

<b>Primer</b>	<b>FP620</b>	<b>Wash Primer Grey</b>	TDS No.: FP620/UK
<b>Surfacer</b>	<b>FP510</b>	<b>HS Surfacer Grey</b>	TDS No.: FP510/UK
<b>Topcoat</b>	<b>TB500</b>	<b>PU Topcoat Performance High Gloss</b>	TDS No.: TB500/UK

Preparation and Pre-treatment	Characteristics
Iron, steel, stainless steel (substrate blasted), cast iron, galvanized steel, aluminium, glass fibre reinforced plastic. Hardened, solvent resistant surfaces, sanded original and old paintwork. Recommended for high level paint work for commercial transportation. 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").	1K Wash Primer
	2K HS Surfacer
	2K PU Topcoat
	Total layer thickness: 100-160µm
For more information see our Technical Information and Data Sheets.	<b>Application</b>
	Conversion gun
	<b>HS420 System VOC compliant!</b>

Primer				
Product		Mixing ratio (Volume)	Layers	Dry times
FP620	Wash Primer Grey	4 parts	1 or ½ +1 10-20µm	Dust dry: 5 min/20°C Dry: 15 minutes/20°C Force dry: N/A
RS605	Universal Reducer	1 part		
Recoatable after 20 minutes. After 24 hours, please sand again. <b>Do not respray with Epoxy Primer or Epoxy Products!</b>				

HS Surfacer (recommended as sanding product)				
Product		Mixing ratio (Volume)	Layers	Dry times
FP510	HS Surfacer Grey	7 parts	1-2 40-140µm	Dust dry: 15 min/20°C Dry: 4-6 hours/20°C Force dry: 20-30 min/60°C
AU500	Polyurethane Activator	1 part		
RS610	Extended Potlife Reducer	+20-25%		

For a short pot life (20 min), the Universal Reducer RS60x is recommended.  
 After drying, sand the surface with P320 or P400, re-coat within 12 hours.

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 Dry to assembly: 5-7 hours/20°C Dry: 24 hours/20°C Force dry: 30-40 min/60°C
AU500	Polyurethane Activator	1 part		
RS605	Universal Reducer	max. 5%		

For a faster drying process, use the AA600 Accelerator (max. 3%), to be dispensed with the amount of Reducer.  
 Possibility to use AD601 Texture Additive "Fine" and AD602 Texture Additive "Coarse".

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.