

<b>Primer</b>	<b>FP640</b>	<b>Etch Primer</b>	TDS-Nr.: FP640/UK
<b>PU Surfacer</b>	<b>FP510</b>	<b>HS Surfacer Performance</b>	TDS-Nr.: FP510/UK
<b>Topcoat</b>	<b>TB500</b>	<b>PU Topcoat "Performance" High gloss</b>	TDS-Nr.: TB500/UK

Preparation and Pre-treatment	Characteristics
Steel, cast iron, galvanized steel, aluminum, glass fiber reinforced plastic. Hardened, solvent resistant surfaces, sanded original- and old paintwork. Recommended for high level paint work for Commercial transportation.	2K Etch Primer
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 PU Surfacer
For more Information see our Technical Information- and Data Sheets.	2K Topcoat
	Total layer thickness: 100-180µm
	<b>Application</b>
	Conventional spray gun,

Primer				
Product		Mixing ratio (Volume)	Layers	Dry times
FP640	Etch Primer	1 part	1 10-20µm	Dust dry: 5 min./20°C
AP640	Etch Primer Hardener	1 part		Dry: 15 minutes/20°C Force-dry: N/A

Recoat after 15-20 minutes.

**Do not spray topcoat on etch primer - a between PU Primer layer is necessary!**

PU Surfacer				
Product		Mixing ratio (Volume)	Layers	Dry times
FP510	HS Surfacer Performance Grey	7 parts	1-3 40-140µm	Dust dry: 15 min./20°C
AU500	PU Activator	1 part		Dry: 4-6 hours/20°C
RS610	Extended Potlife Reducer	10-25%		Force-dry: 20-30 min./60°C

If a short potlife (<20 min.) sufficient use Universal Reducer RS605 or RS607.

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 6:1 10-25%).  
FP511 HS Surfacer Performance is the same product, the color is White.

After full drying/curing sand the surface with P320-P400.

Topcoat				
Product		Mixing ratio (Volume)	Layers	Dry times
TB500	PU Topcoat Performance High Gloss (VOC <420g/l)	4 parts	2 40-65µm	Dust dry: 60-90 min./20°C
AU500	Polyurethane Activator	1 part		Dry to assembly: 5-7 hours/20°C
RS605	Universal Reducer	max. 5%		Dry: 24 hours/20°C Force-dry: 30-40 min./60°C

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).

Information:
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.