

**Technical data sheet**  
**PROTECT 330**  
**Acrylic filler**

<b>PROPERTIES</b>	
<p>The PROTECT 330 acrylic filler is an acrylic primer which thanks to high quality resins and special additives provides good anti-corrosion protection and insulation of polyester materials (putties) from topcoats. The product has a very good adhesion to various substrates. It is available in three colours: black, white and grey. By mixing the colours in appropriate ratios a substrate colour is made that enables optimum hiding by specific topcoats.</p>	
<b>RELATED PRODUCTS</b>	
H 5520	Hardener Standard, Fast.
THIN 850	Acrylic thinner Standard, Fast and Slow
PLUS 770	Elasticity increasing agent <span style="float: right;">LT-04-01</span>
PLUS 750	Acrylic accelerating agent <span style="float: right;">LT-04-02</span>
PLUS 760	Antisilicone additive <span style="float: right;">LT-04-04</span>
<b>SUBSTRATES</b>	
Old paint coatings, including thermoplastic paints	Degrease, dry sand with P220 – P280, blow off, degrease again.
Polyester putties	Dry sand, use P240 - P320 for final sanding, blow off, degrease.
Epoxy primers	Up to 48 hours without sanding, after 48 hours sand dry with P320, blow off, degrease.
Steel	Degrease and dry sand with P120.
Wash primers	Apply after drying.
Plastics	<p>Degrease with the PLUS 780 degreaser, mat with an abrasive finishing pad, blow off, degrease again.</p> <p>Use the PLUS 700 adhesion increasing agent.</p> <p>Use the PLUS 770 elasticity increasing agent if necessary.</p>
Polyester laminates	Degrease, dry sand with P280, blow off, degrease again.

MIXING RATIO							
	PROTECT 330 H 5520 THIN 850	Filling version		Priming version		Wet on wet version	
		Volume ratio	Weight ratio	Volume ratio	Weight ratio	Volume ratio	Weight ratio
		5	100	5	100	5	100
		1	13	1	13	1	13
		15%	9	40%	23	60%	35
Apply the thinner in the amount calculated for the primer.							
VISCOSITY							
	DIN 4/20°C	Filling version		Priming version		Wet on wet version	
		50 – 80 s		25 – 35 s		16 – 20 s	
CONTENT OF VOLATILE ORGANIC COMPOUNDS							
VOC II/B/c limit*				540 g/l			
Actual VOC content: filling version				510 g/l			
Actual VOC content: priming version				570 g/l			
Actual VOC content: wet on wet version				600 g/l			
* For ready to use mixture acc. to EU Directive 2004/42/CE The requirements of Directive 2004/42/EC are met by the filling version only.							
APPLICATION CONDITIONS							
It is recommended to apply the primer at a temperature above 15°C and a humidity of no more than 80 %.							
APPLICATION							
 <p>CAUTION: Instructions of the equipment manufacturer must be followed.</p>	Conventional gravity fed spray gun Filling and priming versions Wet on wet version		Nozzle	Pressure	Distance		
			1.6 – 1.8 mm	3 – 4 bar	15 – 20 cm		
	Low-pressure gravity fed HVLP spray gun Filling and priming versions Wet on wet version		1.2 – 1.4 mm	3 – 4 bar	15 – 20 cm		
			1.6 – 1.7 mm	2 bar	10 – 15 cm		
		1.4 – 1.6 mm	2 bar	10 – 15 cm			
	Number of layers		1 – 3				
	Single dry layer thickness		Filling version	Priming version	Wet on wet version		
			40 – 60 µm	30 – 50 µm	20 – 30 µm		
The yield of the ready to use mixture for the given range of dry layer thickness		4.3 m <sup>2</sup> /l at 100 µm	7.9 m <sup>2</sup> /l at 50 µm	11.7 m <sup>2</sup> /l at 30 µm			

	Mixture life at 20°C	1 h	
	Flash off time between layers at 20°C	5 –10 min	
<b>CURING TIMES</b>			
	20°C	60°C	
	3 h	30 min	
CAUTION: The curing times apply to the temperatures of the individual elements.			
<b>IR DRYING</b>			
	Distance Time depending on the type and power of the lamp	Follow the recommendations of the equipment manufacturer 10 –20 min	
CAUTION: Start IR heating no sooner than 10 mins after applying the last layer.			
<b>SANDING</b>			
	Dry sanding	P360 – P500	
	Wet sanding	P600 – P1000	
<b>THIN 850 ACRYLIC THINNER</b>			
<b>Surface</b>	<b>15 – 20°C</b>	<b>20 – 25°C</b>	<b>25 – 35°C</b>
Small 1-2 elements, spot repair	THIN 850 Fast	THIN 850 Fast	THIN 850 Standard
Medium 3-5 elements	THIN 850 Fast / Standard	THIN 850 Standard	THIN 850 Slow
Large more than 5 elements	THIN 850 Standard / Slow	THIN 850 Slow	THIN 850 Slow
<b>COLOUR</b>			
White, grey, black.			
<b>EQUIPMENT CLEANING</b>			
THIN 850 acrylic thinner or NC solvent.			
<b>STORAGE CONDITIONS</b>			
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.			

<b>SHELF LIFE</b>	
PROTECT 330	24 months/20°C
H 5520 Standard.	18 months/20°C
H 5520 Fast.	12 months/20°C
THIN 850	24 months/20°C
<b>SAFETY</b>	
See Safety Data Sheet.	
<b>NOTES</b>	
Use PROTECT 330 with NOVOL H 5520 hardener only. Use of other hardeners may reduce the anti-corrosion properties and the chemical and mechanical resistance of the filler.	
<b>OTHER INFORMATION</b>	
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.	

**ADDITIONAL INFORMATION**

**WEIGHT QUANTITY OF COMPONENTS:**

**Filling version 5+1+15%**

**CAUTION!**

In order to obtain a primer with appropriate parameters it is very important to exactly dose the individual components.

Mixture quantity	PROTECT 330	H 5520	THIN 850
0.10 l	115 g	15 g	10 g
0.15 l	173 g	22 g	15 g
0.20 l	231 g	30 g	20 g
0.25 l	288 g	37 g	25 g
0.30 l	346 g	44 g	30 g
0.40 l	461 g	59 g	40 g
0.50 l	577 g	74 g	50 g
0.75 l	965 g	111 g	74 g
1.00 l	1153 g	148 g	99 g

**WEIGHT QUANTITY OF COMPONENTS:**

**Priming version 5+1+40%**

**CAUTION!**

In order to obtain a primer with appropriate parameters it is very important to exactly dose the individual components.

Mixture quantity	PROTECT 330	H 5520	THIN 850
0.10 l	97 g	13 g	22 g
0.15 l	146 g	19 g	33 g
0.20 l	195 g	25 g	45 g
0.25 l	243 g	31 g	56 g
0.30 l	292 g	37 g	67 g
0.40 l	389 g	50 g	89 g
0.50 l	487 g	62 g	111 g
0.75 l	730 g	93 g	167 g
1.00 l	973 g	125 g	222 g

**WEIGHT QUANTITY OF COMPONENTS:**

**Wet on wet version 5+1+60%**

**CAUTION!**

In order to obtain a primer with appropriate parameters it is very important to exactly dose the individual components.

Mixture quantity	PROTECT 330	H 5520	THIN 850
0.10 l	87 g	11 g	30 g
0.15 l	130 g	17 g	45 g
0.20 l	173 g	22 g	59 g
0.25 l	216 g	28 g	74 g
0.30 l	260 g	33 g	89 g
0.40 l	346 g	44 g	119 g
0.50 l	433 g	55 g	148 g
0.75 l	649 g	83 g	222 g
1.00 l	865 g	111 g	296 g