



PAINT SYSTEM

N° 17

7-414 Epoxy vinyl primer + 7-512 Polyurethane extra 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 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
7-414 Epoxy vinyl primer	1000	2	10-15 min	Dust free : 15-20 min Handling : 2-3 hours Overcoat : 2-3 hours	Not needed
9-010 Epoxy hardener (or 9-011)	200				
1-410 Epoxy thinner	400-500				

TOPCOAT				
PRODUCT	MIXING RATIO (by weight)	NB OF COATS	FLASH OFF	DRYING
7-512 Polyurethane extra topcoat	1000	2	10-15 min	Dust free : 30-40 min Handling : 6-8 hours Through Dry : 12-18 hours (20°C) 60 min (60°C)
9-060 Extra PU hardener	250			
1-420 Polyurethane thinner	200-300			

OR (top resistance and quality)				
PRODUCT	MIXING RATIO (by weight)	NB OF COATS	FLASH OFF	DRYING
7-512 Polyurethane extra topcoat	1000	2	10-15 min	Dust free : 30-40 min Handling : 6-8 hours Through Dry : 12-18 hours (20°C) 60 min (60°C)
9-080 Acrylic hardener	350			
1-420 Polyurethane thinner	0-100			

TOTAL FILM BUILD : 90-100 microns

Note : Using hardener 9-080 will improve the resistance to atmospheric attacks and give a better final aspect.
Matt and semi gloss finish : use 7-511 polyurethane matt topcoat

TECHNICAL DATASHEETS

For further information, please refer to the following technical datasheets

7-414 Epoxy vinyl primer	TDS : 527
7-512 Polyurethane extra topcoat	TDS : 537
7-511 Polyurethane matt topcoat	TDS : 536