Technical Data Sheet

PROTECT 360 TIX

Anti-corrosion epoxy primer

Fast-drying anti-corrosion epoxy primer, hardened with amine adduct.

RELATED PRODUCTS

H5950	Hardener for epoxy primer dedicated to aluminum
H5960 STANDARD	Hardener for epoxy primer, standard
H5960 FAST	Hardener for epoxy primer, fast
THIN 60	Epoxy thinner

USE:

- Transport vehicles
- Machines and equipment
- Outer surfaces of tanks
- Steel structures

PROPERTIES

- Excellent insulating performance
- Very good chemical resistance
- High yield
- Perfect hiding power and flowability
- Suitable for application in thick layers
- Very good mechanical resistance
- Possibility of the application of thick layers up to 200 µm wet in a single layer

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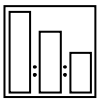
SUBSTRATES	
Steel	Clean steel surfaces to Sa $2^1/_2$ (wet blasting) or St3 (manual cleaning or with a power tool) in accordance with PN-ISO 12944-4; the surface after treatment must be free of oil, grease, dust, loose old paint coating, mill scale, rust and foreign contaminants; the surface should exhibit the gloss of the metal substrate.
Old coatings	Degrease and dry sand with P220 - P360.
Polyester putties	Dry sand, finishing levelling with P240 - P320.
Galvanized steel and 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. CAUTION: H5950 hardener should be used for aluminum substrates.
Stainless steel	Degrease and matt with P240 to P320. Degrease again.
Polyester laminates	Dry sand with P280 and degrease.

MIXING RATIO



	Volume ratio	Weight ratio
PROTECT 360 TIX H5950	1 1	100 58
PROTECT 360 TIX H5960 STANDARD THIN 60	4 1 25%	100 16 14
PROTECT 360 TIX H5960 FAST THIN 60	4 1 15%	100 16 8
The thinner quantity is given as calculated on the basis of the primer.		

SPRAYING PARAMETERS

Component A	Hardener	Mixing ratio	THIN 60	Viscosity DIN 4/20°C	Pneumatic spraying	Airless spraying
PROTECT 360TIX 	H5950	1+1	None	22 - 28 s	Nozzle: 1.4 - 1.6 mm, Pressure: 3 - 4 bar Distance: 15 - 20 cm	Nozzle: 0.23 ÷ 0.28 mm (0.009" ÷ 0.011") Pressure: 100 - 120 bar, Air jacket: 2 - 4 bar Distance: 10 - 15 cm
	H5960 STANDARD	4+1	25%	60 - 80 s	Nozzle: 1.6 - 2.0 mm, Pressure: 3 - 4 bar Distance: 15 - 20 cm	Nozzle: 0.33 ÷ 0.38 mm (0.013" ÷ 0.015") Pressure: 100 - 140 bar, Air jacket: 2 - 4 bar Distance: 10 - 15 cm
	H5960 FAST	4+1	15%	60 - 80 s	Nozzle: 1.6 - 2.0 mm, Pressure: 3 - 4 bar Distance: 15 - 20 cm	Nozzle: 0.33 ÷ 0.38 mm (0.013" ÷ 0.015") Pressure: 100 - 140 bar, Air jacket: 2 - 4 bar Distance: 10 - 15 cm

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APPLICATION

Hardener	Mixing ratio	Thinner THIN 60	Single dry layer thickness	Recommended number of layers
H 5950	1+1	None	50 - 60 µm	1-2
H 5960 STANDARD	4+1	25%	80 - 100 µm	1-2
H 5960 FAST	4+1	15%	80 - 100 µm	1-2

CAUTION: The minimum epoxy primer thickness is 80 µm on steel substrates and 60 µm on aluminium substrates.

Yield of the ready to use mixture for the given range of dry layer thickness	1+1 version: approx.. 6.3 m^2/l 0,16 l/m^2 at 60 µm	4+1 version: approx.. 7.3 m^2/l 0,14 l/m^2 at 80 µm

The actual yield depends on the surface shape, roughness and application parameters.

Mixture life at 20°C	12 hours for hardener H5960 STANDARD 3 hours for hardeners H5960 FAST / H5950
Flash off between layers	10 -20 minutes

CURING TIME

Time to sand

For max. thickness of 80-120 µm.

H 5960 STANDARD			H 5950 / H5960 FAST		
10°C	20°C	60°C	10°C	20°C	60°C
-	24 hours	60 min.	48 hours	14 hours	45 min.

SANDING

Dry sanding	P240 - P500

COATABILITY

Topcoat application time for a 80 µm thick primer.

10°C	20°C	60°C
4 hours H5960 STANDARD 2 hours H5960 FAST/H5950	60 min. H5960 STANDARD 45 min. H5960 FAST/H5950	30 min. H5960 STANDARD 20 min. H5960 FAST/H5950

Coatable by all NOVOL topcoats. The maximum coating time without matting is 48 h.
The H5960 FAST and H5950 hsrdeners permits applying the Tech Plus Industrial Putty after 4 hours.

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TECHNICAL DATA				
Product	Solids content by weight	Solids content by volume	Density	Fineness of grind
PROTECT 360 TIX	≈ 76%	≈ 58%	≈ 1.52 g/cm^3	< 12.5µm
H5950	≈ 19%	≈ 17.5%	≈ 0.88 g/cm^3	——
H5960 STANDARD / H5960 FAST	≈ 68%	≈ 65%	≈ 0.92 g/cm^3	——
PROTECT 360 TIX + H5950: 1+1	≈ 55%	≈ 38%	≈ 1.22 g/cm^3	< 12.5µm
PROTECT 360 TIX + H5960 STANDARD / H5960FAST: 4+1	≈ 75%	≈ 59%	≈ 1.44 g/cm^3	< 12.5µm

VOC CONTENT	
VOC II/B/c limit*	540 g/l
Actual VOC	540 g/l (for 1+1) 440 g/l (4+1 + 25% THIN 60)
* For ready to apply mixture acc. to EU Directive 2004/42/EC	

COLOUR MATCHING

Not recommended.

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.

COLOUR

Grey.

EQUIPMENT CLEANING

THIN 60 epoxy thinner

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 360 TIX	24 months/20°C
H5950	24 months/20°C
H5960 STANDARD	24 months/20°C
H5960 FAST	24 months/20°C
THIN 60	24 months/20°C
* In originally sealed packaging	

SAFETY
See the Safety Data Sheet.
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.