INDUSTRIAL
COATING SYSTEMS NOVOL

Technical data sheet

PROTECT 366

Anti-corrosion epoxy primer
Thick epoxy anti-corrosion primer hardened with amine adduct

RELATED PRODUCTS

H5966	Epoxy primer hardener
THIN 60	Epoxy thinner

USE:

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

PROPERTIES

- Perfect hiding power
- Application of thick layers is possible
- Perfect insulation properties
- Perfect hiding power and levelling
- Very good chemical resistance
- Very good mechanical resistance

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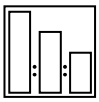
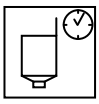
2017/09/06

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			
		Volume ratio	Weight ratio
	PROTECT 366 H5966 THIN 60	4 1 10% (20%)	100 15 6 (12)
Apply the thinner in the amount calculated for the primer.			

VISCOSITY			
	DIN 4/20 °C	4 + 1 + 10% 4 + 1 + 20%	45 ÷ 55s 20 ÷ 30s

APPLICATION				
		Nozzle	Pressure	Distance
CAUTION: Instructions of the equipment manufacturer must be followed.	Pneumatic spraying	1.6 ÷ 2.0 mm	3 ÷ 4 bar	15 ÷ 20 cm
	Airless spraying in air jacket	0.33 ÷ 0.38 mm (0013" ÷ 0.015 ")	100 ÷ 140 bar Air jacket 2 bar	10 ÷ 15 cm
	Number of layers	1 – 2		
	CAUTION: If the epoxy primer is the only primer in the paint coating, its minimum thickness must be 80 µm.			
	Single dry layer thickness.	180 µm		
	Yield of the ready to apply mixture for a dry layer thickness in the provided range	approx. 4.0 m^2/l at 180 µm PROTECT 366 + H5966 (4+1)		
	The actual yield depends on the surface shape, roughness and application parameters.			
	Mixture life at 20℃	2 hours		

	Flash off between layers	10 ÷ 15 min.	
CURING TIME			
	Time to sand For the max. dry coating thickness of 130 µm.	20℃	60 ℃
		24 hours	45 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			
Can be coated with all NOVOL topcoats. The maximum application time of the next coating without matting is 48 h.			

TECHNICAL DATA

Product	Solids content by weight	Solids content by volume	Density
PROTECT 366	≈ 78 %	≈ 59 %	≈ 1.68 g/cm^3
H5966	≈ 68%	≈ 66%	≈ 0.92 g/cm^3
PROTECT 366 + H5966 (4+1)	≈ 77,5%	≈ 62%	≈ 1.53 g/cm^3

CONTENT OF VOLATILE ORGANIC COMPOUNDS	
VOC II/B/c limit* Actual VOC content	540 g/l 383 g/l (for 4+1)
* 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℃ and +25℃ at a maximum relative humidity of 80%. The coated surface temperature should exceed the dew point by a minimum of 3℃.	
COLOUR	
Grey.	
EQUIPMENT CLEANING	
THIN 60 epoxy thinner.	
STORAGE CONDITIONS	
Store in a dry and cool room, away from sources of fire and heat. Avoid direct exposure to sunlight. Store at +5 do +35℃.	
SHELF LIFE	
PROTECT 366	24 months/20 ℃
H5966	24 months/20 ℃
THIN 60	24 months/20 ℃
SAFETY	
See Safety Data Sheet.	
OTHER INFORMATIONS	
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 resultwas affected by factors beyond our control.	