

<b>Primer</b>	<b>FP402</b>	<b>Epoxy Primer Zinc Rich</b>	TDS No.: FP402/UK
<b>Primer</b>	<b>FP400</b>	<b>Epoxy Primer Grey</b>	TDS No.: FP400/UK
<b>Topcoat</b>	<b>TB510</b>	<b>PU Topcoat DTM High Gloss</b>	TDS No.: TB510/UK

Preparation and Pre-treatment	Characteristics
Iron, steel – only blasted metal surfaces (SA 2½).	2K Epoxy Primer Zinc rich
	2K Epoxy Primer
	2K PU Topcoat DTM
	Total layer thickness: 140-250µm
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”).	<b>Application</b>
	Conversion gun
	Airless, Airmix
For more information see our Technical Information and Data Sheets.	

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 Recoatable: 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		
As Sanding Primer use 25-40g Epoxy Reducer. Wet on wet application use 40g Epoxy Reducer / 1 layer 30-40µm. 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 Recoatable: 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	+ 10-50%		

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.**

For the best quality and a smooth surface – sand after the drying time with Excenter machine P320-P400.

Topcoat				
Product		Mixing ratio (Volume)	Layers	Dry times
TB510	PU Topcoat DTM High Gloss	5 parts	2 50-100µm	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 drying process, use the AA600 Accelerator (max. 3%), to be dispensed with the amount of Reducer. Please see the TDS for more information.

Information:
<p>If you want to weigh the components using scales, please use our VIM-CRS software.</p> <p>For airless or air assisted processing, follow the instructions on our technical data sheet.</p> <p>Further information about the products mentioned can be found in our technical data sheets.</p> <p>For recommended layer thickness, as per ISO 12944, see the information sheet TI-G9.</p>