



**PAINT SYSTEM**

**N° 13**

**7-413 Epoxy primer + 7-110 Acrylic 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	<b>Wet on wet :</b> Overcoat : 2 - 24 h at 20°C  <b>Dry :</b> 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
7-110 Acrylic Topcoat	1000	2	10 min	Dust free : 10 min Handling : 4-5 hours Through Dry : 20-24 hours (20°C) 30-40 min (50-60°C)
9-080 Acrylic hardener	500			
1-430 Acrylic thinner	100-150			
TOTAL FILM BUILD : 90-130 microns				

TECHNICAL DATASHEETS	
For further information, please refer to the following technical datasheets	
7-413 Epoxy primer	TDS : 526
7-110 Acrylic topcoat	TDS : 510