

FP450 Epoxy Primer Gray
 FP451 Epoxy Primer White

FP450 / ANZ
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Product Information

Product Description:

FP450/451 is a 2K high solids corrosion protection direct-to-metal epoxy primer with excellent performance properties. This highly flexible epoxy primer is suitable for multiple substrates and offers many advantages in terms of dry time, build, long overcoating interval and wet-on-wet and sanding options. It is the ideal primer for fleet (trucks and buses), construction machinery, farm equipment, and other industrial applications.

Preparation:

For more detailed information go to TI-Substrate and Pre-treatment on Colour Retrieval System (CRS) or website www.valsparindustrialmix.com.

Substrates:

Cold rolled steel, Hot rolled steel, Aluminium, Fibreglass, GRP / FRP, SMC

Other: Solvent resistant surfaces, cleaned/sanded/hardened original and cured coatings.

Iron/steel: Abrasive shot blasting is recommended or dry sanding P80
 SMC/GRP/FRP: Sand with P180-P240
 Aluminium: P120 – P180
 Old Paint finishes: P240 – P320

Cleaning:

Surface must be dry and free from any contamination, e.g. oil, grease & release agents.
 Use AD690 Degreaser Solvent Based for metal substrate/paint finishes.

Material Description: FP450/451				
Application Method	Minimum DFT μm	Maximum DFT μm	Minimum WFT μm	Maximum WFT μm *
Primer (4:1)	50 μm	75 μm	85 μm	130 μm
Wow (4:1+40%)	30 μm	60 μm	75 μm	145 μm

* Higher thicknesses possible if given extended drying times

Topcoats:

Recoat from a range of VIM PU Topcoats: TB500/510/511/512/520/TW518/TY518/TB540/TB543;
 For more detailed information refer to the relevant Technical Data Sheet;



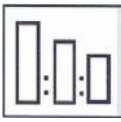

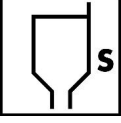
Physical properties:

Chemical base	Epoxy
Density (kg/L)	1.75 - 1.77 (base)
Volume solids (%)	62.4
Flash point	24°C
Pot life (+20°C)	Approx. 8 hours (unaccelerated)
Shelf life	Min. 24 months under normal storage conditions and unopened tins
Coverage (m ² /L)	Approx. 16.3 (25 μm 4:1+40%)
Gloss	Satin
Colour	FP450: Grey / FP451: White
Temperature Stability	Dry Heat up to 150°C
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

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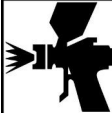



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Application Data

	Preparation/ Cleaning:	<ul style="list-style-type: none"> Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean cloth. Solvent clean with AD690 Degreaser Solvent Based wipe on and wipe dry with a clean cloth Cold rolled steel, Hot rolled steel: Abrasive blast all metal areas to EN ISO 12944, part 4 (SA 2.5) with a uniform blast profile of 20 – 30 microns (preferred) or sand with P80 grit sandpaper. SMC, GRP or FRP: Sand with P180-P240. Aluminium: Sand with P120-P180 Old Paint finishes: P240 – P320 Please, check and change abrasive paper regularly as required. Before painting the surface must be dry and free from any contamination and release agents, solvent clean with surface cleaner AD690 wipe on and wipe dry with a clean cloth. <p>NOTE: FP450/FP451 does not require an etch primer and can be applied directly to the properly cleaned and blasted or sanded substrates as indicated above.</p>						
	Handling:	Before use/spraying: <ul style="list-style-type: none"> Stir or shake FP450/FP451 thoroughly before mixing If reduction is needed, use up to 40% RS603/605/607/609 Universal Reducer RS603 Fast Reducer - temperature range of 10 - 25°C (recommended for small repairs) RS605 Medium Reducer - temperature range of 20 - 35°C RS607 Slow / RS609 Ultra Slow Reducer- temperature range of 35°C+ Stir thoroughly and strain before use; 						
	Mixing ratio with Activator and Reducer – Primer version: (By volume)	<table border="1"> <tr> <td>FP450 Epoxy Primer DTM Gray or FP451 Epoxy Primer DTM White</td> <td>4 parts</td> </tr> <tr> <td>AP450 EP Activator</td> <td>1 part</td> </tr> <tr> <td>RS603/605/607/609 Universal Reducer</td> <td>add 0% – 20%</td> </tr> </table>	FP450 Epoxy Primer DTM Gray or FP451 Epoxy Primer DTM White	4 parts	AP450 EP Activator	1 part	RS603/605/607/609 Universal Reducer	add 0% – 20%
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<p>IMPORTANT NOTE: For accelerated curing speed add 7.5 – 22ml AA450 Epoxy Primer Accelerator per litre ready to spray, for the Primer version only. Recommended reducers: RS603 Fast / RS605 Medium / RS607 Slow / RS609 Ultra Slow; Use dependent on temperature.</p>								
Mix stick:		Use the Mixing stick M2 4:1 (74-202 = 3:1/4:1) or M6 Universal cm-stick (74-206 standard) / M7 (74-207 large)						
	Viscosity (Sprayable) Din Cup 4	31 sec. at 24°C (4:1) 15 sec. at 24°C (4:1+40%)						


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	EQUIPMENT:		
	Spraygun Type:	Nozzle Size:	Air-Pressure:
	HVLP / Conventional:	1.3 – 1.4mm (WOW) 1.3 – 1.8mm (Primer)	1.8 - 2.0 bar 1.7 - 2.0 bar
	Pressure Pot:	0.8-1.5mm	10 PSI at pot
	Airless/Airmix:	0.009-0.015 inch (see manufacturer information)	
	APPLICATION:		
	<ul style="list-style-type: none"> Primer 4 : 1 +0-20% Apply 1 -3 full wet coats at a gun distance of 20 – 25cm. Allowing adequate flash off in between coats. Recommended max. dry film thickness is 225 microns. WOW 4 : 1 +30-40% Apply 1-2 medium coats at a gun distance of 20 – 25cm. Allowing adequate flash off in between coats. Recommended max. dry film thickness is 75 microns. 		
	CLEAN UP:		
	<ul style="list-style-type: none"> Use solvent borne gun-cleaner for cleaning the equipment, check for local compliancy if applicable. 		
	DRYING SCHEDULE AT 24°C:		
	<ul style="list-style-type: none"> Air Dry at 24°C and 50% R.H. (Relative Humidity). Dry film thickness of 50 – 75 microns. Thicker films will extend drying times. 		
		Un-accelerated:	Accelerated (22ml. AA450 per Litre RTS):
	Flash off:	15 minutes	15 minutes
	Hand Slick:	1 hour	30 minutes
	Nib Sandable:	2 hours	2 hours
	Tack Free:	3 hours	2 hours
	Sandable:	3 hours	2 hours
FORCED DRYING SCHEDULE:			
Temperature:	Tape free:		
60°C	1 hour		
RE-COAT ABILITY WET ON WET VERSION:			
<ul style="list-style-type: none"> Min: 15 minutes. Max: <u>up to 5 days</u> without sanding or scuffing. After 5 days, sand surface with P220 - P320 grit sandpaper.			

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	PERSONAL PROTECTION:
	<ul style="list-style-type: none"> • Read all label directions before use. • Refer to SDS for specific information. • Wear positive-air respirator when mixing and applying. • Wear an approved dust particulate mask when sanding. • Wear safety goggles, overalls, and appropriate gloves when using product. • For Professional Use Only.
SHELFLIFE & STORAGE:	
<ul style="list-style-type: none"> • Minimum 2 years; (Under normal storage conditions 10°C - 30°C) (unopened cans). 	

	Over coated with:	PU Topcoat: TB500/510/511/512/520/TW518/TY518 / TB540/TB543 (See Technical Data Sheet for additives and mixing ratios).
	Precautions: During application all health and safety measures referring to the use and handling of coating materials are to be observed, e. g. existing regulations issued by the trade associations in the Chemical Industry. For Health and Safety information please refer the Safety Data Sheet (SDS). Information also available at www.valsparindustrialmix.com.au ;	
Note: The products listed are intended only for the professional user and for professional use. All recommendations in words and writing given on the use of our products to customers or users are not binding and do not give reasons for secondary obligations resulting from the bill of sale. Every care is taken to ensure that the technical information provided is accurate and up to date according to the present state of knowledge in science and our experience. These recommendations do not, however, exempt the customer from autonomously checking whether our products are suitable for the intend purpose. The durability of the coating system largely depends on the thorough preparation of the surface. Furthermore our universal terms of delivery and payment are applicable.		
With the publication of this Technical Data Sheet all previous versions regarding this product are no longer valid.		

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