

IME.FP400 Epoxy Primer DTM Grey
IME.FP401 Epoxy Primer DTM White

IME.FP400 / UK
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Product Information

Product Description:

IME.FP400/401 is a 2K Epoxy corrosion protection primer with excellent adhesion properties. IME.FP400/401 has excellent air and force dry capabilities. It is possible to add 5% color toner to IME.FP401 White to tint.

Substrates:

All Iron, steel, cast iron, galvanized steel, aluminum.

Industrial OEM and solvent resistant surfaces, sanded, cleaned original and old cured coatings.

Preparation:

Dry Sanding: P80 – P180.

Galvanized: Sweep Blasting recommended.

(More Detailed information go-to Preparation and Pre-treatment on CRS or website www.valsparindustrialmix.com)

Surface Preparation: Abrasive blast to EN ISO 12944, Part 4 (ISO Sa 2.5) with a uniform blast profile of 20 to 50µm.

NOTE: Make sure that the layer thickness of the primer is 3 times more than the grade of the sandblasted surface.

Material Description	Application Method	Minimum DFT µm	Maximum DFT µm	Minimum WFT µm	Maximum WFT µm
FP400/FP401	Spray	30µm	100µm	50µm	140µm

*Product can be brushed and rolled.

Cleaning:

Surface must be dry and free from any contamination, eg. oil, grease and release agents. Use IME.RS405 Epoxy Reducer, IME.RS605/607 Universal Reducer or IME.AD690 Solvent Degreaser.

(More Detailed information go-to cleaning processes on CRS or website www.valsparindustrialmix.com)

Topcoats:

IME.TB400/01 - Epoxy Topcoat Binder.

IME.TB500/10/11/12/20 PU Topcoat Binder.







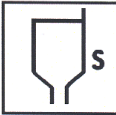

Physical properties:

Chemical base	Epoxy	
Density (kg/l)	FP400 / 1,583	FP401 / 1,594
Volume Solids (%)	FP400 / 49.7%	FP401 / 50,2%
Weight solids (%)	FP400 / 71.4%	FP401 / 72%
Flash point	28.5°C	
Pot life (+20°C)	Approx. 5 – 6 hours	
Shelf life	Min. 24 month under normal storage conditions and unopened tins	
Coverage (m²/kg)	Approx. 8.5m² (at 40µm dry film thickness)	
Gloss	Matt	
Color	Grey/White	
Temperature Stability	Dry Heat up to 150°C	
VOC (g/l)	< 540g/l see CRS Value	VOC: 2004/42/II(B)(c)(540)540g/l
Processing temperature	+8°C till max. +40°C, max. Humidity 85%	

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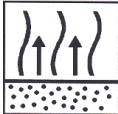



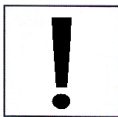
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Application Data

	Cleaning:	(Metal substrate surface only: IME.RS405/RS605/RS607 Reducer) IME.AD690 Solvent Degreaser Surface must be dry and free from any contamination, e.g. oil, grease		
	Preparation:	Sanded systems:	P80 – P180 Surface	
		Galvanized:	Sweep Blasting is recommended.	
		Abrasive Systems:	Blast to EN ISO 12944, Part 4 (ISO Sa 2.5) with a uniform blast profile of 20 to 50µm	
	Before using:	The product must be shaken and thoroughly stirred before using.		
	Mixing stick:	Use the mixing stick M2 3:1 (M2 - 74-202 = 3:1/4:1)		
	Mixing ratio with Activator and Reducer – sanded version: (By volume)	IME.FP400 Epoxy Primer DTM Grey or IME.FP401 Epoxy Primer DTM White	3 parts	
		IME.AP401 EP Activator	1 part	
		IME.RS405 Epoxy Reducer	+ 10-30%	
	Mixing ratio with Activator and Reducer – wet/wet version: (By volume)	IME.FP400 Epoxy Primer DTM Grey or IME.FP401 Epoxy Primer DTM White	3 parts	
		IME.AP401 EP Activator	1 part	
		IME.RS405 Epoxy Reducer	+ 35-50%	
	Viscosity: 22 – 36 sec. (DIN4/20°C)			
	Gravity or Suction Feed: Nozzle set Spray gun “High pressure” Spray gun “Reduce pressure” HVLP (Air cap pressure) Airless/Airmix Pressure Pot	1.5 – 1.9 mm (Wet on wet 1,4 – 1,6 mm) 3.0 – 4.5 bar (42 – 65 psi) 1.5 – 2.5 bar (21 – 36 psi) 0.7 bar (10 psi) maximum See info manufacturer 1.0 – 1.5mm		

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	Application: Film Thickness: (Recommended 40 – 80µm)	Option 1: Wet on wet 1 closed coat or ½ + 1 closed coat 30 – 40 µm (DFT)	Option 2: Sanding 1 coat followed by 1 full coat 60 – 100µm (DFT)
	Between coats at 20°C:	5 minutes	5 – 10 minutes
	Before baking at 20°C:	10 minutes	10 minutes
	Air-dry at 20°C:	Dust free: 30 minutes Dry to sand: 8 – 10 hours	
	Force-dry at 60°C – 70°C:	30 – 40 minutes 60°C object temperature	
	Recoatable: 1hr-12hrs	Epoxy Topcoat Binder IME.TB400/401 PU Topcoat Binder IME.TB500/10/11/12/20 (see Technical Data Sheets) After 12 hours: Sanding required.	
	Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).		
	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 Material Safety Datasheet (MSDS). Information also available on our webpage: www.valsparindustrialmix.com		
	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.		