

## Product Information

**Product Description:**

FP420 Epoxy Primer/Sealer Gray, FP421 Epoxy Primer/Sealer White, and FP422 Epoxy Primer/Sealer Black are a two pack polyamide cured epoxy primer/sealer formulated for superior adhesion with maximum resistance to moisture, chemical and corrosive environments.

**Substrates:**

Properly prepared steel, iron, cast iron, galvanized steel, aluminum surfaces, Industrial OEM and solvent resistant surfaces, sanded, cleaned original and old cured coatings.

**Preparation:**

Dry Sanding substrate: Steel: P80 – P180 / Aluminum: P180 – P240

Dry Sanding Coating: Existing finishes: P220 – P280

Steel: Abrasive blast to SSPC and NACE recommendation with a uniform blast profile of 0.7 to 2.0mil (20-50µm).

Galvanized: Sweep Blasting recommended.

**Note:** The layer thickness of the Primer should be three (3) times more than the grade of the shot blasted surface.

(More Detailed information go-to Preparation and Pre-treatment at [www.valsparindustrialmix.com](http://www.valsparindustrialmix.com))

**Cleaning:**

Surface must be dry and free from any contamination, e.g. oil, grease, release agents. Use only approved cleaning products per your local regulations. (More Detailed information go-to cleaning processes at [www.valsparindustrialmix.com](http://www.valsparindustrialmix.com))

**Topcoats:**

TB230 – Acrylic Enamel 3.5 VOC High Gloss

TB400 – Epoxy Enamel High Gloss

TB540 – Polyurethane Enamel 3.5 VOC High Gloss

TB543 – Polyurethane Enamel 3.5 VOC Semi Gloss

TB550 – Polyurethane Enamel 2.8 VOC High Gloss

**Physical Data:**

RTS REGULATORY DATA	10:1 +0-10%		10:1 +0-10%	
	(Reducer Line)		(Exempt Reducer Line)	
	LBS/GAL	g/L	LBS/GAL	g/L
Actual VOC	4.6 Max.	550 Max.	3.5 Max.	420 Max.
Regulatory VOC (less water and exempt solvents)	4.6 Max.	550 Max.	3.5 Max.	420 Max.
Density	8 - 13	960 - 1560	10 - 13	1200 - 1560
	WT.%	VOL.%	WT.%	VOL.%
Total Volatile Content	20 - 40	40 - 60	30 - 45	50 - 65
Water Content	0	0	0	0
Exempt Compound Content	0 - 5	0 - 5	0 - 10	0 - 10
<b>Physical properties:</b>				
Chemical base	Epoxy Primer/Sealer	Coverage (sq ft - DFT)	Approx. 799sq ft / 1.0mil	
Density lbs/gal (kg/l)	12.33 lbs/gal (1.48 kg/L)	Gloss	Matt	
Volume solids (%)	49%	Color	Gray/White/Black	
Weight Solids (%)	79%	Temperature Stability	Dry Heat up to 284°F/140°C	
Flash point	81.5°F (27.5°C)	Processing temperature	50 – 100°F (+10°C - 38°C)	
Pot life / 77°F (+25°C)	Approx. 8 - 10 hours	Humidity	Until 80% R.H.	
Shelf life	Min. 24 month under normal storage conditions and unopened tins			

## Application Data

	<b>Cleaning:</b> Use only approved products per your local regulations	Steel, Primed or existing finishes – Valspar 155 SunPrep Cleaner Aluminum, Primed or existing finishes – 170 AquaClean Low VOC WaterBase All metal substrates and existing finishes – AD680 Water Based Cleaner Surface must be cleaned, dry and free from any contamination, e.g. oil, grease	
	<b>Preparation:</b>	<b>Dry sanding substrate:</b> Steel P80 – P180 / Aluminum P180 – P240 <b>Dry sanding coating:</b> Existing finishes P220 – P280 <b>Galvanized:</b> Sweep blasting recommended <b>Abrasive blast:</b> with a uniform blast profile of 0.7 to 2mil (20-50µm)	
	<b>Before using:</b> The product must be shaken and thoroughly stirred directly after the Activator and Reducer have been added.		
	<b>Mixing stick:</b> Use the mixing stick	<b>M5 10:1</b> (74-205=8:1/10:1) or <b>M6</b> (74-206 standard) / <b>M7</b> (74-207 large) Universal cm-stick	
	<b>US National Rule:</b> If used as instructed, this product is designed to comply with the US National Volatile Organic Compound (VOC) Emission Standard for Automobile Refinish Coatings. Confirm compliance with state and local air quality rules before use.		
	<b>Mixing ratio with Activator and Reducer:</b> (By volume)	FP420 Epoxy Primer/Sealer Gray or FP421 Epoxy Primer/Sealer White or FP422 Epoxy Primer/Sealer Black AP420 Epoxy Activator RS6x0 Reducer Solvent (RS670/680/690) or RE6x0 Exempt Reducer (RE670/680/690) (Rx670 Fast / 680 Medium / 690 Slow)	10 parts  1 part + 0-10%
	<b>USA VOC Compliant rules:</b>	For VOC 3.5 compliant use Exempt Reducer RE6x0. For VOC national rule use Solvent Reducer RS6x0 (listed above).	
	<b>Viscosity:</b> 22 – 28 sec. (DIN4/68°F/20°C)		
	<b>Gun set up:</b> Gravity Feed Siphon Feed HVLP (Gravity Feed) Pressure Pot Airless / and with air support Atomizing Air Pressure	<b>Nozzle / Tip Size:</b> 1.5 – 1.9 mm 1.6 – 1.9 mm 1.3 – 1.5 mm 1.1 – 1.4 mm 013" - .017"	<b>Air Pressure:</b> 35-40 psi (2.5-2.8 bar) 35-45 psi (2.5-3.1 bar) 30 psi (2.0 bar) <b>Inlet Air</b> 35-40 psi (2.5-2.8 bar) 900 – 1200 psi (60-80 bar) 55-65 psi (3.8-4.5 bar)
	<b>Application:</b>	<b>Sealer /wet on wet</b> 1 full wet coat	<b>Sanding Primer</b> 2 – 3 medium wet coats Allow each coat to flash dull before applying the next coat
	<b>Recommended Film Thickness:</b>	1.0 – 1.6mil / 25 – 40 µm (DFT)	1.6 – 3.0mil / 40 – 75µm (DFT)
	<b>Clean up:</b> (check the local regulations!)	RS6x0 Reducer Solvent or RE6x0 Exempt Reducer	

	<b>Flash between coats at 77°F/25°C:</b>	<b>Sealer / wet on wet</b> NA	<b>Sanding Primer</b> 10 minutes or until previous coat has flashed dull
	<b>Air-dry at 77°F/25°C:</b> (DFT dependent)	<b>Print Free:</b> 1 – 3 hour <b>To Topcoat:</b> without sanding 30 minutes until maximum 72 hours, after 72 hours FP420 must be scuffed or sanded <b>Dry to sand:</b> 8 - 12 hours	
	<b>Force-dry at 140 – 158°F:</b> (60°C – 70°C)	<b>Sealer /wet on wet</b> NA	<b>Sanding Primer</b> 30 – 40 minutes 140°F/60°C object temperature
	<b>Recoatable:</b> (see Technical Data Sheets)	TB230 – Acrylic Enamel 3.5 VOC High Gloss TB400 – Epoxy Enamel High Gloss TB540 – Polyurethane Enamel 3.5 VOC High Gloss TB543 – Polyurethane Enamel 3.5 VOC Semi Gloss TB550 – Polyurethane Enamel 2.8 VOC High Gloss	
	<b>Use suitable respiratory protection (the use of fresh air supply respirator recommended).</b>		
	<p><b>Precautions:</b> During application all health and safety measures referring to the use and handling of coating materials are to be observed, e. g. existing regulations issued by the trade associations in the Chemical Industry. For Health and Safety information please refer the Material Safety Datasheet (MSDS). Information also available at <a href="http://www.valsparindustrialmix.com">www.valsparindustrialmix.com</a></p> <p><b>Note:</b> The products listed are intended only for the professional user and for professional use. All recommendations in words and writing given on the use of our products to customers or users are not binding and do not give reasons for secondary obligations resulting from the bill of sale. Every care is taken to ensure that the technical information provided is accurate and up to date according to the present state of knowledge in science and our experience. These recommendations do not, however, exempt the customer from autonomously checking whether our products are suitable for the intend purpose. The durability of the coating system largely depends on the thorough preparation of the surface. Furthermore our universal terms of delivery and payment are applicable.</p> <p>With the publication of this Technical Data Sheet all previous versions regarding this product are no longer valid.</p>		

If used as instructed, this product is designed to comply with the US National Volatile Organic Compound (VOC) Emission Standard for Automobile Refinish Coatings. Confirm compliance with state and local air quality rules before use. The data on this sheet represent typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Valspar assumes no obligation or liability for use of this information. **UNLESS VALSPAR AGREES OTHERWISE IN WRITING, VALSPAR MAKES NO WARRANTIES, EXPRESS OR IMPLIED, AND DISCLAIMS ALL IMPLIED WARRANTIES INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE OR FREEDOM FROM PATENT INFRINGEMENT. VALSPAR WILL NOT BE LIABLE FOR ANY SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES.** Your only remedy for any defect in this product is the replacement of the defective product, or a refund of its purchase price, at our option.