

Primer	FP440	Epoxy Primer Basic Grey	TDS No.: FP440/UK
Topcoat	TB520	PU Topcoat Basic High Gloss	TDS No.: TB520/UK

Preparation and Pre-treatment	Characteristics
Iron, steel, stainless steel (substrate 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.	2K Epoxy Primer
	2K PU Topcoat
	Total layer thickness: 100-180µm
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”).	Application
	Conversion gun
For more information see our Technical Information and Data Sheets.	

Primer				
Product		Mixing ratio (Volume)	Layers	Dry times
FP440	Epoxy Primer Basic Grey	5 parts	1-3 40-140µm	Dust dry: 20-30 min/20°C Recoat: 1-48 hours/20°C Dry: 10-16 hours/20°C Force dry: 40-50 min/60°C
AP404	Epoxy Activator	2 parts		
RS405	Epoxy Reducer	+10-25%		
Wet on wet application 1 layer 40-60µm/1 hour, 60-140µm/2-3 hours flash-off time/20°C. After 48 hours, please sand again.				

Topcoat				
Product		Mixing ratio (Volume)	Layers	Dry times
TB520	PU Topcoat Basic High Gloss	6 parts	2 40-60µm	Dust dry: 15-25 min/20°C Dry to assembly: 1-3 hours/20°C Dry: 6-8 hours/20°C Force dry: 20-30 min/60°C
AU500	Polyurethane Activator	1 part		
RS605	Universal Reducer	+20-35%		

For a faster drying process, use the AA600 Accelerator (max. 3%), to be dispensed with the amount of Reducer. Possibility to use AD601 Texture Additive “Fine” and AD602 Texture Additive “Coarse”.

Information:
<p>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. For recommended layer thickness, as per ISO 12944, see the information sheet TI-G9.</p>