



PAINT SYSTEM

N° 10

7-413 Epoxy primer + 7-510 Polyurethane 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

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

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

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	250-300				

TOPCOAT				
PRODUCT	MIXING RATIO (by weight)	NB OF COATS	FLASH OFF	DRYING
7-510 Polyurethane topcoat	1000	2	10-15 min	Dust free : 10-15 min Handling : 4-6 hours Through Dry : 10-14 hours (20°C) 30-40 min (60°C)
9-060 PU hardener	300			
1-420 PU thinner	350-400			

OR (for interior use)				
PRODUCT	MIXING RATIO (by weight)	NB OF COATS	FLASH OFF	DRYING
7-510 Polyurethane topcoat	1000	2	10-15 min	Dust free : 10-15 min Handling : 4-6 hours Through Dry : 10-14 hours (20°C) 30-40 min (60°C)
9-510 PU interior hardener	500			
1-420 PU thinner	200-300			

TOTAL FILM BUILD : 90-130 microns

Note : 9-510 is not recommended for items to be situated outside, or for light colours (yellowing). Matt, semi gloss colours : use 7-511 Polyurethane matt topcoat.

TECHNICAL DATASHEETS

For further information, please refer to the following technical datasheets

7-413 Epoxy primer	TDS : 526
7-510 Polyurethane topcoat	TDS : 535
7-511 Polyurethane matt topcoat	TDS : 536