

Technical data sheet

# PROTECT 368 TIX UHS

Anti-corrosion epoxy primer UHS

Anti-corrosion primer with high solid particle content hardened with amine adduct

## RELATED PRODUCTS

**H5970 STANDARD**

Epoxy primer hardener standard

**H5970 SLOW**

Epoxy primer hardener slow

**THIN 60**





Epoxy thinner





## USE:

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

## PROPERTIES

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

SUBSTRATES				
Steel	Clean steel surfaces until reaching Sa 2 <sup>1/2</sup> (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 - H5970 STANDARD, H 5970 SLOW				
	PROTECT 368 TIX UHS H5970 THIN 60	Volume ratio	Weight ratio	
		4	100	
		1	15	
	10% ÷ 20%	5.5 ÷ 11		
Apply the thinner in the amount calculated for the primer.				
VISCOSITY				
	DIN 4/20 °C	4 + 1	100 – 120 s	
		4 + 1 + 10%	60 – 65 s	
		4 + 1 + 20%	32 – 37 s	
APPLICATION				
 <p><b>CAUTION:</b> Instructions of the equipment manufacturer must be followed.</p>	Pneumatic spraying	1.6 ÷ 2.2 mm	3 ÷ 4 bar	15 ÷ 20 cm
	Airless spraying in air jacket	0.33 ÷ 0.43 mm (0013" ÷ 0017")	100 ÷ 160 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 and 60 µm on aluminium substrates.			
	Single dry layer thickness.	100 ÷ 120 µm		
	Yield of the ready to apply mixture for a dry layer thickness in the provided range	approx. 8.0 m <sup>2</sup> /l 0.13 l/ m <sup>2</sup> at 80 µm  PROTECT 368 TIX UHS + H5970 (4+1)		
	The actual yield depends on the surface shape, roughness and application parameters.			

	Mixture life at 20°C	H5970 SLOW 6 hours H5970 STANDARD 1 hours					
	Flash off between layers	15 ÷ 20 min.					
<b>CURING TIME</b>							
	Time to sand For the max. dry coating thickness of 130 µm.	H 5970 SLOW			H 5970 STANDARD		
		10°C	20°C	60°C	10°C	20°C	60°C
		-	24 hours	60 min.	48 hours	14 hours	45 min.
<b>SANDING</b>							
	Dry sanding	P240 ÷ P500					
<b>COATABILITY</b>							
Topcoat application time for a 80 µm thick primer.	10°C	20°C		60°C			
	4 hours H5970 STANDARD	90 min. H5970 SLOW 60 min. H5970 STANDARD		50 min. H5970 SLOW 30 min. H5970 STANDARD			
Coatable by all NOVOL topcoats. The maximum coating time without mating is 48 h. The H 5970 STANDARD Hardener permits applying the Tech Plus Industrial Putty after 8 hours.							
<b>TECHNICAL DATA</b>							
Product	Solids content by weight	Solids content by volume	Density	Fineness of grind			
PROTECT 368 TIX UHS	≈ 80 %	≈ 63%	≈ 1.55 g/cm <sup>3</sup>	< 25µm			
H 5970	≈ 71%	≈ 66%	≈ 0.97 g/cm <sup>3</sup>	—			
PROTECT 368 TIX UHS + H 5970 (4:1)	≈79%	≈ 64%	≈ 1.43 g/cm <sup>3</sup>	< 25µm			
<b>CONTENT OF VOLATILE ORGANIC COMPOUNDS</b>							
VOC II/B/c limit*	540 g/l						
Actual VOC content	310 g/l (for 4+1) 350 g/l (for 4+1+10%) 385g/l (for 4+1+20%)						
* For the ready to apply mixture compliant with Directive UE 2004/42/CE							
<b>COLOUR MATCHING</b>							
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%. The coated surface temperature should exceed the dew point by a minimum of 3°C.</p>	
TEMPERATURE RESISTANCE	
<p>The operating temperature of the applied primer is between -60°C and +80°C. Transient temperatures up to +120°C maximum are permitted.</p>	
COLOUR	
<p>Beige</p>	
EQUIPMENT CLEANING	
<p>THIN 60 epoxy thinner.</p>	
STORAGE CONDITIONS	
<p>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.</p>	
SHELF LIFE	
PROTECT 368 TIX UHS	24 months/20 °C
H5970 SLOW	24 months/20 °C
H5970 STANDARD	24 months/20 °C
THIN 60	24 months/20 °C
SAFETY	
<p>See Safety Data Sheet.</p>	
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>	