. We may not be held liable for defects if the final result was affected by factors beyond our control.	