

## Product Information

### Product Description:

FP640 2K Etch Primer is a fast drying, low build product. It is designed to promote adhesion and give excellent corrosion protection in combination with FP510 Surfacer Performance grey on recommended substrates. Suitable for use on small and large surfaces. Always recoat with FP510 Surfacer Performance grey directly after drying.

**Note:** Do not use polyester putty over FP640 Etch Primer, do not use as an isolator, to repair thermoplastic acrylic finishes or overcoat with Epoxy Primer. Do not mix FP640 Etch Primer in metal vessel / container.

### Preparation:

For more detailed information go-to TI-Substrate and Pre-treatment on Color Retrieval System (CRS) or website [www.valsparindustrialmix.com](http://www.valsparindustrialmix.com).

<b>Substrates:</b>	Bare metals: steel, cast iron, galvanized steel, aluminum, Solvent resistant surfaces, cleaned/sanded/hardened original and cured coatings, Polyester putties and glass fiber reinforced plastics.
Iron/steel:	Dry sanding P180 – P280 or scuff pad (very fine)
Aluminum:	P240 – P280 or scuff pad (very fine)
Galvanized:	P240 – P280 or scuff pad (very fine)
Paint finishes:	P280 – P320 (Please, check and change abrasive paper regularly on machine) or scuff pad (very fine)
<b>Cleaning:</b>	Surface must be dry and free from any contamination, e.g. oil, grease, corrosion & release agents. Use AD690 Solvent Degreaser.

### Material Description: FP640

Application Method	Minimum DFT µm	Maximum DFT µm	Minimum WFT µm	Maximum WFT µm
Spraying equipment	10µm	20µm	15µm	25µm

### Primer:

Always use FP510 Surfacer Performance before applying any topcoat.



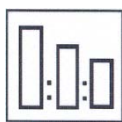

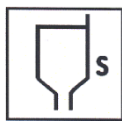


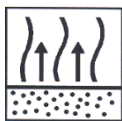


### Topcoat:




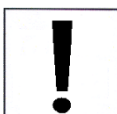
Recoat from a range of Valspar Industrial Mix / VIL Topcoats: TB500 VOC compliant and TB510/511/512/TW518/TY518 non-VOC compliant, MI or IC + CC700/CC710  
More detailed information go-to Technical Data Sheet.

### Physical properties:

Chemical base	Special resins, chromate free antirust pigments and mild solvents
Density (kg/l)	0,951 (Primer)
Volume solids (%)	12,7 %
Weight Solids (%)	23,0 %
Flash point	16°C
Pot life (+20°C)	8 hours
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m²)	Approx. 7m² 20µm DFT (100% transfer efficiency)
Gloss	Matt
Color	Beige
Temperature Stability	Dry Heat up to 100°C
VOC (g/l)	Max. 732g/l see CRS (VOC: 2004/42/IB(c)780g/l)
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

## Application Data

	<b>Preparation/ Cleaning:</b>	<b>All surfaces must be properly sanded (dry sanding) and cleaned</b> Iron/steel: P180 – P280 Aluminum: P240 – P280 Galvanized: P240 – P280 Paint finishes: P280 – P320 Scuff pad: Fine until Ultra fine (according to the selected coating system) Cleaning: AD690 Solvent Degreaser Surface must be dry and free from any contamination, e.g. oil, grease		
	<b>Handling:</b>	<b>Before use/spraying:</b> 1. Mix mechanically (paint shaker/ mechanical stirrer) 2. Add AP640 Etch Primer Activator 3. Stir this mixture well with a mixing stick or a (pneumatic) stirrer		
	<b>Mixing ratio with Activator:</b> (By volume)		FP640 Etch primer AP640 Etch Primer Activator	1 part 1 part
	<b>Mix stick:</b>		Use the Mixing stick <b>M6 Universal cm-stick</b> (74-206 standard) / <b>M7</b> (74-207 large)	
	<b>Viscosity:</b> 18 – 20 sec. (DIN4/20°C)			
	<b>Gravity or Suction Feed:</b> Nozzle set Spray gun “High pressure” Spray gun “Reduce pressure” HVLP (Air cap pressure) Airless/Airmix Pressure Pot		1.3 – 1.5 mm 3.0 – 4.5 bar (42 – 65 psi) 1.5 – 2.5 bar (21 – 36 psi) 0.7 bar (10 psi) maximum Not recommended 1.0 – 1.2 mm	
	<b>Application:</b>  <b>Film Thickness:</b>		1 full coat  10 – 20µm (DFT)	
	<b>Flash off at 20°C:</b>		5 – 10 minutes	
	<b>Clean up:</b> (Check the local regulations!)		RS605/607/609 Universal Reducer or Gun cleaner (solvent)	
	<b>Air-dry at 20°C:</b>  <b>Force-dry:</b>		<b>Dust Free:</b> 10 – 15 minutes  N/A	

	IR-dry:	N/A
	Use suitable respiratory protection (air fed respirator is strongly recommended).	
	Recoatable (Primer):	FP510 Surfacer Performance Grey
	<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 (SDS). Information also available on our webpage: <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 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>	