valspar
INDUSTRIAL MIX

System Technique
No. 54-27

ISO 12944	
C4	> 15 years
C5 I/M	> 15 years

Primer	**FP400**	**Epoxy Primer Grey**	TDS No.: FP400/UK
Topcoat	**TB510 + AD600**	**PU Topcoat DTM High Gloss High Build Additive**	TDS No.: AD600/UK

Preparation and Pre-treatment

Iron, steel, cast iron, galvanized steel, aluminium, glass fibre reinforced plastic. Hardened, solvent resistant surfaces, sanded original and old paintwork. For plastic substrates – after suitability and adhesion test, use FP600 Plastic Primer. When adding the additive AD600, the colour of the topcoat changes (slightly) and the gloss will reduce.

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 Information and Data Sheets.

Characteristics

2K Epoxy Primer
2K PU Topcoat DTM + High Build
Additive
Total layer thickness: 150-300µm

Application

Conversion gun
Airless, Airmix

Primer

Product		Mixing ratio (Volume)	Layers	Dry times
FP400	Epoxy Primer Grey	3 parts	1-2 40-80µm	Dust dry: 20 min/20°C Recoatable: 1-48 hours/20°C Dry: 10-16 hours/20°C Force dry: 30-40 min/60°C
AP401	Epoxy Activator	1 part		
RS405	Epoxy Reducer	+ 10-50%		

As Sanding Primer use 10-30% Epoxy Reducer.
Wet on wet application use 35-50% Epoxy Reducer / 1 layer 30-40µm.
After 48 hours, please sand again.
FP401 Epoxy Primer DTM is the same product, only the colour is white.

Topcoat

Product		Mixing ratio (Volume)	Layers	Dry times
TB510	PU Topcoat DTM High Gloss	5 parts	2-4 75-200µm	Dust dry: 2-4 hours /20°C Dry to assembly: 6-10 hours/20°C Dry: 24-48 hours/20°C Force dry: not recommended
AU500	PU Activator	1 part		
AD600	High Build Additive	+ 20-80%		
RS605	Universal Reducer	+ 10-20%		

For a faster drying process, use the AA600 Accelerator (max. 3%), to be dispensed with the amount of Reducer.
Please see the TDS for more information.

Information:

If you want to weigh the components using scales, please use our CRS software.
For airless or air assisted 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.