Technical data sheet
PROTECT 380
Polyester filler

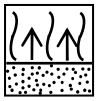
PROPERTIES	
PROTECT 380 – Polyester finishing filler applied by pneumatic spraying. Once mixed with the hardener, the product gains spray viscosity without the need for extra thinners. A unique indicator allows the readiness of the mixture to be evaluated (when the olive colour turns light beige, the product is ready for spraying), and the thoroughness of the mixing of the components to be inspected. Allows a high fill ratio to be achieved leaving a smooth surface, even on very large areas. Ready to sand after approx. 1.5 hour at 20℃ (this can be reduced by heating to a maximum of 60℃). The product is intended for machine sanding, as well as for manual sanding with fine-grained abrasive paper.	
RELATED PRODUCTS	
CETOX 12 OB. (red)	Hardener
SUBSTRATES	
Old paint coatings	Degrease, dry sanding with P220 – P280, degrease again.
Polyester putties	Dry sanding with P240, degrease again.
Epoxy primers	Mat and degrease. If NOVOL epoxy primers are used, apply the filler after a minimum of 4 hours from applying the epoxy primer.
Steel surfaces	Degrease, dry sanding with P80 – P120, degrease again.
Aluminium surfaces	Degrease with the PLUS 780 degreaser, mat with a needled cloth, degrease again.
Plastics, except for PE, PP and PTFE	Degrease with the PLUS 780 degreaser, mat with a needled cloth, degrease again.
Two-component acrylic fillers	Degrease, dry sanding with P220 – P280, degrease again.
Note: Do not apply the spray filler directly on top wash primers or one-component acrylic and cellulose nitrate products.	

MIXING RATIO

		Volume ratio	Weight ratio
	PROTECT 380	100 ml	100 g
	CETOX-12 OB (red)	10 ml	6.5 g

CONTENT OF VOLATILE ORGANIC COMPOUNDS (VOC)	
VOC II/B/c limit* Actual VOC content	540 g/l 220 g/l
* For ready to use mixture acc. to EU Directive 2004/42/CE	

APPLICATION CONDITIONS
It is recommended to apply the primer at a temperature above 10℃ and humidity of no more than 80%.

APPLICATION				
	Conventional gravity fed spray gun CAUTION: Specifications of the equipment manufacturer must be followed.	Nozzle **1.6 – 1.8 mm**	Pressure **3 – 4 bar**	Distance **15 – 20 cm**
	Number of layers	1 – 3		
	Single wet layer thickness	Approx. 150 µm		
	The yield of the ready to use mixture for the given range of dry layer thickness	6.0 m^2/l at 100 µm		
	Maximum total layer thickness	Approx. 300 µm		
	Mixture life at 20℃	**17 – 25** minutes **Caution**: Mix components directly before application due to the short life of the mixture.		
	Flash off time between layers at 20℃	**2 – 4** minutes		

DRYING TIMES		
	20℃	**70 – 90** minutes
	60℃	**20** min
CAUTION: The curing times apply to the temperatures of the individual elements.		
	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.		

DRY SANDING ONLY		
	rough	finish
	P180 ─ P240	P240 ─ P320

COLOUR
Olive

COATABILITY
Most commercial acrylic primers and epoxy primers. Isolate PROTECT 380 polyester primer with a layer of an acrylic or epoxy primer before applying topcoats.

EQUIPMENT CLEANING
THIN 880 spray filler 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 380	12 months/20℃
CETOX-12 OB (red)	18 months/20℃

SAFETY
See Safety Data Sheet.

NOTES
Intended for professional use only. Use PROTECT 380 only with the hardener CETOX-12 OB (red). Using other systems (hardener, thinner) may result in insufficient curing of the filler and flaws in coating.

OTHER INFORMATION
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 carry out 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.