



PAINT SYSTEM

N° 14

7-413 Epoxy primer + 7-120 UHS 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
7-120 UHS Acrylic Topcoat	1000	1 light + 1full	15-20 min	Dust free : 20 min Handling : 5-6 hours Through Dry : 24 hours (20°C) 40-50 min (60°C)
9-120 UHS Acrylic extra fast hardener (or 9130)	500			
1-430 Acrylic thinner (or 1-440)	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
7-120 Acrylic topcoat	TDS : 511