







Technical data sheet

PROTECT 320





Acrylic filler

PROPERTIES	
PROTECT 320 ACRYLIC FILLER – fast acrylic resin filler. Has a significantly lower tendency to stick to sandpaper, especially during power sanding. At the selected spraying viscosity, the product can be applied in smooth layers which perfectly fill even relatively large scratches and surface irregularities. 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.	
RELATED PRODUCTS	
H 5520	Hardener.
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 12 hours, then sand with P320, blow off the dust and degrease.
Steel	Degrease, dry sand with P120, blow off the dust and degrease again.
Aluminium	Degrease and dry sand with P280 - P360 or mat with an abrasive cloth, and degrease.
Wash primers	Apply when dry.
Plastics	Degrease with PLAST 780 Degreaser, mat with an abrasive cloth, 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.

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MIXING RATIO					
	PROTECT 320 H 5520 THIN 850	Filling version		Priming version	
		Volume ratio	Weight ratio	Volume ratio	Weight ratio
		4	100	4	100
		1	16	1	16
		10%	5.5	20%	11
The thinner quantity is given as calculated on the basis of the filler.					
VISCOSITY					
	DIN 4/20°C	Filling version		Priming version	
		40 - 50 s		22 - 26 s	
CONTENT OF VOLATILE ORGANIC COMPOUNDS					
VOC II/B/c limit*		540 g/l			
Actual VOC: priming version		530 g/l			
Actual VOC: filling version		505 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		Nozzle	Pressure	Distance	
	Conventional gravity fed spray gun	1.6 - 1.8 mm	3 - 4 bar	15 - 20 cm	
	Low-pressure gravity fed HVLP spray gun	1.6 - 1.7 mm	2 bar	10 - 15 cm	
	Number of layers	Filling version		Priming version	
		1 - 2		2 - 3	
	Single dry layer thickness	Ca. 60 µm		Ca. 45 µm	
	The yield of the ready to use mixture for the given range of dry layer thickness	4.2 m²/l at 100 µm		4 m²/l at 100 µm	
	Mixture life at 20°C	10 min.		20 min.	
	Flash off time between layers at 20°C	5 - 10 min.		5 - 7 min.	

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CURING TIMES			
	20°C	60°C	
	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	
THIN 850 ACRYLIC THINNER			
Surface	15 - 20°C	20 - 25°C	25 - 35°C
Small 1-2 elements, spot repair	THIN 850 Fast	THIN 850 Fast	THIN 850 Standard
Moderate 3-5 elements	THIN 850 Fast/Standard	THIN 850 Standard	THIN 850 Slow
Large over 5 elements	THIN 850 Standard/Slow	THIN 850 Slow	THIN 850 Slow
COLOUR			
Grey.			
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 320	24 months/20°C		
H 5520	12 months/20°C		
THIN 850	24 months/20°C		

SAFETY			
See the Safety Data Sheet.			
NOTES			
<p>Use the PROTECT 320 acrylic filler only with the H 5520 NOVOL hardener.</p> <p>Using other hardeners may reduce the anti-corrosion properties and the mechanical and chemical resistance of the filler.</p>			
OTHER INFORMATION			
<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 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.</p>			
OTHER INFORMATION			
<p>WEIGHT QUANTITY OF COMPONENTS: 4+1+10%</p> <p>CAUTION!</p> <p>In order to obtain a filler with suitable parameters, it is very important to accurately dose the specific components.</p>			
Mixture amount	PROTECT 320	H 5520	THIN 850
0.10 l	113	19	7
0.15 l	167	28	10
0.20 l	225	37	13
0.25 l	281	46	17
0.30 l	338	56	20
0.40 l	450	74	26
0.50 l	563	93	33
0.75 l	844	139	49
1.00 l	1125	185	66

WEIGHT QUANTITY OF COMPONENTS: 4+1+20%

CAUTION!

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

Mixture quantity	PROTECT 320	H 5520	THIN 850
0.10 l	105	17	12
0.15 l	157	26	18
0.20 l	210	35	25
0.25 l	262	43	31
0.30 l	314	52	37
0.40 l	419	69	49
0.50 l	524	86	61
0.75 l	786	129	92
1.00 l	1048	172	123