



Technical Data Sheet

POLYCOAT PROTECT 5:1

Anti-corrosion topcoat for underbody protection

RELATED PRODUCTS

**POLYCOAT PROTECT
HARDENER**






Anti-corrosion topcoat hardener



THINNER

Acrylic and polyurethane thinner

PROPERTIES

- A product designed and dedicated for renovation of classic cars
 - High yield
 - Excellent anti-corrosion properties
 - Excellent hiding power and flowability
- Excellent resistance to atmospheric conditions
 - Good chemical resistance
 - Good mechanical resistance

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.			
Old paint coatings	Mat and degrease.			
Polyester laminates	Mat and degrease.			
MIXING RATIO				
	POLYCOAT PROTECT 5:1 POLYCOAT PROTECT HARDENER THINNER	Volume ratio	Weight ratio	
		5	100	
		1	14	
		15%	9	
Apply the thinner in the amount calculated for the topcoat.				
VISCOSITY				
	DIN 6/20°C	28 – 36 s		
CONTENT OF VOLATILE ORGANIC COMPOUNDS				
VOC II/B/d limit*		420 g/l		
Actual VOC content (5+1+15%)		415 g/l		
* For ready to use mixture acc. to EU Directive 2004/42/CE				
APPLICATION CONDITIONS				
<p>The coated surface must be dry. The coat, coated surface and ambient temperatures must not be below +15°C; the relative humidity must not exceed 80%. The coated surface temperature must exceed the dew point by at least 3°C.</p>				
APPLICATION				
 <p>CAUTION: Instructions of the equipment manufacturer must be followed.</p>	Pneumatic spraying	Nozzle 1.6 – 1.8 mm	Pressure 2 – 4 bar	Distance 15 – 20 cm
	Airless spraying	0.33 – 0.38 mm (0.013" – 0.015")	100 – 180 bar Air jacket 2 bar	10 – 15 cm
	Number of layers	1 – 2		
	Single dry layer thickness	80-120 µm		
	The yield of the ready to use mixture for the given range of dry layer thickness	5.4 m ² /l at 100 µm		
	Mixture life at 20°C	2 h		

	Flash-off time between layers	10 – 15 min	
<p>In the case of applying POLYCOAT PROTECT 5:1 directly on steel to obtain the best anti-corrosion properties, it is recommended to secure the metal substrate with an epoxy primer.</p>			
<p>COLOUR</p>			
<p>Black.</p>			
<p>Gloss level</p>			
<p>Gloss at 60° ca. 50 NOTE: The gloss depends on the application method, the thickness of applied layers and the colour.</p>			
<p>TECHNICAL DATA</p>			
Product	Solids content by weight	Solids content by volume	Density
POLYCOAT PROTECT 5:1	≈ 72 – 77 %	≈ 59 – 64 %	≈ 1.42 – 1.47 g/cm ³
POLYCOAT PROTECT HARDENER	56 %	55 %	1.03 g/cm ³
POLYCOAT PROTECT 5:1 + POLYCOAT PROTECT HARDENER; 5+1	≈ 69 – 74 %	≈ 58 – 63 %	≈ 1.35 – 1.40 g/cm ³
<p>CURING TIME</p>			
	20°C	60°C	
Dust-free	30 min	10 min	
Tack-free	5 h	30 min	
Operating hardness	24 h	60 min	
Ending hardness	7 days	60 min + 1 day/20°C	
<p>CAUTION: The curing times apply to the temperatures of the individual elements.</p>			
<p>IR DRYING</p>			
	Distance	Follow the recommendations of the equipment manufacturer	
	Time depending on the type and power of the lamp	30 – 45 min	
<p>CAUTION: Start IR heating no sooner than 10 mins after applying the last layer.</p>			
<p>EQUIPMENT CLEANING</p>			
<p>THINNER acrylic and polyurethane thinner or NC solvent.</p>			



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STORAGE CONDITIONS	
Store in a dry and cool room, away from sources of fire and heat at 5-25°C. Avoid direct exposure to sunlight.	
SHELF LIFE	
POLYCOAT PROTECT 5:1	24 months/20°C
POLYCOAT PROTECT HARDENER	12 months/20°C
THINNER	24 months/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 trial/test application of the product due to the potential variation of product performance between substrate materials. We may not be held liable for defects if final results were affected by factors beyond our control.	

ADDITIONAL INFORMATION

WEIGHT QUANTITY OF COMPONENTS: POLYCOAT PROTECT 5:1; 5+1+15%

CAUTION! In order to obtain a primer with appropriate parameters it is very important to exactly dose the individual components.

Mixture quantity	POLYCOAT PROTECT 5:1	POLYCOAT PROTECT HARDENER	THINNER
0.10 l	106 g	15 g	10 g
0.15 l	159 g	23 g	15 g
0.20 l	212 g	30 g	19 g
0.25 l	265 g	38 g	24 g
0.30 l	318 g	46 g	29 g
0.40 l	424 g	61 g	39 g
0.50 l	530 g	76 g	49 g
0.75 l	794 g	114 g	73 g
1.00 l	1059 g	153 g	98 g