



PAINT SYSTEM

N° 21

7-820 Fast dry primer extra + 7-630 1K synthetic urethane topcoat

TYPE OF SUBSTRATE
Corroded steel Non corroded steel Black iron steel with calamine Black iron steel without calamine

PREPARATION OF SUBSTRATES
See enclosed "Preparation of substrates" sheet for details

CHARACTERISTICS
Speed : ** Durability : ** Aspect : ** Low cost : **
NB OF PROCESSES : 2
PRODUCT TYPE
Primer : 1K Topcoat : 1K
SPRAYING METHOD
Conventional - Airless

SYSTEM

PRIMER					
PRODUCT	MIXING RATIO (by weight)	NB OF COATS	FLASH OFF	DRYING	SANDING
7-820 Fast dry primer extra	1000	2	10-15 min	Dust free : 10-15 min Handling : 40-60 min Overcoat : 60-90 min	Not needed
1-610 Synthetic Thinner (or 1-215, 1-205)	300-400				

TOPCOAT				
PRODUCT	MIXING RATIO (by weight)	NB OF COATS	FLASH OFF	DRYING
7-630 1K synthetic urethane topcoat	1000	2	15-20 min	Dust free : 10-15 min Handling : 10-12 hours Through Dry : 48-72 hours (20°C)
1-610 Synthetic thinner (or 1-215, 1-205)	250-350			
TOTAL FILM BUILD : 75-100 microns				

TECHNICAL DATASHEETS	
For further information, please refer to the following technical datasheets	
7-820 Fast dry primer extra	TDS : 561
7-630 1K synthetic urethane topcoat	TDS : 544