

**Technical Data Sheet**  
**PROTECT 3500 2.1**  
**Acrylic primer**

<b>PROPERTIES</b>					
PROTECT 3500 is a acrylic urethane two component 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.					
<b>RELATED PRODUCTS</b>					
HARDENER 3500 Standard	Hardener for PROTECT 3500 (64° - 95°F / 18° - 35°C)				
HARDENER 3500 Fast	Hardener for PROTECT 3500 (55° - 68°F / 13° - 20°C)				
THIN 2.1	Thinner for Acrylic Products 2.1 (59° - 95°F / 13° - 35°C)				
<b>SUBSTRATES</b>					
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 finishing pad, degrease again.				
Galvanised steel	Degrease, mat with an abrasive finishing pad, degrease again.				
Stainless steel	Degrease.				
Wash primers	Apply after drying.				
Polyester laminates	Degrease, dry sand with P280, blow off, degrease again.				
<b>MIXING RATIO</b>					
	PROTECT 3500 HARDENER 3500 THIN 2.1	Priming version		Wet on wet version	
		Volume ratio	Weight ratio	Volume ratio	Weight ratio
		4	100	4	100
		1	20	1	20
		0 – 0.4	0 - 8	1.2	24
Apply the thinner in the amount calculated for the primer.					

VISCOSITY									
	70°F /21°C		Priming version			Wet on wet version			
	DIN #4		24 - 32 s			16 - 19 s			
	Zahn #2		32 - 45 s			20 - 25 s			
APPLICATION CONDITIONS									
It is recommended to apply the primer at a temperature above 59°F/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	Priming version			Wet on wet version			
			Tip size	Pressure	Distance	Tip size	Pressure	Distance	
			1.3–1.8 mm	43 – 58 psi	6 – 8 inches	1.2 – 1.3 mm	43 – 58 psi	6 – 8 inches	
		Low-pressure gravity fed HVLP spray gun	1.3–1.7 mm	29 psi	4 – 6 inches	1.2 – 1.3 mm	29 psi	4 – 6 inches	
	Number of layers		1 – 3			1 – 2			
	Single dry layer thickness		1.2 – 2.0 mils			0.6 – 1.0 mils			
	Mixture life at 68°F/ 20°C		HARDENER 3500 Standard		HARDENER 3500 Fast		HARDENER 3500 Standard		HARDENER 3500 Fast
			60 min		15 min		60 min		20 min
	Flash off time between layers at 68°F/20°C		5 – 10 min			5 – 7 min			
CURING TIMES									
	Priming version				Wet on wet version				
	HARDENER 3500 Standard		HARDENER 3500 Fast		HARDENER 3500 Standard		HARDENER 3500 Fast		
	68°F/20°C	140°F/60°C	68°F/20°C	140°F/60°C	68°F/20°C	140°F/60°C	68°F/20°C	140°F/60°C	
	3 hours	30 min	2 hours	20 min	15 - 20 min	5 min	15 min	5 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  Time depending on the type and power of the lamp	Follow the recommendations of the equipment manufacturer  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	4 : 1 : 0,4	4 : 1 : 1,2
Applicable Use Category	Primer	Primer	Primer wet-on-wet
VOC Actual (g/l)	140	130	113
VOC Actual (lbs/gal)	1.17	1.08	0.94
VOC Regulatory (g/l) Less water less exempt	250	250	250
VOC Regulatory (lbs/gal) Less water less exempt	2.09	2.09	2.09
Density (g/l)	1430	1420	1390
Density (lbs/gal)	11.9	11.8	11.6
Volatiles wt. %	46.4	49.7	55.2
Water wt. %	0.0	0.0	0.0
Exempt wt. %	36.7	40.6	47.1
Water vol. %	0.0	0.0	0.0
Exempt vol. %	44.2	48.1	54.8
Solids vol. %	40.8	36.9	32.1
STORAGE CONDITIONS			
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.			

<b>SHELF LIFE</b>	
PROTECT 3500	24 months at 68°F/20°C
HARDENER 3500 Standard	18 months at 68°F/20°C
HARDENER 3500 Fast	12 months at 68°F/20°C
THIN 2.1	24 months at 68°F/20°C
<b>SAFETY</b>	
See Safety Data Sheet.	
<b>OTHER INFORMATION</b>	
<p>Registration number: 000024104.</p> <p>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.</p>	