

Technical data sheet

PROTECT 365 TIX

Anti-corrosion epoxy primer

Thick epoxy anti-corrosion primer hardened with amine adduct

RELATED PRODUCTS

H5960 STANDARD

Epoxy primer hardener standard

H5960 FAST

Epoxy primer hardener fast

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 of thick layers up to 350 μm wet in a single layer
 - Perfect hiding power and flowability
 - Very good chemical resistance
 - Very good mechanical resistance

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 365 TIX	4	100	
	H5960 STANDARD	1	16	
	THIN 60	25%	14	
	PROTECT 365 TIX	4	100	
H5960 FAST	1	16		
THIN 60	15%	8		
Apply the thinner in the amount calculated for the primer.				
VISCOSITY				
	DIN 6/20 °C	15 ÷ 20s		
APPLICATION				
 <p>CAUTION: Instructions of the equipment manufacturer must be followed.</p>		Nozzle	Pressure	Distance
	Pneumatic spraying	1.8 ÷ 2.2 mm	3 ÷ 4 bar	15 ÷ 20 cm
Airless spraying in air jacket	0.38 ÷ 0.43 mm (0015" ÷ 0017 ")	100 ÷ 160 bar Air jacket 2 bar,	10 ÷ 15 cm	

	Number of layers	1					
	CAUTION: The minimum epoxy primer thickness is 80 µm on steel substrates and 60 µm on aluminium substrates.						
	Single dry layer thickness.	150 µm					
	Yield of the ready to apply mixture for a dry layer thickness in the provided range	approx. 7.3 m ² /l 0.14 l/ m ² at 80 µm PROTECT 365 TIX + H5960 (4+1)					
	The actual yield depends on the surface shape, roughness and application parameters.						
	Mixture life at 20°C	12 hours for hardener H5960 STANDARD 3 hours for hardener H5960 FAST					
	Flash off between layers	10 ÷ 15 min.					
CURING TIME							
	Time to sand. For a dry layer thickness, not exceeding 130 µm.	H 5960 STANDARD			H5960 FAST		
		10°C	20°C	60°C	10°C	20°C	60°C
		-	24 hours	60 min.	48 hours	14 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 H5960 STANDARD 2 hours H5960 FAST	60 min. H5960 STANDARD 45 min. H5960 FAST		30 min. H5960 STANDARD 20 min. H5960 FAST			
Coatable by all NOVOL topcoats. The maximum coating time without matting is 48 h. The H 5960 FAST Hardener permits applying the Tech Plus Industrial Putty after 4 hours.							
TECHNICAL DATA							
Product	Solids content by weight	Solids content by volume		Density	Fineness of grind		
PROTECT 365TIX	≈ 76 %	≈ 58 %		≈ 1.48 g/cm ³	< 25µm		
H5960	≈ 68%	≈ 65%		≈ 0.92 g/cm ³	—		
PROTECT 365TIX + H5960 (4+1)	≈ 74%	≈ 59%		≈ 1.37 g/cm ³	< 25µm		

CONTENT OF VOLATILE ORGANIC COMPOUNDS	
VOC II/B/c limit*	540 g/l
Actual VOC content	480 g/l (for 4+1 + 25% THIN 60)
* For the ready to apply mixture compliant with Directive UE 2004/42/CE	
COLOUR MATCHING	
Not recommended.	
APPLICATION CONDITIONS	
<p>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%.</p> <p>The coated surface temperature should exceed the dew point by a minimum of 3°C.</p>	
COLOUR	
Beige, grey.	
EQUIPMENT CLEANING	
THIN 60 epoxy thinner.	
STORAGE CONDITIONS	
<p>Store in a dry room, away from sources of flame and heat. Avoid direct exposure to sunlight.</p> <p>Recommended storage temperature: +5°C to +35°C.</p>	
SHELF LIFE	
PROTECT 365TIX	24 months/20 °C
H5960 STANDARD	24 months/20 °C
H5960 FAST	24 months/20 °C
THIN 60	24 months/20 °C
SAFETY	
See Safety Data Sheet.	
OTHER INFORMATIONS	
<p>Registration number: 000024104.</p> <p>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.</p>	