

7-410

EPOXY TOPCOAT

PRODUCT DESCRIPTION

7-410 Epoxy Topcoat is a 2K epoxy enamel which offers good gloss and a hard durable film. It is recommended for the painting of industrial equipment and machinery, particularly those situated in an aggressive environment. It should not be used on exterior surfaces exposed to sunlight if a good level of colour stability is required.

SELECTION AND PREPARATION OF SUBSTRATES

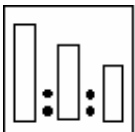


Bare steel
7-413, 7-414 primers
Sandblasted steel

Sand
P80-120 -240 (dry)
see relevant primers data sheets

Degrease thoroughly prior to painting.

APPLICATION GUIDE



Mixing ratio (by weight):

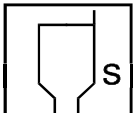
AIRLESS		CONVENTIONAL	
Topcoat	1000	Topcoat	1000
9-010 *	500	9-010 *	500
1-410	400-500	1-410	400-500

Mixing ratio (by volume):

Topcoat	3	Topcoat	3
9-010 *	2	9-010 *	2
1-410	2 – 2.5	1-410	2 – 2.5

*9-011 fast can be used

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Pot life 20 °C:

6- 8 hours

6-8 hours

Spray viscosity:

18-22 secs Din 4 20°C

18-22 secs Din 4 20°C



Spray gun set up:

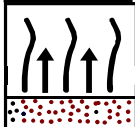
9 - 11

1.4-1.7 mm

Spray pressure:

120-140 bar

3-4 bar



Number of coats:

2

2

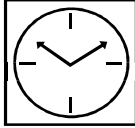
Flash off between coats:

10-15 minutes 20°C

10-15 minutes 20°C

APPLICATION GUIDE

Drying times at 20 °C



Dust free: 30-40 minutes

Handling: 6-8 hours

Through dry: 12-18 hours



Through dry at 60 °C: 1 hour

Total dry film build: 50 microns

Overcoat/recoat time with itself 3 hours mini and 24 hours maxi 20°C without flatting

TECHNICAL DATA

Theoretical coverage 6.8 – 7.6 m² /l ready to spray giving 50µm dry film thickness

HEALTH AND SAFETY

Please refer to Material Safety Data Sheet for full health and safety details and storage regulations

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further enquiries as to the stability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of our experience and our policy of continuous product development. Drying times quoted are average times at 20°C. Film thickness, humidity and shop temperature can all affect drying times.

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