valspar
INDUSTRIAL MIX

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Technical Data Sheet

IME.FP402 Zinc Rich Epoxy Primer Grey — IME.FP402 / UK

Product Information

Product Description:
IME.FP402 is a 2K Zinc Rich Epoxy Primer with excellent adhesion on blasted Iron or Steel substrates. IME.FP402 has high performance corrosion protection, with air-dry and force-dry capabilities. Chromate and lead free.
NOTE: Make sure that the layer thickness of the primer is 3 times more than the grade of the sandblasted surface.

Substrates:
IME.FP402 Zinc Rich Epoxy Primer is only recommended for blasted Iron and steel surfaces.

Preparation:
(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.					
Material Description	**Application Method**	**Minimum DFT µm**	**Maximum DFT µm**	**Minimum WFT µm**	**Maximum WFT µm**
FP402	Spray	30µm	100µm	50µm	130µm

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.FP400/01 Epoxy Primer - for higher film build.
IME.TB400/01 Epoxy Topcoat.
IME.TB500/10/11/12/20 PU Topcoats.

Physical properties:

Chemical base	Epoxy
Density (kg/l)	3,032 kg/l
Volume Solids (%)	57.4%
Weight solids (%)	88%
Flash point	28.5°C
Pot life (+20°C)	Approx. 3 – 5 hours
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m²/kg)	Approx. 5m² (at 40µm dry film thickness)
Gloss	Matt
Color	Grey
Temperature Stability	Dry Heat up to 200°C
VOC (g/l)	< 540g/l see CSF VOC: 2004/42/IIB(c)(540)540g/l
Processing temperature	+5°C till max. +40°C, max. Humidity 65%

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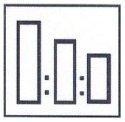
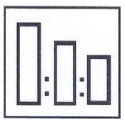
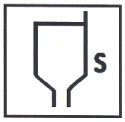
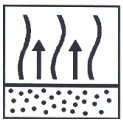
Application Data

	**Cleaning:**	IME.RS405/605/607 Reducer Surface must be dry and free from any contamination, e.g. oil, grease	
	**Preparation:**	Abrasive blast to EN ISO 12944, Part 4 (Sa 2.5) with a uniform blast profile of 20 to 50 µm	
	**Before using:** The product must be shaken before and thoroughly stirred directly after the Activator and Reducer have been added.		
	**Mixing ratio with Activator and Reducer:** (By weight - scale)	IME.FP402 Epoxy Primer Zinc Rich – Grey IME.AP402 EP Activator IME.RS405 Epoxy Reducer	1000 g 84 g 25-40 g
	**Mixing ratio with Activator and Reducer: (Wet on Wet Application)** (By weight - scale)	IME.FP402 Epoxy Primer Zinc Rich – Grey IME.AP402 EP Activator IME.RS405 Epoxy Reducer	1000 g 84 g 25-40 g
	**Viscosity:** 24 – 36 sec. (DIN4/20°C) Depending of the application process		
	**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 (1.5/1.6 mm wet on wet) 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 1.2 – 1.5mm	
	**Application:** **Film Thickness:** (Recommended 40 – 80µm)	**Option 1: Wet on wet** 1 full coat or ½ + 1 full coat 30 – 40 µm (DFT)	**Option 2: Sanded** 1 thin closed coat followed by 1 full coat 60 – 100 µm (DFT)
	**Between coats at 20°C:**	5 – 10 Minutes	
	Before baking at 20°C:	10 Minutes	

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	**Air – Dry at 20°C:**	Dry to sand: 10 – 16 hours
	Force – Dry at 60°C – 70°C:	30 – 40 Minutes 60°C object temperature
	**Recoatable:** **1 hour-24 hrs at 20°C:**	(For higher film thickness apply: Epoxy Primer IME.FP400/FP401) Epoxy Topcoat IME.TB400/401 PU Topcoat IME.TB500/10/11/12/20 After 24 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.