



PAINT SYSTEM

N° 4

7-820 Fast dry primer extra + 7-330 Cellulose extra gloss topcoat

TYPE OF SUBSTRATE
Non corroded steel Corroded steel Black iron steel with calamine Black iron steel without calamine Old finishes

PREPARATION OF SUBSTRATES
See enclosed "Preparation of substrates" sheet for details

CHARACTERISTICS
Speed : ***
Durability : **
Aspect : **
Low cost : ***
NB OF PROCESSES : 2
PRODUCT TYPE
Primer : 1K Topcoat : 1K
SPRAYING METHOD
Conventional - Airless

SYSTEM

PRIMER					
PRODUCT	MIXING RATIO (by weight)	NB OF COATS	FLASH OFF	DRYING	SANDING
7-820 Fast dry primer extra (tinted)	1000	2	10-15 min	Dust free : 10-15 min Handling : 40-60 min Overcoat : 60-90 min	Not needed
1-610 Synthetic thinner (or 1-215, 1-205)	300-400				

TOPCOAT (conventional spraying only)					
PRODUCT	MIXING RATIO (by weight)	NB OF COATS	FLASH OFF	DRYING	
7-330 Cellulose extra gloss topcoat	1000	2-3	10-15 min	Dust free : 10-15 min Handling : 60-80 min Through Dry : 24 hours	
1-215 Nitro thinner (or 1-205)	400-600				
TOTAL FILM BUILD : 70-95 microns					

Note : 7-330 Cellulose extra gloss topcoat has 80-90 gloss. Matt and semi-gloss finish : use 7-320 Cellulose matt topcoat

TECHNICAL DATASHEETS	
For further information, please refer to the following technical datasheets	
7-820 Fast dry primer extra	TDS : 561
7-330 Cellulose extra gloss topcoat	TDS : 515
7-320 Cellulose matt topcoat	TDS : 516