valspar
INDUSTRIAL MIX

System Technique

Nº 54-27

Primer	**FP400**	**Epoxy Primer Grey**	TDS–Nr.: FP400/UK
Topcoat	**TB510**	**PU Topcoat DTM High Gloss**	TDS–Nr.: TB510/UK
+ Additive	**AD600**	**High Build Additive**	TDS–Nr.: AD600/UK

Preparation and Pre-treatment

Steel, stainless steel (blasted), cast iron, galvanized steel, aluminum, glass fiber reinforced plastic. 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 Information- and Data Sheets.

Characteristics

2K Epoxy Primer
2K PU Topcoat DTM + High Build Additive
Total layer thickness: 100-240µm

Application

Convertional spray gun,

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	+ 10-40%		

For larger objects or areas with higher temperatures use RS407 Epoxy Reducer Slow.
As Sanding Primer use 10-25% Epoxy Reducer. Wet on wet application use 25-40% Epoxy Reducer / 1 layer 30-40µm.
After 48 hours please, sand again.
FP401 Epoxy Primer DTM is the same product only the color is white.
For higher layer thickness use Epoxy Primer FP440 Grey up to 140µm.

Topcoat

Product		Mixing ratio (Volume)		Layers	Dry times
TB510	PU Topcoat DTM	100 parts	5 parts	2-4 100-240µm	Dust dry: 1-2 hours/20°C Dry: 24 hours/20°C Force-dry: 30-40 min./60°C
AD600	High Build Additive	10-50 parts			
AU500	Polyurethane Activator		1 part		
RS605	Universal Reducer		+ 10-20%		
Or (with more AD600 High Build Additive)					
TB510	PU Topcoat DTM	100 parts	6 parts	2-4 100-240µm	Dust dry: 1-2 hours/20°C Dry: 24 hours/20°C Force-dry: 30-40 min./60°C
AD600	High Build Additive	51-100 parts			
AU500	Polyurethane Activator		1 part		
RS605	Universal Reducer		+ 10-20%		

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).
Other DTM Topcoats: TB511 Semi-Gloss (54-37), TB512 Matt (54-47).

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.
For recommended layer thickness, as per ISO 12944, see the information sheet TI-G9.