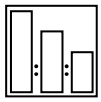
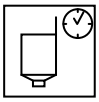
Technical Data Sheet
PROTECT 3600 PREMIUM HS
Acrylic primer

PROPERTIES	
PROTECT 3600 is a two component high build multipurpose primer, designed for use on multi-panel and overall refinishing. It may be applied as a conventional primer-filler, primer-surfacer and wet-on wet sealer. It provides easy applications, non-sag properties, good sandability. The product has a very good adhesion to various substrates.	
RELATED PRODUCTS	
HARDENER 3000/3600	Hardener for acrylic primer (64°- 86℉ / 18°- 30℃)
THIN 8500	Thinner for acrylic products (50°- 86℉ / 10°- 30℃)
SUBSTRATES	
Old paint coatings, including thermoplastic paints	Degrease, dry sand with P220 – P280, blow off, degrease again.
Body fillers	Dry sand, use P240 - P320 for final sanding, blow off, degrease.
Epoxy primers	Up to 12 hours without sanding, after 12 hours sand dry with P320, blow off, degrease.
Steel	Degrease and dry sand with P120.
Aluminium	Degrease, mat with an abrasive needled cloth, degrease again.
Galvanised steel	Degrease, mat with an abrasive needled cloth, degrease again.
Stainless steel	Degrease.
Wash primers	Apply after drying.
Polyester laminates	Degrease, dry sand with P280, blow off, degrease again.

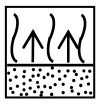
MIXING RATIO

		Primer Filler		Primer surfacer		Wet on wet sealer	
		Volume ratio	Weight ratio	Volume ratio	Weight ratio	Volume ratio	Weight ratio
	PROTECT 3600	4	100	4	100	4	100
	HARDENER 3000/3600	1	17	1	17	1	19
	THIN 8500	0.5	7.5	1	15	1.5	22

Apply the thinner in the amount calculated for the primer.

VISCOSITY				
		Primer Filler	Primer surfacer	Wet on wet sealer
	70°F /21℃ DIN #4 Zahn #2	 35 – 45 s 55 – 70 s	 25 – 35 s 37 – 55 s	 15 – 18 s 20 – 25 s

APPLICATION CONDITIONS
It is recommended to apply the primer at a temperature above 59℉/15 ℃ and a humidity of no more than 80 %.

APPLICATION				
 CAUTION: Instructions of the equipment manufacturer must be followed.	Conventional gravity fed spray gun	Tip size	Pressure	Distance
	Primer filler and surfacer Wet on wet sealer	1.6 ─ 2.0 mm 1.2 ─ 1.4 mm	43 ─ 58 psi 43 ─ 58 psi	6 ─ 8 inches 6 ─ 8 inches
	Low-pressure gravity fed HVLP spray gun			
	Primer filler and surfacer Wet on wet sealer	1.6 – 1.7 mm 1.4 – 1.6 mm	29 psi 29 psi	4 – 6 inches 4 – 6 inches
	Number of layers	1 ─ 3		
	Single dry layer thickness	Primer filler	Primer surfacer	Wet on wet sealer
		1.4 ─ 2.2 mils	1.0 ─ 1.6 mils	0.8 ─ 1.2 mils
	Mixture life at 68℉/ 20℃	30 min		
	Flash off time between layers at 68℉/20℃	5 ─10 min		

CURING TIMES		
	68℉/20℃	140℉/60℃
	3 hours	30 min
CAUTION: The curing times apply to the temperatures of the individual elements.		

IR DRYING		
	Distance	Follow the recommendations of the equipment manufacturer
	Time depending on the type and power of the lamp	10 ─20 min
CAUTION: Start IR heating no sooner than 10 mins after applying the last layer.		

SANDING		
	Dry sanding	P360 ─ P500
	Wet sanding	P600 ─ P1000

COLOUR
Grey.

TECHNICAL DATA			
Volume Ratio	4:1:0.5	4:1:1	4:1:1.5
Applicable Use Category	Primer	Primer	Primer
VOC (g/l)	512	540	569
VOC (lbs/gal)	4.27	4.51	4,75
Density (g/l)	1338	1300	1269
Density (lbs/gal)	11.2	10.9	10.6
Volatiles wt. %	38.4	41.9	45.0
Water wt. %	0.0	0.0	0.0
Exempt wt. %	0.0	0.0	0.0
Water vol. %	0.0	0.0	0.0
Exempt vol. %	0.0	0.0	0.0
Solids vol. %	41.8	38.3	35.4

STORAGE CONDITIONS
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.

SHELF LIFE	
PROTECT 3600	24 months at 68℉/20℃
HARDENER 3000/3600	12 months at 68℉/20℃
THIN 8500	24 months at 68℉/20℃

SAFETY
See Safety Data Sheet.

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 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.