

Product Information

Product Description:

FP510 HS Surfacer Performance grey is a high performance 2-pack Acrylic Surfacer for use under VIM/VIL Topcoats. This product has been designed as a high build surfacer up to 150µm, easy application, with air- and force dry capabilities, excellent for mechanical sanding. VOC compliant to current European VOC legislation of less than 540g/L. This product must be used in conjunction with a Wash primer or for higher corrosion resistance an Epoxy primer. Ideal for spot, panel and overall repair application.

Note: Do not use FP510 HS Surfacer Performance over: Thermoplastic, Synthetic finishes or direct to metal.

Preparation:

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

Substrates:	Solvent resistant surfaces, cleaned/sanded/hardened original and cured coatings, E-coat, Polyester putty and glass fiber reinforced plastics.
Plastic:	use FP600 Plastic Primer (adhesion test recommended)
Substrate:	Iron, steel, cast iron, galvanized steel, aluminum, pre-prime 1 coat of suitable primer
Iron/steel:	Dry sanding P80 – P180
Aluminum:	P180 – P240
Galvanized:	Sweep blasting recommended
Paint finishes:	P240 – P320 (Please, check and change abrasive paper regularly on sanding machine)
Cleaning:	Surface must be dry and free from any contamination, e.g. oil, grease & release agents. Use AD690 Solvent Degreaser

Material Description: FP510

Application Method	Minimum DFT µm	Maximum DFT µm	Minimum WFT µm	Maximum WFT µm *
Spraying equipment	50µm	150µm	70µm	200µm

* Higher thicknesses possible if given extended drying times

Pre-prime: Use FP620 1K Wash primer, FP640 Etch Primer or PB400, FP400 or FP401 Epoxy Primer





Topcoat: Recoat from a range of Valspar Industrial Mix PU Topcoats: TB500 VOC compliant and TB510/511/512/520/TW518/TY518 VIL: MI/IC non-VOC compliant
More detailed information go-to Technical Data Sheets.

Physical properties:

Chemical base	2-pack hydroxyl acrylic resins	
Density (kg/l)	1,600 (Surfacer)	1,410 (RFU 7:1 +25%)
Volume solids (%)	51.2%	43,6%
Weight Solids (%)	73.5%	64.6%
Flash point	27°C	
Pot life (+20°C)	20-30 min. RS605 / approx. 2 hours RS610	
Shelf life	Min. 24 month under normal storage conditions and unopened tins	
Coverage (m ²)	Approx. 10,5m ² 40µm DFT (100% transfer efficiency)	
Gloss	Matt	
Color	Grey	
Temperature Stability	Dry Heat up to 140°C	
VOC (g/l)	Max. 510g/l see CRS (VOC: 2004/42/IIB(c)540g/l)	
Processing temperature	+10°C till max. +40°C, max. Humidity 85%	

Application Data

 	Preparation/ Cleaning:	All surfaces must be properly sanded and cleaned Paint finishes: P240 – P320 Polyester putty: P240 – P280 Cleaning: AD690 Solvent Degreaser Surface must be dry and free from any contamination, e.g. oil, grease	
	Handling:	Before use/spraying: 1. Mix mechanically (paint shaker/ mechanical stirrer) 2. Add Activator and Reducer 3. Stir this mixture well with a mixing stick or a (pneumatic) stirrer	
	Mixing ratio with Activator and Reducer: (By volume)	FP510 Surfacer Performance grey AU500 PU Activator RS610 Extended Potlife Reducer or RS605/607/609 Universal Reducer	7 parts 1 part add 20 – 25%
	Airless/Airmix application: Note: Use RS603/5/7/9 Universal Reducer if short potlife is required (20-30 minutes or RS610 ~2 hours)	Only RS610 Extended Potlife Reducer	Add 5-15%
	Mix stick:	Use the Mixing stick M6 Universal cm-stick (74-206 standard) / M7 (74-207 large)	
	Viscosity: 20 – 26 sec. (DIN4/20°C)		
	Gravity or Suction Feed: Nozzle set Spray gun “High pressure” Spray gun “Reduce pressure” 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, too) 1.0 – 1.5 mm	
	Application: Film Thickness: (recommended 50 – 100µm)	Option 1: ½ coat followed by 1 full coat 50 – 80µm (DFT)	Option 2: 1 full closed coat followed by 1-2 full coat 80 – 150µm (DFT)
	Between coats at 20°C: Before baking at 20°C:	5 – 10 minutes 10 minutes	10 minutes 10 minutes
	Clean up: (Check the local regulations!)	RS605/607/609 Universal Reducer or Gun cleaner (solvent)	
	Air-dry at 20°C: Force-dry:	Dust Free: 15 minutes Dry: 4 – 6 hours 20 – 30 minutes / 60°C object temperature	

	IR-dry:	12 – 15 minutes (The panel must not exceed 90°C)
	Use suitable respiratory protection (air fed respirator is strongly recommended).	
	Recoatable (PU Topcoat): (wet on wet) After min. 30 min./20°C <40µm and 2-4 hours/20°C 80-100µm	TB500/510/511/512/520/TW518/TY518, MI, IC + CC700 or CC710 (See Technical Data Sheet) After 4 hours and full drying: Sanding required (P320-P400 or scuff pad)
	<p>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</p> <p>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.</p> <p>With the publication of this Technical Data Sheet all previous versions regarding this product are no longer valid.</p>	