

Technical data sheet
PROTECT 330

Acrylic filler

Filling acrylic primer hardened with aliphatic isocyanate.

RELATED PRODUCTS

HARD 10 STANDARD

HARD 10 FAST

THIN 50

Hardener Standard

Hardener Fast




Universal thinner
standard, fast and slow



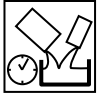



USE:

- Means of transport
- Machines and equipment

PROPERTIES

- Perfect hiding power and flowability
 - High yield
 - Perfect filling properties
 - Good chemical resistance
 - Good mechanical resistance
- Possibility of the application up to 150 µm wet in a single layer
- Certificate of Conformity from the Polish Railway Institute

SUBSTRATES							
Steel	Clean steel surfaces until reaching Sa 2½ (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.						
Wash primers	Without preparation, after 15 minutes.						
Epoxy primers	Up to 48 hours without sanding, sand P320 after 48 hours						
Plastics, except for PP, PE, PTFE and mixtures thereof	Degrease with the PLUS 780 silicone degreaser and mat with an abrasive finishing pad. Degrease again and apply the PLUS 700 adhesion increasing agent and the PLUS 770 elasticity increasing agent.						
Polyester laminates	Dry sand P280, degrease again.						
MIXING RATIO 6+1 – small areas (up to 1 m ²)							
	PROTECT 330 HARD 10 THIN 50	Filling version		Priming version		Wet on wet version	
		Volume ratio	Weight ratio	Volume ratio	Weight ratio	Volume ratio	Weight ratio
		6	100	6	100	6	100
		1	11	1	11	1	11
		25 %	14	45 %	25	70 %	39
Apply the thinner in the amount calculated for the primer.							
MIXING RATIO 5+1 – large areas (over 1 m ²)							
	PROTECT 330 HARD 10 THIN 50	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	12	1	12	1	12
		25 %	14	45 %	25	70 %	39
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 – 30 s		16 – 20 s	

SPRAYING PARAMETERS							
 CAUTION: Instructions of the equipment manufacturer must be followed.							
Filling version		Priming version		Wet on wet version			
Pneumatic spraying	Airless spraying	Pneumatic spraying	Airless spraying	Pneumatic spraying	Airless spraying		
nozzle: $\varnothing 1.7 \div 2.0$ mm, pressure: 3 \div 4 bar distance: 15 \div 20 cm	0.33 \div 0.38 mm (0.013" \div 0.015"), pressure: 100 - 160 bar, air jacket: 2 bar distance: 10-15 cm	nozzle: $\varnothing 1.6 \div 1.8$ mm, pressure: 3 \div 4 bar distance: 15 \div 20 cm	0.28 \div 0.33 mm (0011" \div 0013"), pressure: 100 - 120 bar, air jacket: 2 bar distance: 10-15 cm	nozzle: $\varnothing 1.2 \div 1.4$ mm, pressure: 3 \div 4 bar distance: 15 \div 20 cm	0.23 \div 0.28 mm (0009" \div 0011"), pressure: 100 - 120 bar, air jacket: 2 bar distance: 10-15 cm		
APPLICATION							
		Filling version	Priming version	Wet on wet version			
	Number of layers	1 \div 3	1 \div 3	1 \div 2			
	Single dry layer thickness.	40 \div 50 μ m	25 \div 35 μ m	15 \div 20 μ m			
	Yield of the ready to apply mixture for a dry layer thickness in the provided range	approx. 7.0 m ² /l 0.14 l/ m ² at 80 μ m PROTECT 330 + HARD 10 (6+1) / (5+1)					
	The actual yield depends on the surface shape, roughness and application parameters.						
	Mixture life at 20°C						
	HARD 10 STANDARD	2 hours	4 hours	6 hours			
	HARD 10 FAST	1 hour	1.5 hours	2 hour			
	Flash off between layers	5 \div 10 min.					
CURING TIME							
	Time to sand for the max. thickness of 100 μ m.	HARD 10 STANDARD			HARD 10 FAST		
		10°C	20°C	60°C	10°C	20°C	60°C
		-	4 hours.	45 min.	10 hours.	3 hours.	30 min.
SANDING							
	Dry sanding	P240 \div P500					

COATABILITY				
Topcoat application time for a 80 µm thick primer.	10°C	20°C	60°C	
	3 hours. HARD 10 STANDARD 2 hours. HARD 10 FAST	45 min. HARD 10 STANDARD 35 min. HARD 10 FAST	30 min. HARD 10 STANDARD 20 min. HARD 10 FAST	
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 330	≈ 74 %	≈ 57 %	≈ 1.59 g/cm ³	< 12.5µm
HARD 10	≈ 56%	≈ 55%	≈ 1.03 g/cm ³	---
PROTECT 330 + HARD 10 (6+1) / (5+1)	≈ 71%	≈ 57%	≈ 1.51 g/cm ³	< 12.5µm
CONTENT OF VOLATILE ORGANIC COMPOUNDS				
VOC II/B/c limit*	540 g/l			
Actual VOC content	510 g/l (for 6+1/5+1 + 25% THIN 50)			
* For the ready to apply mixture in the filling version compliant with Directive UE 2004/42/CE				
COLOUR MATCHING				
Colour matching can be done with colour acrylic topcoats at max. 15% of volume. Count the hardener content for the total quantity of the colour-matched primer.				
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 -60°C and +80°C. Transient temperatures up to +120°C maximum are permitted.				
COLOUR				
White, grey.				
EQUIPMENT CLEANING				
THIN 50 acrylic thinner or NC solvent.				
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 330	24 months/20 °C
HARD 10 STANDARD	18 months/20 °C
HARD 10 FAST	12 months/20 °C
THIN 50	24 months/20 °C
* In original sealed packaging	
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.	