



PAINT SYSTEM

N° 9

7-413 Epoxy primer + 7-410 Epoxy topcoat

TYPE OF SUBSTRATE

Corroded / Non corroded steel
 Black iron steel with / without calamine
 Electronically / hot galvanized metal
 Precoated metal
 Light alloys & aluminium
 Stainless steel
 Fibre-glass, reinforced polyester
 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 : 2K

Topcoat : 2K

SPRAYING METHOD

Conventional - Airless

SYSTEM

PRIMER					
PRODUCT	MIXING RATIO (by weight)	NB OF COATS	FLASH OFF	DRYING	SANDING
7-413 Epoxy primer	1000	2	15-20 min	Wet on wet : Overcoat : 2 - 24 h at 20°C Dry : Overcoat : over 24 h at 20°C 50-60 min at 60°C	Not needed P400+600/800 wet P220+320/400 dry
9-010 Epoxy hardener (or 9-011)	200				
1-410 Epoxy thinner	250-350				

TOPCOAT				
PRODUCT	MIXING RATIO (by weight)	NB OF COATS	FLASH OFF	DRYING
7-410 Epoxy topcoat	1000	2	20-25 min	Dust free : 30-40 min Handling : 6-8 hours Through Dry : 12-18 hours (20°C) 60 min (60°C)
9-010 Epoxy hardener (or 9-011)	500			
1-410 Epoxy thinner	400-500			
TOTAL FILM BUILD : 90-130 microns				

Note : Matt and semi-gloss finish : use 7-412 Epoxy matt topcoat . At temperature below 15°C and with a relative humidity above 85% drying times are longer.
 When exposed to sunlight, epoxy topcoats may become mat and fade and colours show yellowing.

TECHNICAL DATASHEETS

For further information, please refer to the following technical datasheets

7-413 Epoxy primer	TDS : 526
7-410 Epoxy topcoat	TDS : 520
7-420 Epoxy matt topcoat	TDS : 522