

Primer	FP440	Epoxy Primer Basic Grey	TDS-Nr.: FP440/UK
Topcoat	TB520	PU Topcoat „Basic“ High Gloss	TDS-Nr.: TB520/UK

Preparation and Pre-treatment	Characteristics
<p>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.</p> <p>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”).</p> <p>For more Information see our Technical Data Sheets.</p>	2K Epoxy Primer
	2K PU Topcoat “Basic”
	Total layer thickness: 100-160µm
	Application
	Conversional 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.
Other Epoxy primers: FP400 (grey) and FP401 (white)
After 48 hours please, sand again.

Topcoat				
Product		Mixing ratio (Volume)	Layers	Dry times
TB520	PU Topcoat Basic High Gloss	6 parts	2 40-60µm	Dust dry: 12-20 min./20°C Dry to assembly: 4-7 hours/20°C Dry: 10-12 hours/20°C Force-dry: 20-40 min./60°C
AU500	Polyurethane Activator	1 part		
RS605	Universal Reducer	+20-35%		

For a faster process of drying use AA600 Accelerator (max.3%), to dispense with the amount of Reducer.
Drying and curing is according to use of the wide range of Activator and Reducer.
Possible HS Hardeners: AU577 Extra Fast, AU576 Fast, AU575 Standard and AU574 Slow (mixing ratio is the same).
Please, see the TDS for more information.

Information:
<p>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. For recommended layer thickness, as per ISO 12944, see the information sheet TI-G9.</p>