

Primer	FP400	Epoxy Primer	TDS No.: FP400/UK
Basecoat	IC	Basecoat Solvent (Industrial Coating)	TDS No.: IC/UK
Clear Coat	CC710	HS420 Clear Coat Performance	TDS No.: CC710/UK

Preparation and Pre-treatment	Characteristics
<p>Iron, steel, stainless steel (blasted), cast iron, galvanized steel, aluminium, glass fibre 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 Epoxy Primer
	Basecoat Solvent
	HS420 Clear coat
	Total layer thickness: 140-180µm
	Application
	Conversion gun

Primer (airless, airmix application possible)			
Product	Mixing ratio (Volume)	Layers	Dry times
FP400	Epoxy Primer Grey	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		
RS405	Epoxy Reducer		

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.

Basecoat Solvent			
Product	Mixing ratio (Volume)	Layers	Dry times
IC	Industrial Coating Solvent	2-3 15-25µm	Flash off: 5-15 min/20°C Before clear coat: 20-30 min/20°C
RS605	Universal Reducer		

If necessary, apply a dust coat (orientation of effect pigments).
Use slower Universal Reducer (RS607 or RS609) for higher temperature.

Clear coat			
Product	Mixing ratio (Volume)	Layers	Dry times
CC710	HS420 Clear coat Performance	2 50-70µm	Dust dry: 60 min/20°C Dry to assembly: 4-6 hours/20°C Dry: 12-16 hours/20°C Force dry: 30-40 min/60°C
AU575	HS Activator Standard		
RS605	Universal Reducer		

For a faster drying process, the HS Activator Fast (AU576) is available.

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