



PAINT SYSTEM

N° 18

7-411 Grained 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 : 1

PRODUCT TYPE

Topcoat : 2K

SPRAYING METHOD

Conventional

PREPARATION OF SUBSTRATES

See enclosed "Preparation of substrates" sheet for details

TOPCOAT

(smooth coat)

PRODUCT	MIXING RATIO (by weight)	NB OF COATS	FLASH OFF	DRYING	SANDING
7-411 Grained epoxy topcoat	1000	1	1-3 hours	Dust free : 20-30 min Handling : 8-24 hours Through Dry : 36-48 h (20°C) 60 min (60°C)	Not needed
9-015 Epoxy textured hardener	200				
1-410 Epoxy thinner	300-400				

(textured coat)

PRODUCT	MIXING RATIO (by weight)	NB OF COATS	FLASH OFF	DRYING
7-411 Grained epoxy topcoat	1000	1	-	-
9-015 Epoxy textured hardener	200			
1-410 Epoxy thinner	0-100			

TOTAL FILM BUILD : 40-50 microns

Note : 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

7-411 Grained epoxy topcoat	TDS : 521
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