











Technical data sheet

PROTECT 390

Acrylic filler

PROPERTIES			
<p>PROTECT 390 ACRYLIC FILLER – high solid filler based on acrylic resin. High filling properties and anti-sag additives gives possibility to apply very thick layers. Very good levelling, sanding properties and adhesion to various substrates. Very short drying time allowing for making quick repairs is the main advantage of the primer. The product has excellent adhesion to various substrates. The acrylic filler features high quality resins and special additives to ensure good anti-corrosion protection and isolation of polyester materials (fillers) from acrylic topcoats. Possibility of applying without flash-off.</p>			
RELATED PRODUCTS			
H 5520	Hardener standard, fast.		
THIN 850	Acrylic thinner, standard, fast, slow.		
PLUS 770	Elasticity increasing agent.		LT-04-01
PLUS 760	Anti-silicone additive.		LT-04-04
SUBSTRATES			
Old paint coatings, including thermoplastic coats	Degrease, dry sand with P220 - P360, blow off the dust and degrease again.		
Polyester putties	Dry sand, finish levelling with P240 - P320, blow off the dust and degrease.		
Epoxy primers	No sanding for up to 48 hours, then sand with P320, blow off the dust and degrease.		
Steel	Degrease, dry sand with P120, blow off the dust and degrease again.		
Wash primers	Apply when dry.		
Plastics	Degrease with PLAST 780 Degreaser, mat with an abrasive finishing pad, degrease again. Apply the PLUS 700 Adhesion Increasing Agent. If necessary, use PLAST 770 Elasticity Increasing Agent.		
Polyester laminates	Degrease, dry sand with P280, blow off the dust and degrease again.		
MIXING RATIO			
	PROTECT 390	Volume ratio	Weight ratio
	H 5520	4	100
	THIN 850	1	16,5
		0 - 10%	0 - 6
The thinner quantity is given as calculated on the basis of the filler.			

VISCOSITY					
	DIN 4/20°C	35 - 50 s			
CONTENT OF VOLATILE ORGANIC COMPOUNDS					
VOC II/B/c limit*		540 g/l			
Actual VOC		500 g/l			
* For ready to use mixture acc. to EU Directive 2004/42/EC					
APPLICATION CONDITIONS					
It is recommended to apply the filler over 15°C and at humidity of 80%.					
APPLICATION					
	CAUTION: Follow the equipment manufacturer's guidelines	Conventional gravity fed spray gun	Nozzle 1.6 ÷ 1.8 mm	Pressure 2 ÷ 4 bar	Distance 15 ÷ 20 cm
		Low-pressure gravity fed spray gun	1.6 ÷ 1.8 mm	1,5 ÷ 2 bar	10 ÷ 15 cm
	Number of layers	2 ÷ 3			
	Single dry layer thickness	Ca. 60 µm			
	The yield of the ready to use mixture for the given range of dry layer thickness	4.5 m ² /l at 100 µm			
	Mixture life at 20°C	H5520 Standard		H5520 Fast	
		30 min		15 min	
	Flash off time between layers at 20°C	0 ÷ 10 min			
CURING TIMES					
	H5520 Standard		H5520 Fast		
	20°C	60°C	20°C	60°C	
	4 h	40 min	2 h	30 min	
CAUTION: The curing times apply to a dry coat of 80 µm thick.					

IR DRYING			
	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 at least 10 min after applying the last layer.			
SANDING			
	Dry sanding	P360 - P500	
	Wet sanding	P600 - P1000	
H5520 HARDENER / THIN 850 ACRYLIC THINNER			
Surface	15 ÷ 20°C	20 ÷ 25°C	25 ÷ 35°C
Small 1-2 elements, spot repair	H5520 fast THIN 850 fast	H5520 fast/standard THIN 850 fast	H5520 standard THIN 850 standard
Moderate 3-5 elements	H5520 fast/standard THIN 850 fast/standard	H5520 standard THIN 850 standard	H5520 standard THIN 850 slow
Large over 5 elements	H5520 standard THIN 850 standard/slow	H5520 standard THIN 850 slow	H5520 standard THIN 850 slow
COLOUR			
White, grey, black.			
EQUIPMENT CLEANING			
THIN 850 acrylic thinner or NC solvent.			
STORAGE CONDITIONS			
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.			
SHELF LIFE			
PROTECT 390	24 months/20°C		
H 5520 Standard.	18 months/20°C		
H 5520 Fast.	12 months/20°C		
THIN 850	24 months/20°C		
SAFETY			
See the Safety Data Sheet.			
NOTES			
Use the PROTECT 390 acrylic filler only with the H 5520 NOVOL hardener. Using other hardeners may reduce the anti-corrosion properties and the mechanical and chemical resistance of the filler.			

OTHER INFORMATION

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 perform 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.

OTHER INFORMATION

WEIGHT QUANTITY OF COMPONENTS: 4+1

CAUTION!

In order to obtain a filler with suitable parameters, it is very important to accurately dose the specific components.

Mixture amount	PROTECT 390	H 5520
0.10 l	120 g	20 g
0.15 l	181 g	30 g
0.20 l	241 g	40 g
0.25 l	301 g	50 g
0.30 l	361 g	60 g
0.40 l	482 g	80 g
0.50 l	602 g	100 g
0.75 l	903 g	149 g
1.00 l	1204 g	199 g

OTHER INFORMATION

WEIGHT QUANTITY OF COMPONENTS: 4+1+10%

CAUTION!

In order to obtain a filler with suitable parameters, it is very important to accurately dose the specific components.

Mixture amount	PROTECT 390	H 5520	THIN 850
0.10 l	111 g	18 g	7 g
0.15 l	167 g	28 g	10 g
0.20 l	223 g	37 g	13 g
0.25 l	279 g	46 g	17 g
0.30 l	334 g	55 g	20 g
0.40 l	446 g	74 g	26 g
0.50 l	557 g	92 g	33 g
0.75 l	836 g	138 g	49 g
1.00 l	1115 g	184 g	66 g