valspar
INDUSTRIAL MIX

System Technique

Nº 34-34

Primer	**FP440**	**Epoxy Primer Basic Grey**	TDS–Nr.: FP440/UK
Topcoat	**TB350**	**Synthetic Fast Drying Topcoat HG**	TDS-Nr.: TB350/UK

Preparation and Pre-treatment

Steel, cast iron, aluminum, galv. steel, glass fiber reinforced plastic, for plastic substrates – after suitability and adhesion test, use FP600 Plastic Primer.
Hardened, solvent resistant surfaces, sanded original- and old paintwork.

The durability of the coating system largely depends on the thoroughness of the preparation of the surface (for more detailed information about preparing, see the Technical Information “Preparation and Pre-treatment”).

For more Information see our Technical Data Sheets.

Characteristics

2K Epoxy Primer
1K Synthetic Topcoat

Total layer thickness: 80-160µm

Application

Convertional spray gun

Primer

Product		Mixing ratio (Volume)	Layers	Dry times
FP440	Epoxy Primer “Basic” Grey	5	1-2 40-140µm	Dust dry: 10-15 min./20°C Recoatable: 1-48 hours/20°C Dry: 10-16 hours/20°C Force-dry: 40-50 min./60°C
AP404	Epoxy Activator	2		
RS405	Epoxy Reducer	+ 10-25%		

For larger objects or areas with higher temperatures use RS407 Epoxy Reducer Slow.
Wet on wet application 1 layer 40-60µm respraying with Topcoat after 1 hour.
Higher thicknesses possible (up to 140µm) if given extended drying times, respray with topcoat after 10 hours.
After 48 hours please, sand again.

Topcoat

Product		Mixing ratio (Volume)	Layers	Dry times
TB350	Synthetic Fast Drying Topcoat High Gloss	100 parts	2 40-50µm	Dust dry: 15‘-30‘/20°C Dry to assembly: 1-2 hours/20°C Dry: 24 hours/20°C Force-Dry: 20‘- 30‘/60°C
RS300	Synthetic Reducer	15-30%		

N.C. Reducer RS330 can also be used.
For a higher chemical- and weather resistance also for faster curing, use Activator AU500 or AU575 by 5-10% and the amount of Reducer.
Possibility with AD300 Synthetic Matting Agent, too.
Other Synthetic Topcoats: TB330, TB332 and TB350

Please, see the TDS for more information.

Information:

If you want to weigh the components by balance, please use our VIM-CRS software.
For airless or air mix processing, follow the instructions on our technical data sheet.
Further Information about the products mentioned can be found in our technical data sheets.