

### PRODUCT DESCRIPTION

7-411 Grained Epoxy Topcoat is a 2K epoxy textured enamel which is easy to apply and gives high durability. It is recommended for the painting of industrial equipment and machinery, particularly those situated in an aggressive environment. It should not be used on exterior surfaces exposed to sunlight if a good level of color stability is required.

### SELECTION AND PREPARATION OF SUBSTRATES

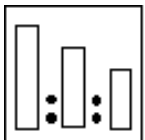


Bare steel  
7-413, 7-414  
Sandblasted steel

**Sand**  
P80-120 -240 (dry)  
see relevant primers data sheets

*Degrease thoroughly prior to painting.*

### APPLICATION GUIDE



*Mixing ratio (by weight):*

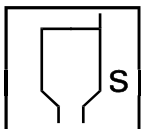
	SMOOTH COAT		TEXTURED COAT	
Topcoat	1000	Topcoat	1000	
9-015	200	9-015	200	
1-410 *	300-400	1-410 *	0-100	

*Mixing ratio (by volume):*

	SMOOTH COAT		TEXTURED COAT	
Topcoat	7	Topcoat	7	
9-015	2	9-015	2	
1-410 *	3 - 4	1-410 *	0 - 1	

\*\* For large areas use 1-400 Slow Thinner

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*Pot life 20°C:*

6- 8 hours

2-4 hours

*Spray viscosity:*

18-22 secs Din 4 20 °C

TIX



*Spray gun set up (Conventional):*

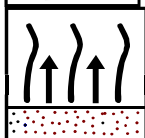
1.8 - 2.5 mm

1.8 - 2.5 mm

*Spray pressure:*

3.5-5 bar

3.5 -5 bar



*Number of coats:*

1 smooth + 1 textured

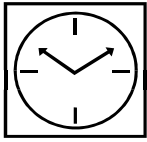
1 smooth + 1 textured

*Flash off between coats:*

1-3 hours 20° C

1-3 hours 20° C

## APPLICATION GUIDE



*Drying times at 20 °C:*

*Dust free:* 20-30 minutes

*Handling:* 16-24 hours

*Through dry:* 36-48 hours



*Through dry at 60°C:* 1 hour

*Total dry film build:* 40-50 microns

*Overcoat/recoat time with itself* 3 hours mini and 24 hours maxi 20°C without flatting

## TECHNICAL DATA

*Theoretical coverage* 10-12 m<sup>2</sup> /l ready to spray giving 40µm dry film thickness

## HEALTH AND SAFETY

Please refer to Material Safety Data Sheet for full health and safety details and storage regulations

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further enquiries as to the stability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of our experience and our policy of continuous product development. Drying times quoted are average times at 20°C. Film thickness, humidity and shop temperature can all affect drying times.

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