



PAINT SYSTEM

N° 16

7-414 Epoxy vinyl primer + 7-410 Epoxy 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

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
7-414 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)	100				
1-410 Epoxy thinner	400-500				

TOPCOAT

PRODUCT	MIXING RATIO (by weight)	NB OF COATS	FLASH OFF	DRYING
7-410 Epoxy topcoat	1000	2	20-25 min	Dust free : 30-40 min Handling : 6-8 hours Through Dry : 12-18 hours (20°C) 60 min (60°C)
9-010 Epoxy hardener (or 9-011)	500			
1-410 Epoxy thinner	400-500			

TOTAL FILM BUILD : 90-100 microns

Note : Epoxy primers and topcoats may be over-coated after long periods without sanding. Matt and semi-gloss finish : use 7-412 Epoxy matt topcoat .
 At temperature below 15°C and with a relative humidity above 85% drying times are longer.
 When exposed to sunlight, epoxy topcoats may become mat and fade and colours show yellowing.

TECHNICAL DATASHEETS

For further information, please refer to the following technical datasheets

7-414 Epoxy vinyl primer	TDS : 527
7-410 Epoxy topcoat	TDS : 520
7-412 Matt epoxy topcoat	TDS : 522