

<b>Primer</b>	<b>FP402</b>	<b>Epoxy Primer Zinc Rich</b>	TDS-Nr.: FP402/UK
<b>Primer</b>	<b>FP400</b>	<b>Epoxy Primer Grey</b>	TDS-Nr.: FP400/UK
<b>Topcoat</b>	<b>TB510</b>	<b>PU Topcoat DTM High Gloss</b>	TDS-Nr.: TB510/UK

Preparation and Pre-treatment	Characteristics
Steel – only blasted metal surfaces (SA 2½).	2K Epoxy Primer Zinc rich
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”).	2K Epoxy Primer
For more Information see our Technical Information- and Data Sheets.	2K PU Topcoat DTM
	Total layer thickness: 140-240µm
	<b>Application</b>
	Conversional spray gun,
	Airless, Airmix (Primer only)

Primer				
Product		Mixing ratio (Weight)	Layers	Dry times
FP402	Epoxy Primer Zinc Rich Grey	1000 g	1-2 40-80µm	Dust Dry: 20 min./20°C Recoat: 60'/20°C Dry: 10-16 hours/20°C Force-dry: 30-40 min./60°C
AP402	Epoxy Activator	84 g		
RS405	Epoxy Reducer	25-60 g		
For larger objects or areas with higher temperatures use RS407 Epoxy Reducer Slow. After 48 hours please, sand again.				

Primer				
Product		Mixing ratio (Volume)	Layers	Dry times
FP400	Epoxy Primer Grey	3 parts	1-2 40-80µm	Dust Dry: 20 min./20°C Recoat: 60 min./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. After 48 hours please, sand again. FP401 Epoxy Primer DTM is the same product only the color is white. For higher thickness use FP440 Epoxy Primer Grey up to 140µm. For the best Quality and a smooth surface – sand the cured Primer with Orbital sander P320-P400.				

Topcoat				
Product		Mixing ratio (Volume)	Layers	Dry times
TB510	PU Topcoat DTM High Gloss	5 parts	2 50-80µm	Dust dry: 2-3 hours/20°C Dry to assembly: 6-9 hours/20°C Dry: 24 hours/20°C Force-dry: 30-40 min./60°C
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) and TB512 (matt).  
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.