

FP400 Epoxy Primer DTM Grey  
 FP401 Epoxy Primer DTM White

FP400 / UK  
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## Product Information

### Product Description:

FP400/401 is a 2K Epoxy corrosion protection primer DTM (direct to metal) with excellent adhesion properties. This Epoxy primer has excellent air- and force dry capabilities. FP400/401 can be used as wet on wet and for higher thicknesses of up to 120µm. Epoxy primer needs recoating with Topcoat. It is possible to add 5% color toner to FP401 Epoxy Primer white to tint.

### Preparation:

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

### Substrates:

Iron, steel, stainless steel (blasted), cast iron, galvanized steel, aluminum, glass fiber 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 substrate or AD690 Solvent Degreaser for metal substrate/paint finishes.

### Material Description: FP400/401

Application Method	Minimum DFT µm	Maximum DFT µm	Minimum WFT µm	Maximum WFT µm *
Spraying equipment	40µm	100µm	50µm	130µm

\* Higher thicknesses possible if given extended drying times

### Topcoat:

Recoat from a range of VIM Topcoats-, Synthetic: TB300 / TB300 + AD300 / TB300 + AD309

PU Topcoats: TB500/510/511/512/520/TW518/TY518

For more detailed information go-to Technical Data Sheets TB500/510/511/512/520/TW518/TY518.

### Physical properties:

Chemical base	Epoxy
Density (kg/l)	FP400 / 1.583    FP401 / 1.594
Volume solids (%)	FP400 / 49.7%    FP401 / 57.4%
Weight Solids (%)	FP400 / 71.4%    FP401 / 72.0%
Flash point	28,5°C
Pot life (+20°C)	Approx. 5 – 6 hours
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m <sup>2</sup> )	Approx. 8.5m <sup>2</sup> 40µm (DFT)
Gloss	Matt
Color	Grey
Temperature Stability	Dry Heat up to 150°C
VOC (g/l)	Max. 540g/l see CRS (VOC: 2004/42/IIB(c)540g/l) up to 15% is the product VOC compliant!
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

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## Application Data

	<b>Preparation/ Cleaning:</b>	<p><b>All surfaces must be properly shot blast or sanded and cleaned</b>                  Abrasive blast to EN ISO 12944, part 4 (SA 2.5) with a uniform blast profile of 20 – 50µm.                  Dry sanding Steel: P80 – P180                  Aluminum: P180 – P240                  Galvanized: Sweep blasting recommended                  Paint finishes: P240 – P320                  Cleaning: RS405, RS605/607/609 (metal surface) and/or AD690 Solvent Degreaser (paint finishes)                  Surface must be dry and free from any contamination, e.g. oil, grease</p>	
	<b>Handling:</b>	<p><b>Before use/spraying:</b>                  1. Mix mechanically (paint shaker/ mechanical stirrer) until homogeneous                  2. (possibility with FP401) add 5% colour toner and stir the product very well                  3. Add Activator and Reducer                  4. Stir this mixture well with a mixing stick or a (pneumatic) stirrer</p>	
	<b>Mixing ratio with Activator and Reducer – sanded version:</b> (By volume)	FP400 Epoxy <b>Primer</b> DTM grey or FP401 Epoxy <b>Primer</b> DTM white AP401 EP Activator RS405 Epoxy Reducer	3 parts  1 part add 10 – 30%
	<b>Mixing ratio with Activator and Reducer – wet/wet version:</b> (By volume)	FP400 Epoxy <b>Primer</b> DTM grey or FP400 Epoxy <b>Primer</b> DTM white AP401 EP Activator RS405 Epoxy Reducer	3 parts  1 part add 35 – 50%
	<b>Mix stick:</b>	Use the Mixing stick <b>M2 3:1</b> (74-202 = 3:1/4:1) or <b>M6 Universal cm-stick</b> (74-206 standard) / <b>M7</b> (74-207 large)	
	<b>Viscosity:</b> 20 – 36 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	1.5 – 1.9 mm 3.0 – 4.5 bar (42 – 65 psi) 1.5 – 2.5 bar (21 – 36 psi) 0.7 bar (10 psi) maximum 0.009 – 0.015 (see manufacture information) 1.0 – 1.5mm	
	<b>Application:</b>  <b>Film Thickness:</b> (recommended 40 – 80µm)	<b>Option 1:</b> 1 full coat or ½ coat followed by 1 full coat 30 – 50µm (DFT)	<b>Option 2:</b> 1 full closed coat followed by 1 full coat 60 – 120µm (DFT)
	<b>Between coats at 20°C:</b>  <b>Before baking at 20°C:</b>	5 minutes  10 minutes	5 – 10 minutes  10 minutes

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	<b>Clean up:</b> (Check the local regulations!)	RS405 Epoxy Reducer or Gun cleaner (solvent)
	<b>Air-dry at 20°C:</b>  <b>Force-dry:</b>	<b>Dust Free:</b> 25 – 30 minutes <b>Dry:</b> 10 – 16 hours (according to the thickness)  30 minutes / 60°C object temperature
	<b>IR-dry:</b>	12 – 15 minutes (The panel must not exceed 90°C)
	<b>Use suitable respiratory protection (air fed respirator strongly recommended).</b>	
	<b>Over coated with:</b>  After min. 1hr/20°C <40µm After min. 3hr/20°C 40-80µm	Synthetic: TB300/TB300+AD300/TB300+AD309 PU Topcoat: TB500/510/511/512/520/TW518/TY518/+Additives AD60x Topcoat (See Technical Data Sheet)  After 48 hours: Sanding required (P280-P360 or scuff pad)
	<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 (MSDS). 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>	