

Technical data sheet

PROTECT 361TIX

Anti-corrosion epoxy primer

Thick epoxy anti-corrosion primer hardened with amine adduct

RELATED PRODUCTS

H5980

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 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
- Possibility of sanding after 30 minutes in 60 degrees

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				
	PROTECT 361TIX H5980 THIN 60	Volume ratio	Weight ratio	
		4	100	
		1	16	
		10%	5	
Apply the thinner in the amount calculated for the primer.				
VISCOSITY				
	DIN 6/20 °C	13 ÷ 18s		
APPLICATION				
 <p>CAUTION: Instructions of the equipment manufacturer must be followed.</p>	Pneumatic spraying	Nozzle	Pressure	Distance
	Airless spraying in air jacket	1.8 ÷ 2.2 mm	3 ÷ 4 bar	15 ÷ 20 cm
		0.38 ÷ 0.43 mm (0015" ÷ 0017 ")	100 ÷ 160 bar Air jacket 2 bar,	10 ÷ 15 cm
	Number of layers	1		
	CAUTION: If the epoxy primer is the only primer in the paint coating, its minimum thickness must be 80 µm.			
	Single dry layer thickness.	150 µm		
	Yield of the ready to apply mixture for a dry layer thickness in the provided range	approx. 5,6 m ² /l at 80 µm PROTECT 361TIX + H5980 (4+1)		
	The actual yield depends on the surface shape, roughness and application parameters.			

	Mixture life at 20°C	3 hours for hardener H5980		
	Flash off between layers	10 ÷ 15 min.		
CURING TIME				
	Time to sand For the max. dry coating thickness of 120 µm.	H 5980		
		20°C	60 °C	
		12 hours	30 min	
DRYING WITH AN INFRARED RADIATOR				
	Distance	Follow the recommendations of the equipment manufacturer.		
	The time depends on the type and power of the lamp	10 ÷ 20 min.		
CAUTION: Use the radiator no sooner than 10 min. after applying the last layer.				
SANDING				
	Dry sanding	P240 ÷ P500		
	Wet sanding	P400 ÷ P800		
COATABILITY				
Coatable by all NOVOL topcoats. Apply the topcoat after 45 mins at 20°C at a primer thickness of 80µm. 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 361TIX	≈ 67 %	≈ 47 %	≈ 1.38 g/cm ³	< 25µm
H5980	≈ 37%	≈ 38%	≈ 0.91 g/cm ³	—
PROTECT 361TIX + H5980 (4+1)	≈ 63%	≈ 45%	≈ 1.28 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 + 10% 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 +15°C and +25°C at a maximum relative humidity of 80%. The coated surface temperature should exceed the dew point by a minimum of 3°C.	
COLOUR	
Beige, RAL 7012.	
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 361TIX	24 months/20 °C
H5980	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.	