

Primer	FP500	PU Primer Grey	TDS-Nr.: FP500/UK
Topcoat	TB511	Fleet-Coat Matt Topcoat	TDS-Nr.: TB532/UK
+ Additive	AD602/600	Texture- and High Build Additive	TDS-Nr.: AD600/602/UK

Preparation and Pre-treatment	Characteristics
<p>Steel, stainless steel (blasted), cast iron, galvanized steel, aluminum, glass fiber reinforced plastic. Hardened, solvent resistant surfaces, sanded original- and old paintwork. For plastic substrates – after suitability and adhesion test, use FP600 Plastic Primer.</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 Information- and Data Sheets.</p>	2K PU Primer
	2K PU Topcoat Semi-Gloss
	Total layer thickness: 100-140µm
	Application
	Conventional spray gun,

Primer				
Product		Mixing ratio (Volume)	Layers	Dry times
FP500	PU Primer Grey	8 parts	1-2 40-80µm	Dust dry: 15- 30 min./20°C Recoatable: 1-2 hours/20°C Dry: 8-10 hours/20°C Force-dry: 20-30 min./60°C
AU500	PU Activator	1 part		
RS605	Epoxy Reducer	+ 10-25%		
<p>For a faster process of drying use AA600 Accelerator (max.3%), to dispense with the amount of Reducer.</p> <p>Drying and curing is according to use of the wide range of Activator and Reducer.</p> <p>Possible HS Hardeners for non-sanding: AU577 Extra Fast or AU576 Fast (<40µm after 1 hour). For larger Objects use HS Hardener AU575 Standard (<40µm) flash-off 2-3 hours before spray topcoat (mixing ratio is the same).</p> <p>After 48 hours please, sand again.</p> <p>PB500 PU Primer DTM “tintable” is the same product, select from CRS (colour retrieval system) the requested Color and follow the instruction.</p>				

Topcoat				
Product		Mixing ratio (Volume)		Dry times
TB511	PU Topcoat DTM Semi-Gloss	2 parts	5	Dust dry: 20-30 min./20°C Dry to assembly: 4-5 hours/20°C Dry: 24hours/20°C Force-dry: 30-40 min./60°C
AD602	Texture Additive “Coarse”	1 part		
AD600	High Build Additive	1 part		
AU500	Polyurethane Activator		1 part	
RS605	Universal Reducer		+ 15-30%	

<p>Layer thickness is not possible to measure!</p> <p>For a faster process of drying use AA600 Accelerator (max.3%), to dispense with the amount of Reducer.</p> <p>Drying and curing is according to use of the wide range of Activator and Reducer.</p> <p>Possible HS Hardeners: AU577 Extra Fast, AU576 Fast. AU575 Standard and AU574 Slow (mixing ratio is the same).</p> <p>Other DTM Topcoats: TB510 (high gloss) and TB512 (matt)</p> <p>Please, see the TDS for more information.</p>

Information:
<p>If you want to weigh the components by balance, please use our VIM-CRS software.</p> <p>For airless or air mix 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>