industrial
anti-corrosion coatings
NOVOL

Technical data sheet

PROTECT 371

Alkyd primer fast-drying
Modified fast-drying primer based on alkyd resin.

USE:

- Means of transport
- Machines and equipment

PROPERTIES

- High yield
- Good hiding power and flowability
- Good filling properties
- Good chemical resistance
- Application of thick layers is possible
- Good mechanical resistance
- Possibility of the application up to 250 µm wet in a single layer

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.

MIXING RATIO			
		Volume ratio	Weight ratio
	PROTECT 371	100	100

VISCOSITY		
	DIN 6/20 °C	unmeasurable

SPRAYING PARAMETERS				
CAUTION: Instructions of the equipment manufacturer must be followed.		Nozzle	Pressure	Distance
	Conventional gravity fed spray gun	1.6 ÷ 2.0 mm	3 ÷ 4 bar	15 ÷ 20 cm
	Airless spraying in air jacket	0.33 ÷ 0.38 mm (0.013” ÷ 0.015 ”)	150 ÷ 200 bar Air jacket 2 bar	10 ÷ 15 cm

APPLICATION		
	Number of layers	1 ÷ 2
	CAUTION: The minimum alkyd primer thickness is 80 µm on steel substrates.	
	Single dry layer thickness.	70 ÷ 90 µm
	Yield of the ready to apply mixture for a dry layer thickness in the provided range	approx. 7.5 m^2/l 0.13 g/ m^2 at 80 µm PROTECT 371
	The actual yield depends on the surface shape, roughness and application parameters.	
	Flash off between layers	5 ÷ 10 min.

DRYING TIME

			10°C	20°C
	For the max. dry coating thickness of 80 µm.	Dust-free	1.5 hours	45 min.
		Tack-free	2 hours	1 hours
		Operating hardness	6 hours	2.5 hours

COATABILITY

Topcoat application time for a 80 µm thick primer.	10°C	20°C
	3 hours	45 min.

Coatable by all NOVOL alkyd topcoats. The time to recoat ranges from 1 hour to 7 days before sanding, assuming the coat is free of salts, grease, dust, and foreign debris. It is recommended to degrease and sand the coat after 7 days.

TECHNICAL DATA

Product	Solids content by weight	Solids content by volume	Density	Fineness of grind
PROTECT 371	≈ 72 %	≈ 60 %	≈ 1.3 ÷ 1.5 g/cm^3	< 25µm

CONTENT OF VOLATILE ORGANIC COMPOUNDS

VOC II/B/c limit*	540 g/l
Actual VOC content	375 g/l

* For the ready to apply mixture compliant with Directive UE 2004/42/CE

APPLICATION CONDITIONS

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.

TEMPERATURE RESISTANCE

The operating temperature of the applied primer is between -60ºC and +80ºC.
Transient temperatures up to +120°C maximum are permitted.

COLOUR

Grey, dark grey, black, red, white.

EQUIPMENT CLEANING

THIN 50.

STORAGE CONDITIONS

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.

SHELF LIFE	
PROTECT 371	12 months/20 °C

SAFETY
See Safety Data Sheet.

OTHER INFORMATIONS
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 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.