

Primer	FP620	Washprimer Grey	TDS No.: FP620/UK
Primer	FP510	HS Surfacer	TDS No.: FP510/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>	1K Washprimer
	2K HS Surfacer
	Basecoat Solvent
	HS420 Clear coat
	Total layer thickness: 140-240µm
	Application
	Conversion gun

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		

Recoat after 20 minutes.
After 24 hours, please sand again.
Do not respray with Epoxy Primer or Epoxy Products!

PU Primer – Grey (or tintable PB500)				
Product		Mixing ratio (Volume)	Layers	Dry times
FP510	HS Surfacer Grey	7 parts	1-3 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		
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.

Basecoat Solvent				
Product		Mixing ratio (Volume)	Layers	Dry times
IC	Industrial Coating Solvent	1 part	2-3 15-25µm	Flash off: 5-15 min/20°C Before clear coat: 20-30 min/20°C
RS605	Universal Reducer	1 part		

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	3 parts	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	1 part		
RS605	Universal Reducer	max. 5%		

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

Information:

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.