

Technical data sheet

PROTECT 341

Epoxy Wash Primer

One-component wash primer based on PVC epoxy resin.

The wash primer contains anti-corrosion pigments based on zinc, aluminium and phosphorus oxides.

RELATED PRODUCTS

THIN 50

Universal thinner
standard, fast and slow

USE:

- Means of transport
- Machines and equipment
- Steel and aluminium substrates

PROPERTIES

- High yield
- Perfect anticorrosion properties
- Perfect adhesion to numerous substrates
 - Good mechanical resistance
- Possibility of the application up to 80 µm wet in a single layer

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SUBSTRATES					
Steel		Clean steel surfaces until reaching Sa 2 ^{1/2} (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.			
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.			
MIXING RATIO					
	PROTECT 341 THIN 50* / THIN 50 FAST*	Volume ratio	Weight ratio	Volume ratio	Weight ratio
		100 30%	100 22	100 60%	100 44
* - see APPLICATION CONDITIONS (p.3)					
VISCOSITY:					
	DIN 4/20 °C	44-48 s		22-25 s	
APPLICATION					
 CAUTION: Instructions of the equipment manufacturer must be followed.	Pneumatic spraying	Nozzle	Pressure	Distance	
		1.3 — 1.5 mm	2 — 4 bar	15 — 20 cm	
	Airless spraying in air jacket. Recommended with THIN 50 STANDARD.	0.28 — 0.33 mm (0.011" — 0.013 ")	100 — 120 bar Air jacket 2 bar	10 — 15 cm	
	Number of layers	2 — 3			
	CAUTION: The minimum primer thickness is 80 µm on steel substrates and 60 µm on aluminium substrates.				
	Single dry layer thickness.	20 — 25 µm			
	Yield of the ready to apply mixture for a dry layer thickness in the provided range	approx. 4.0 m ² /l 0.25 l/ m ² at 50 µm PROTECT 341 + THIN 50			
	The actual yield depends on the surface shape, roughness and application parameters.				
	Flash off between layers	5 — 10 min.			

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DRYING TIME				
	For the max. dry coating thickness of 50 µm.	10°C	20°C	
		40 min.	15 min.	
TECHNICAL DATA				
Product	Solids content by weight	Solids content by volume	Density	Fineness of grind
PROTECT 341	≈ 51 %	≈ 32 %	≈ 1.22 g/cm ³	< 12.5µm
PROTECT 341 + THIN 50; 100+30%	≈ 42 %	≈ 25 %	≈ 1.13 g/cm ³	——
PROTECT 341 + THIN 50; 100+60%	≈ 36 %	≈ 20 %	≈ 1.08 g/cm ³	< 12.5µm
CONTENT OF VOLATILE COMPONENTS				
VOC II/B/c limit*	780 g/l			
Actual VOC content	695 g/l			
* For the ready to apply mixture compliant with Directive UE 2004/42/CE				
COLOUR MATCHING				
Not recommended.				
COATABILITY				
Topcoat application time for a 50 µm thick primer.	10°C		20°C	
	60 min.		20 min.	
Can be coated with acrylic topcoats, basecoat paints, acrylic primers, antigravel products. The maximum application time of the next coating is 48 h. Do not apply polyester putties, epoxy primers or acrylic clearcoat directly on the Protect 341.				
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. Choose the thinner according to the application temperature and the thinning ratio. THIN 50 STANDARD is recommended for 30% dilution and for application at high temperatures (23-25°C). THIN 50 FAST is recommended for 60% dilution and for application at low temperatures (15-18°C).				
COLOUR				
Beige.				
EQUIPMENT CLEANING				
NC solvent.				
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 341	12 months/20 °C
THIN 50	24 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.	