



PAINT SYSTEM

N° 12

7-413 Epoxy primer + 7-513 Grained 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

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	250-300				

TOPCOAT					
(smooth coat)					
PRODUCT	MIXING RATIO (by weight)	NB OF COATS	FLASH OFF	DRYING	
7-513 Graine polyurethane topcoat	1000	1	1-2 hours	Dust free : 15-20 min Handling : 6-8 hours Through Dry : 16-24 hours (20°C) 40 min (60°C)	
9-300 Textured PU hardener	200				
1-420 PU thinner	300-400				
(textured coat)					
7-513 Graine polyurethane topcoat	1000	1	-	-	
9-300 Textured PU hardener	200				
1-420 PU thinner	0-100				
TOTAL FILM BUILD : 80-130 microns					

Note : Re-coatable within 24 hours without sanding

TECHNICAL DATASHEETS	
For further information, please refer to the following technical datasheets	
7-413 Epoxy primer	TDS : 526
7-513 Polyurethane extra topcoat	TDS : 538