EMEAI Valspar bv
Zuiveringweg 89
8243 PE Lelystad
The Netherlands
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www.valsparindustrialmix.com

Product Information

Product Description:
FP440 is a grey 2K Epoxy Primer for good corrosion protection, excellent adhesion properties with good air- and force dry capabilities. This product forms a layer which has strong resistance to aggressive chemical agents, solvents, salt- and fresh water. FP440 can be used as wet on wet at 40-60µm and respray with topcoat after 60 minutes, or higher thicknesses up to 140µm. For higher film thickness from 60-140µm allow at least 10 hours flash-off time, topcoat interval is up to 48 hours. Epoxy primer needs recoating with topcoat.

Preparation:
For more detailed information go-to TI-Substrate and Pre-treatment on Colour Retrieval System (CRS) or website www.valsparindustrialmix.com/emea/en/.

Substrates:

Steel, stainless steel (blasted), cast iron, galvanized steel, aluminium, glass fibre reinforced plastics.
Other: Solvent resistant surfaces, cleaned/sanded/hardened original and cured coatings.

Iron/steel: Abrasive shot blasting is recommended or dry sanding P80 – P180
Aluminum: P180 – P240
Galvanized: Sweep blasting recommended
Paint finishes: P240 – P320 (Please, check and change abrasive paper regularly as required)

Cleaning: Surface must be dry and free from any contamination, e.g. oil, grease & release agents. Use RS405 Epoxy Reducer, RS605/607/609 Universal Reducer for metal substrates or AD690 Degreaser Solvent Based for metal substrates/GFR/paint finishes.

Material Description: FP440				
Application Method	Minimum DFT µm	Maximum DFT µm	Minimum WFT µm	Maximum WFT µm *
Spraying equipment	40µm	140µm	60µm	180µm

* Higher thicknesses possible if given extended drying times

Topcoat: Primer: FP500/PB500 PU Primer or FP510/FP511 HS Surfacer
Synthetic Topcoat: TB300/TB330/TB332/TB350
PU Topcoat: TB500/TB510/TB511/TB512/TB520/TB530/TB532/TW518 or TY518.

For more detailed information go-to Technical Data Sheets.

Physical properties:

Chemical base	Epoxy
Density (kg/l)	1.520 kg/l
Volume solids (%)	52,5%
Weight Solids (%)	71,1%
Flash point	28,5°C
Pot life (+20°C)	Approx. 3 – 5 hours
Shelf life	Min. 24 month under normal storage conditions in unopened tins
Theoretical Coverage (m²/L)	Approx. 13,1m²/L 40µm / 70% = 9,1m²/L 40µm (DFT)
Gloss	Matt
Color	Grey
Temperature Stability	Dry Heat up to 150°C
VOC (g/l)	Max. 440g/l see CRS (VOC: 2004/42/IIB(c)540g/l)
Processing temperature	+10°C till max. +40°C, max. Humidity 80%

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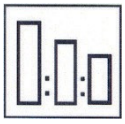
Application Data

 	**Preparation/ Cleaning:**	**All surfaces must be properly abrasive blasted or sanded and cleaned** Abrasive blast to EN ISO 12944, part 4 (SA 2.5) with a uniform blast profile. Dry sanding Steel: P80 – P180 Aluminum: P180 – P240 Galvanized: Sweep blasting recommended Paint finishes: P240 – P320 Cleaning: RS405/RS407, RS605/607/609 (metal surface) and/or AD690 Degreaser Solvent Based (paint finishes) Surface must be dry and free from any contamination, e.g. oil, grease	
	**Handling:**	**Before use/spraying:** 1. Mix mechanically (paint shaker/ mechanical/pneumatic stirrer) until homogeneous 2. Add Activator and Reducer 3. Stir this mixture well with a mixing stick or a (pneumatic) stirrer	
	**Mixing ratio with Activator and Reducer – 60-140µm:** (By volume)	FP440 Epoxy Primer **Basic - G**rey AP404 EP Activator RS405 Epoxy Reducer or RS407 Epoxy Reducer Slow	5 parts 2 parts add 10 – 25%
	**Mixing ratio with Activator and Reducer – wet/wet version:** (By volume) **40-60µm**	FP440 Epoxy Primer **Basic - G**rey AP404 EP Activator RS405 Epoxy Reducer or RS407 Epoxy Reducer Slow	5 parts 2 parts add 25%
	Mix stick:	Use the Mixing stick **M6 Universal cm-stick** (74-206 standard) / **M7** (74-207 large)	
	**Viscosity: (RFU)** 20 – 36 sec. (DIN4/20°C)		
	**Gravity or Suction Feed:** Nozzle set Spray gun "High pressure" HE HVLP (Air cap pressure) Airless/Airmix Pressure Pot	 1.4 – 1.7 mm 3.0 – 4.5 bar (42 – 65 psi) 1.5 – 2.5 bar (21 – 36 psi) 0.7 bar (10 psi) maximum 0.011 – 0.015 (see manufacture information) 1.2 – 1.3mm	
	**Application:** **Film Thickness:** (recommended 40 – 140µm)	**Option 1:** 1 full coat or ½ coat followed by 1 full coat 40 – 60µm (DFT)	**Option 2:** 1 full closed coat followed by 1-2 full coats 60 – 140µm (DFT)
	**Between coats at 20°C:** **Before baking at 20°C:**	5 minutes 10 minutes	10 minutes 10 minutes
	**Clean up:** (Check the local regulations!)	RS405/ RS407 Epoxy Reducer or strong Gun cleaner (solvent) (Check the final cleaning process of the equipment)	

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	**Air–dry at 20°C:**	**Dust Free:** 10 – 15 minutes **Dry:** 10 – 16 hours (according to the thickness)
	Force–dry:	40 – 50 minutes / 60°C object temperature
	**IR–dry:**	15 – 18 minutes (The panel must not exceed 90°C)
	**Use suitable respiratory protection (air fed respirator strongly recommended).**	
	**Over coated with:** After 1hr/20°C 40-60µm After 10hr/20°C 60-140µm After 48 hours:	Primer/Surfacer: FP500/PB500 or FP510/FP511 Synthetic Topcoat: TB300/TB330/TB332/TB350 PU Topcoat: TB500/510/511/512/520/530/532/ TW518 or TY518 Also with Additives: AD600 / AD601/602 (See Technical Data Sheet) Sanding required (P280-P360 or scuff pad)
	**Precautions:** 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 on our webpage: www.valsparindustrialmix.com/emea/en/	
	Note: The products listed are intended only for the professional user and for professional use. All recommendations given in writing 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 uniform terms of delivery and payment are applicable.	
	With the publication of this Technical Data Sheet all previous versions regarding this product are no longer valid.	