











Technical Data Sheet
PROTECT 3500 2.1
Acrylic primer

PROPERTIES			
<p>PROTECT 3500 is a acrylic urethane two component high build primer, designed for use on multi-panel and overall refinishing. It provides easy applications, non-sag properties, good sandability. The product has a very good adhesion to various substrates. It is designed to meet the most stringent VOC regulations in both the U.S. and Canada.</p>			
RELATED PRODUCTS			
HARDENER 3500	Hardener for PROTECT 3500 (59° - 95 F / 15° - 35°C)		
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			
	PROTECT 3500 HARDENER 3500	Volume ratio	Weight ratio
		4	100
		1	20
Apply the thinner in the amount calculated for the primer.			
VISCOSITY			
	70°F /21°C		
	DIN #4	25 - 28 s	
	Zahn #2	30 - 35 s	
APPLICATION CONDITIONS			
It is recommended to apply the primer at a temperature above 59F/15 °C 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
		1.3 – 1.8 mm	43 – 58 psi	6 – 8 inches
	Low-pressure gravity fed HVLP spray gun	1.3 – 1.7 mm	29 psi	4 – 6 inches
	Number of layers	1 – 3		
	Single dry layer thickness	1.2 – 2.0 mils		
	Mixture life at 68°F/ 20°C	60 min		
	Flash off time between layers at 68°F/20°C	5 – 10 min		
CURING TIMES				
	68°F/20°C	140°F/60°C		
	3 hours	30 min		
CAUTION: The curing times apply to the temperatures of the individual elements.				
COATABILITY				
Coatable with waterborne and solventborne basecoats, and colour topcoats.				
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
Applicable Use Category	Primer
VOC Actual (g/l)	140
VOC Actual (lbs/gal)	1.17
VOC Regulatory (g/l) Less water less exempt	250
VOC Regulatory (lbs/gal) Less water less exempt	2.09
Density (g/l)	1430
Density (lbs/gal)	11.9
Volatiles wt. %	46.4
Water wt. %	0.0
Exempt wt. %	36.7
Water vol. %	0.0
Exempt vol. %	44.2
Solids vol. %	40.8
STORAGE CONDITIONS	
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.	
SHELF LIFE	
PROTECT 3500	24 months at 68°F/20°C
HARDENER 3500	12 months at 68°F/20°C
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.	