Light Industrial Product Line

These products are for professional use only

	Primer/Fondo/Appret/Primer/Imprimaciòn								
	1.774.1300 7-413	1.774.1400 7-414	2.704.0400	2.704.0440	2.704.0490	1.778.1000 7-810	1.778.2000 7-820	2.708.080X	2.705.050X
Substrates Supporti Supports Untergrund Sustratos	Cast Iron Bare steel Phosphated steel Light alloys Sandblasted steel	Cast Iron Bare steel Phosphated steel Light alloys	Steel Blasted steel Iron phosphated steel	Cast Iron Bare steel Phosphated steel Light alloys Sandblasted steel Zinc coated steel	Steel Blasted steel	Bare steel Phosphated steel	Bare steel Phosphated steel	Bare steel	Cast Iron/Bare steel/Phosphated steel/Galvanized steel/Light alloys Aluminum/Fiber reinforced plastic
Binder / Tinter ratio (by weight)	85/15	85/15	tinted	tinted	tinted	90/10	85/15	tinted	tinted
Hardener / catalizzatore / durcisseur / Härter / catalizador	9-010 9-011 (Fast)	9-010 9-011 (Fast)	9-020	9-020	9-050	NO	NO	NO	9-060 9-065 9-070
Thinner / Diluente / Diluant / Verdünner / Diluyente	1-410 1-400 (slow)	1-410	1-410	1-410	1-410 1-400 (slow)	1-610 1-215 1-205	1-610 1-215 1-205	1-610 1-215 1-205	1-430
Mixing ratio by weight Rapporto d'impiego per peso Proportions de melange en poids Mischungsverhältnis Gewicht Ratio mezcla por peso	7-413/ 9-010 or 9-011 1000:200	7-414/ 9-010 or 9-011 1000:100	2.704.0400/ 9-020 1000:100	2.704.0440/ 9-020 1000:150	2.704.0490/ 9-050 1000:75	7-810 no hardener	7-820 no hardener	2.708.080X no hardener	2.705.050X/ 9-060 or 9-065 1000:130 9-070 1000:140
Mixing ratio by volume Rapporto d'impiego volume Proportions de melange en volume Mischungsverhältnis Volumen Ratio mezcla por volumen	7-413/ 9-010 or 9-011 3,5 : 1	7-414/ 9-010 or 9-011 9 : 1	2.704.0400/ 9-020 6 : 1	2.704.0440/ 9-020 4 : 1	2.704.0490/ 9-050 4 : 1	7-810 no hardener	7-820 no hardener	2.708.080X no hardener	2.705.050X/ 9-060 or 9-065 or 9-070 5 : 1
Thinning Diluizione Dilution Verdünnung Diluir	25-30%	40-50%	Airmix/Airless: n/a Conventional: 0,5-1%	Airmix/Airless: 0-5% Conventional: 10-15%	Airless: max 10% Conventional: 10-15%	30-40%	30-40%	Airmix/Airless: Ready to use Conventional: 0-5%	Airmix/Airless: 10-15% Conventional: 13-15%
Spray viscosity DIN4 20°C Viscosità DIN4 20°C Viscosità AFNOR4 20°C Viskosität Viscosidad aplicación DIN4 20°C	18-22 sec	20-25 sec	12 sec (Din 6 20°C)	25-35 sec Airmix: 50-55 sec	N/A	20-30 sec	20-25 sec	20-25 sec Airmix: 35-40 sec	20-25 sec Airmix: 35-45 sec
Airless/Airmix Spray gun set up Ugello Buse Spritzdüse Pico fluido pistola	13-15	N/A	Tip airmix: 0.28 - 0.38 mm Tip airless: 0.33 mm	Tip airmix: 0.28 - 0.38 mm Tip airless: 0.33 mm	Tip airless: 17-23	13-15	13-15	9-11	13-15
Conventional Spray gun set up Ugello Buse Spritzdüse Pico fluido pistola	1.6-1.8 mm	1.6-1.8 mm	1.8 mm	1.8 mm	2-2.2 mm	1.6-1.8 mm	1.6-1.8 mm	1.4-1.7 mm	1.6-1.8 mm
Spray pressure / Pressione / Pression de pulverization / Spritzdruck / Presión aplicación	Conv: 3-4 bar Airless: 120-140 bar Airmix: 100-120 bar	Conventional: 3-4 bar	Airmix: 70-100 bar	Conv: 3 bar Airless: 160 bar Airmix: 70-100 bar Air cup (Air mix): 3.5	Airless: 140 bar minimum	Conventional: 3-4 bar Airless: 120-140 bar	Conventional: 3-4 bar Airless: 120-140 bar	Conv: 3-4 bar Airless:120-140 bar Airmix: 70-100 bar	Conv: 3-4 bar Airless:120-140 bar Airmix: 70-100 bar
Potlife Vita utile Durée de vie en pot Verarbeitungszeit Vida útil de la mezcla 20°C	6 h	8-10 h	4 h	3-4 h	4 h	Unlimited	Unlimited	Unlimited	3 h
Number of coats Numero di mani Nombre de couches Anzahl der Spritzgänge Número de capas	2	2	2	2	1-2	2	2	2	1-2
Flash off between coats Appassimento tra le mani Temps d'attente entre les couches Ablüftzeit zwischen den Spritzgängen Tiempo evaporación entre capas	10-15 min at 20°C	10-15 min at 20°C	15 min at 20°C	3-5 min at 20°C	10-15 min at 20°C	10-15 min at 20°C	10-15 min at 20°C	5-7 min at 20°C	5-10 min at 20°C
Dust free / Fuori polvere / Hors poussière / Staub frei / Libre de polvo at 20 °C	20-30 min	15-20 min	6-12 min	10-15 min	20-30 min	10-15 min	10-15 min	10-15 min	20-30 min
Handling / Manipolabile / Manipulable / Durchtrocknung / Totalmente seco at 20 °C	6-8 h	2-3 h	3 h	4 h	2-3 h	40-60 min	40-60 min	30-60 min	2-3 h
Drying times Tempi di essicazione Temps de séchage Ofentrocknung Tiempos de secado	50-60 min at 60°C	30-45 min at 60°C	30 min at 60°C	45-60 min at 60°C	4 h at 20°C 2 h at 40°C	24 h at 20°C	24 h at 20°C	24 h at 20°C	30-45 min at 60°C 4-6 h at 20°C
Overcoat time Tempi di sovraverniciatura Recouvrable Überlackierbar Tiempo para el repintado	Min 2 h and Max 3 weeks at 20°C without flatting	Min 2 hours at 20°C Max 2 months without flatting	After 60 minutes minimum, or up to 2 weeks maximum	After at least 1 hour minimum* After 1 month maximum* Wet on wet* *(for more details refer to the TDS)	Min 4 hours at 20°C	Min 1 hour at 20°C Max 1 month without flatting	Min 1 hour at 20°C Max 1 month without flatting	Min 1 hour at 20°C Max 1 month without flatting	Min 2 hours and Max 24 hours at 20°C without flatting
Overcoatable with / sovraverniciabile con Recouvrable avec / Überlackierbar mit / Repintable con	any 2K Selemix System topcoat	any 2K Selemix System topcoat	any 2K Selemix System and any 2K Selemix Aqua topcoat	any 2K Selemix System topcoat	any Selemix Epoxy Primer and any 2K Selemix System topcoat	any 1K Selemix System topcoat	any 1K Selemix System topcoat	any 1K and 2K Selemix topcoat (except epoxies)	any 2K Selemix System topcoat
Recommended Thickness / Spessore raccomandato / Épaisseur sèche recommandée / Trockenschichtdicke Espesor recomandado	40-80 microns	40-50 microns	70-100 microns	100-150 microns	75 microns	35-50 microns	35-50 microns	50-60 microns	150-200 microns
Tecnichal data sheet Dati tecnici Donees techniques Technische Daten Información tecnica	526	527	577	581	594	560	561	572	571

	Topcoat/Smalto/Laque/Decklack/Acabado																								
	1.771.1000 7-110	1.771.2000 7-120	1.771.3000 7-130	1.773-1000 7-310	1.773.2000 7-320	1.773.3000 7-330	1.774.1000 7-410	1.774.1200 7-412	1.775.1000 7-510	1.775.1100 7-511	1.775.1200 7-512	1.775.5000 7-550	1.775.3XXX 7-53X	1.775.3 800 7-538 7-539	1.776.1000 7-610	1.776.1100 7-611	1.776.2000 7-620	1.776.4900 7-649	2.776.0350	2.776.0600
Substrates Supporti Supports Untergrund Sustratos	2K Epoxy primer/ 2K Epoxy vinyl primer/ Old finishes/ Polyurethane and polyester fillers	2K Epoxy primer/ 2K Epoxy vinyl primer/ Old finishes/ Polyurethane and polyester fillers	PU primer 2K Epoxy primer	1K fast dry primer 1K fast dry primer extra	1K fast dry primer 1K fast dry primer extra	1K fast dry primer 1K fast dry primer extra	Bare steel Epoxy primer Epoxy vinyl primer Sandblasted steel	Bare steel Epoxy primer Epoxy vinyl primer Sandblasted steel	2K Epoxy primer 2K Epoxy vinyl primer/ Polyurethane and polyester fillers	2K Epoxy primer 2K Epoxy vinyl primer/ Sandblasted steel/ Polyurethane and polyester fillers	2K Epoxy primer/ 2K Epoxy vinyl primer/ Polyurethane and polyester fillers	2K Epoxy primer/ 2K Epoxy vinyl primer/ Polyurethane and polyester fillers	Cast Iron/Bare, Blasted, Phosphatated, Galvanized steel/Light alloys/ Aluminium/Fiber reinforced plastic	Cast Iron/Bare, Phosphated, Galvanized steel/ Light alloys/ Aluminium/Fiber reinforced plastic	Bare steel 1K fast dry primer 1K fast dry primer extra	Bare steel 1K fast dry primer 1K fast dry primer extra	Bare steel 1K fast dry primer 1K fast dry primer extra	Bare steel 1K fast dry primer 1K fast dry primer extra	Bare Steel Aluminium	Bare Steel Aluminium
Binder / Tinter ratio (by weight)	white 50/50 other colours 60/40	60/40	70/30	80/20	80/20	75/25	70/30	80/20	75/25	75/25	70/30	75/25	light colors 95/5 other colors 85/15	light colors 95/5 other colors 85/15	70/25+5% 6-530 drier For black colors only 70/20+10% 6-530 drier	72/25+3% 6-530 drier	95/5	70/25+5% 6-549 drier	tinted	tinted
Hardener / catalizzatore / durcisseur / Härter / catalizador	9-080	9-120 9-130 (extra fast)	9-090	NO	NO	NO	9-010 9-011 (fast)	9-010 9-011 (fast)	9-060 9-510 (for internal use only)	9-060 9-510 (for internal use only)	9-060/9-065 (large surfaces) / 9-080 (high resistance)	9-075 HS	9-070/9-080 9-075 HS	9-070/9-080 9-075 HS	NO	NO	NO	NO	NO	NO
Thinner / Diluente / Diluant / Verdünner / Diluyente	1-430 1-470 (slow)	1-430 1-470 (slow)	1-430 1-470 (slow)	1-215 1-205	1-215 1-205	1-215 1-205	1-410 1-400 (slow)	1-410	1-420 1-470 (slow)	1-420 1-208/1-470 (slow)	1-420 1-208/1-470 (slow)	1-480 1-208/1-470 (slow)	1-480 1-208/1-470 (slow)	1-480 1-470 (slow)	1-610 1-215 1-205	1-610 1-215 1-205	1-215 1-205	1-215	with 1-215/1-205 (1-610 for large surfaces or for temperatures above 30°C)	
Mixing ratio by weight Rapporto d'impiego per peso Proportions de melange en poids Mischungsverhältnis Gewicht Ratio mezcla por peso	7-110/9-080 1000:500	7-120/ 9-120 or 9-130 1000:500	7-130/9-090 1000:300	7-310 no hardener	7-320 no hardener	7-330 no hardener	7-410/ 9-010 or 9-011 1000:500	7-412/ 9-010 or 9-011 1000:200	External use: 7-510/9-060 1000:300 Internal use: 7-510/9-510 1000:500	External use: 7-511/9-060 1000:150 Internal use: 7-511/9-510 1000:250	Standard mode: 7-512/ 9-060 or 9-065 1000:250 High Resistance: 7-512/9-080 1000:350	7-550/9-075 1000:400	Standard mode: 7-53X/9-070/9-080 1000:200 HS mode: 7-53X/9-075 1000:130	Standard mode: 7-53X/9-070/9-080 1000:200 HS mode: 7-53X/9-075 1000:130	7-610 no hardener	7-611 no hardener	7-620 no hardener	7-649 no hardener	2.776.0350 no hardener	2.776.0600 no hardener
Mixing ratio by volume Rapporto d'impiego volume Proportions de melange en volume Mischungsverhältnis Volumen Ratio mezcla por volumen	7-110/9-080 5 : 3	7-120/ 9-120 or 9-130 2 : 1	7-130/9-090 3 : 1	7-310 no hardener	7-320 no hardener	7-330 no hardener	7-410/ 9-010 or 9-011 3 : 2	7-412/ 9-010 or 9-011 3,5 : 1	External use: 7-510/9-060 3,5 : 1 Internal use: 7-510/9-510 2 : 1	External use: 7-511/9-060 6 : 1 Internal use: 7-511/9-510 3 : 1	Standard mode: 7-512/ 9-060 or 9-065 4 : 1 High Resistance: 7-512/9-080 5 : 2	7-550/9-075 2,5 : 1	Standard mode: 7-53X/9-070/9-080 4 : 1 HS mode: 7-53X/9-075 6 : 1	Standard mode: 7-53X/9-070/9-080 4 : 1 HS mode: 7-53X/9-075 6 : 1	7-610 no hardener	7-611 no hardener	7-620 no hardener	7-649 no hardener	2.776.0350 no hardener	2.776.0600 no hardener
Thinning Diluizione Dilution Verdünnung Diluir	10-15%	10-15%	25-35%	100-120%	60-80%	40-60%	40-50%	20-30%	35-40% (for internal use 20-30%)	35-40% (for internal use 30-35%)	20-30% (for High resistance 0-10%)	10-20%	Standard mode: Conv: 25% Airless: 5% HS mode: max 5%	Standard mode: Conv: 30-35% Airless: 25% HS mode: Conv: 25% Airless: 10%	25-35%	25-35%	20-30%	45-55%	20-25%	5-15%
Spray viscosity DIN4 20°C Viscosità DIN4 20°C Viscosità AFNOR4 20°C Viskosität Viscosidad aplicación DIN4 20°C	16-18 sec	20-23 sec	25-28 sec Airmix: 28-30 sec	18-22 sec	18-22 sec	18-22 sec	18-22 sec	18-22 sec	18-20 sec	18-20 sec	18-20 sec	23-25 sec	20-25 sec Airless 18-25 DIN6 at 20°C	20-25 sec Airless 25-30 sec	18-22 sec	18-22 sec	20-25 sec	18-22 sec	16-19 sec	19-29 sec
Airless/Airmix Spray gun set up Ugello Buse Spritzdüse Pico fluido pistola	9-11	9-11	9-11	N/A	N/A	N/A	9-11	9-11	9-11	9-11	9-11	9-11	Standard mode: 11-17 (from 7-530 to 7-535) or 11-13 (7-536/7-537 HS mode:13-15	11-13	9-11	9-11	N/A	9-11	11 - 13 thou 50° tips	11 - 13 thou 50° tips
Conventional Spray gun set up Ugello Buse Spritzdüse Pico fluido pistola	1.3-1.6 mm	1.3-1.6 mm	1.5-1.8 mm	1.4-1.7 mm	1.4-1.7 mm	1.4-1.7 mm	1.4-1.7 mm	1.4-1.7 mm	1.4-1.7 mm	1.4-1.7 mm	1.4-1.7 mm	1.4-1.8 mm	1.8 mm	1.8 mm	1.4-1.7 mm	1.4-1.7 mm	1.6-1.8 mm	1.4-1.7 mm	1.6-1.8 mm	1.6-1.8 mm
Spray pressure / Pressione / Pression de pulverization / Spritzdruck / Presión aplicación	Conv: 3-3,5 bar Airless:120-140 bar Airmix: 70-100 bar	Conv: 3-3,5 bar Airless:120-140 bar Airmix: 70-100 bar	Conventional: 2,5-3 bar Airmix: 70-100 bar	Conventional: 3-4 bar	Conventional: 3-4 bar	Conventional: 3-4 bar	Conventional: 3-4 bar Airless: 120-140 bar	Conventional: 3-4 bar Airless: 120-140 bar	Conventional: 3-4 bar Airless: 120-140 bar	Conventional: 3-4 bar Airless: 120-140 bar	Conventional: 3-4 bar Airless: 120-140 bar	Conv: 3-4 bar Airless:120-140 bar Airmix: 70-100 bar	Conv: 3-4 bar Airless:100-140 bar Airmix: 70-100 bar	Conv: 3-4 bar Airless:100-140 bar Airmix: 70-100 bar	Conventional: 3-4 bar Airless: 120-140 bar	Conventional: 3-4 bar Airless: 120-140 bar	Conventional: 3-4 bar	Conventional: 3-4 bar Airless: 120-140 bar	Conventional: as per spraygun producer's recommendation Airmix: 70-100 bar	Conventional: as per spraygun producer's recommendation Airmix: 70-100 bar
Potlife Vita utile Durée de vie en pot Verarbeitungszeit Vida útil de la mezcla 20°C	2 h	2 h	2-3 h	Unlimited	Unlimited	Unlimited	6-8 h	6-8 h	90 min	90 min	90 min	> 2 h	Conventional: 3 hours Airless & HS mode: 2-3 h	Conventional: 3 hours Airless & HS mode: 2-3 h	Unlimited	Unlimited	Unlimited	Unlimited	Unlimited	Unlimited
Number of coats Numero di mani Nombre de couches Anzahl der Spritzgänge Número de capas	2	1 light + 1 full	2	2-3	2-3	2-3	2	2	2	2	2	2	Standard mode: Conv: 2-3 Airless: 1-2 HS mode: Airless:1-2	Standard mode: Conv: 2-3 Airless: 1-2 HS mode: Conventional: 2 Airless:1-2	2	2	2-3	2	1-2	1-2
Flash off between coats Appassimento tra le mani Temps d'attente entre les couches Ablüftzeit zwischen den Spritzgängen Tiempo evaporación entre capas	10 min at 20°C	15-20 min at 20°C	5-10 min at 20°C	10-15 min at 20°C	10-15 min at 20°C	10-15 min at 20°C	10-15 min at 20°C	15-20 min at 20°C	10-15 min at 20°C	10-15 min at 20°C	10-15 min at 20°C	10-15 min at 20°C	10-15 min at 20°C	15-20 min at 20°C	5-10 min at 20°C	5-10 min at 20°C	5-10 min at 20°C	5-10 min at 20°C	10-15 min at 20°C	10-15 min at 20°C
Dust free / Fuori polvere / Hors poussière / Staub frei / Libre de polvo at 20 °C	10 min	20 min	1-2 h	10-15 min	10-15 min	10-15 min	30-40 min	20-30 min	10-15 min	15-20 min	10-15 min	10-15 min	Std mode: 1 h HS mode: 30 min	Std or HS mode: 45-60 min	10-15 min	10-15 min	10-15 min	10-15 min	20-30 min	20-30 min
Handling / Manipolabile / Manipulable / Durchtrocknung / Totalmente seco at 20 °C	4-5 h	5-6 h	1 day	40-50 min	40-50 min	60-80 min	6-8 h	6-8 h	4-6 h	4-5 h	4-5 h	4-6 h	Std mode: 1,5-2 h HS mode: 1h	Std or HS mode: 1,5-2 h	4-5 h	4-5 h	2-3 h	2-3 h	1-2 h	1-2 h
Drying times Tempi di essicazione Temps de séchage Ofentrocknung Tiempos de secado	30-40 min at 60°C	40-50 min at 60°C	40-50 min (at metal temperature) at 60°C	24 h at 20 °C	24 h at 20 °C	24 h at 20 °C	60 min at 60°C	60 min at 60°C	30-40 min at 60°C	30-40 min at 60°C	30-40 min at 60°C	45 min at 60°C	45 min at 60°C	45 min at 60°C	24-48 h at 20°C	24-48 h at 20°C	24-48 h at 20°C	16-24h at 20°C	30-40 min at 180°C	30-40 min at 180°C
Overcoat time Tempi di sovraverniciatura Recouvrable Überlackierbar Tiempo para el repintado	Always possible after sanding	Always possible after sanding	Always possible after sanding	Possible after flatting with P320-360 dry or P600 wet	Possible after flatting with P320-360 dry or P600 wet	Possible after flatting with P320-360 dry or P600 wet	Min 3 hours and Max 24 hours at 20°C without flatting	Min 3 hours and Max 24 hours at 20°C without flatting	Min 14 hours and Max 24 hours at 20°C without flatting	Min 14 hours and Max 24 hours at 20°C without flatting	24 hours at 20°C without flatting	Min 16 hours and Max 24 hours at 20°C without flatting	Overcoatable with themselves, no sanding: 10 days-5 months after drying. Surface to be throughly cleaned.	Overcoatable with themselves, no sanding: 10 days-5 months after drying. Surface to be throughly cleaned.	Min - 6 days 20°C Max 1 month without flatting. or Min - 1 day 20°C by addition of 10% hardener 9-510 in the topcoat ready to spray	Min - 6 days 20°C Max 1 month without flatting. or Min - 1 day 20°C by addition of 10% hardener 9-510 in the topcoat ready to spray	Always possible	Min 24 hours 20°C Max 4-5 days without flatting	After 1 - 2 hours at 20°C or 30 minutes at 60°C and with light sanding	After 1 - 2 hours at 20°C or 30 minutes at 60°C and with light sanding
Overcoatable with / sovraverniciabile con Recouvrable avec / Überlackierbar mit / Repintable con	7-110	7-120	7-130	7-310	7-320	7-330	7-410	7-412	7-510	7-511	7-512	7-550	7-53x	7-538 or 7-539	7-610	7-611	7-620	7-649	2.776.0350	2.776.0600
Recommended Thickness / Spessore raccomandato / Épaisseur sèche recommandée / Trockenschichtdicke Espesor recomandado	50 microns	50 microns	80-90 microns Airmix: 90-100 microns	35-45 microns	35-45 microns	35-45 microns	50 microns	50 microns	50 microns	45-50 microns	50 microns	50-70 microns	80-100 microns	80-100 microns	40-50 microns	40-50 microns	40-50 microns	40-50 microns	Min 25 microns Max 50 microns	Min 25 microns Max 50 microns
Tecnichal data sheet Dati tecnici Donees techniques Technische Daten Información tecnica	510	511	576	517	516	515	520	522	535	536	537	586	570	592	540	541	543	595	588	588

Data displayed are indicative, please refer always to the most updated TDS version.

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