

C3	> 15 years
C4	5 - 15 years

<b>Primer</b>	<b>FP440</b>	<b>Epoxy Primer Basic Grey</b>	TDS No.: FP440/UK
<b>Topcoat</b>	<b>TB510</b>	<b>PU Topcoat DTM High Gloss</b>	TDS No.: TB510/UK
<b>Clear Coat</b>	<b>CC700</b>	<b>Clear Coat Anti Graffiti</b>	TDS No.: CC700/UK

Preparation and Pre-treatment	Characteristics
<p>Iron, steel, stainless steel (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.</p> <p>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”).</p> <p>For more information see our Technical Information and Data Sheets.</p>	2K Epoxy Primer
	2K Topcoat
	2K Clear coat
	Total layer thickness: 140-220µm
	<b>Application</b>
	Conversion gun

### Primer (airless, airmix application possible)

Product	Mixing ratio (Volume)	Layers	Dry times
FP440	Epoxy Primer Basic Grey	1-3 40-140µm	Dust dry: 20-30 min/20°C Recoatable: 1-48 hours/20°C Dry: 10-16 hours/20°C Force dry: 40-50 min/60°C
AP404	Epoxy Activator		
RS405	Epoxy Reducer		

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
TB510	PU Topcoat DTM High Gloss	2 60-80µm	Dust dry: 2-3 hours/20°C Dry to assembly: 6-9 hours/20°C Dry: 24 hours/20°C Force dry: 30-40 min/60°C
AU500	Polyurethane Activator		
RS605	Universal Reducer		

For a faster drying process, use the AA600 Accelerator (max. 3%), to be dispensed with the amount of Reducer.  
 For a very good finish, apply the CC700 Clear Coat after drying time (up to 24 hours later without sanding, after 24 hours sand again – Scotch-brite very fine/ultra fine).

### Clear Coat

Product	Mixing ratio (Volume)	Layers	Dry times
CC700	Clear coat Anti Graffiti	2 40-60µm	Dust dry: 60 min/20°C Dry to assembly: 8-10 hours/20°C Dry: 24 hours/20°C Force dry: 40-50 min/60°C
AU570	Clear coat Activator		
RS605	Universal Reducer		

For a faster drying process, use the AA600 Accelerator (max. 3%), to be dispensed with the amount of Reducer.

### Information:

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.