USAGE CHART *PRIMERS*

	MIXING RATIO	APPLICATION TYPE	HARDENER[1] REPAIR SIZE Small repair 15–20°C	HARDENER[1] Normal repair 20–30°C	HARDENER[1] Total repair >30°C	THINNER[1] Small repair 15–20°C	THINNER[1] Normal repair 20–30°C	THINNER[1] Total repair >30°C	DIRECT TO PLASTIC ADDITIVE 7035 10% INSTEAD OF THINNER	SPRAY GUN SET UP Nozzle / Pressure	APPLICATION No. of coats / Film thickness	FLASH-OFF Between layers / Before baking	DRYING TIME PRIOR TO SANDING 20°C/68°F	60°C/140°F	IR	ADHESION COMPARISON TO DIFFERENT SUBSTRATE MATERIALS**
7120 M12 SFR Superfast HS ultra rapid surfacer	5:1	STANDARD APPLICATION	← 7125 →			7030 10–20%	7050 10–20%	7070 10–20%	✓	1.4–1.8 mm 1.5–2.0 bar	1–2 coats 50–100 µm	3–5 min until matt	15–20 min	5 min	5 min	Fe - 1&2 OEM - 1 Zn - 1&2 PP - 3 Alu - 1&2 Old - 1
7300 M30 Superfast 2K Primer High build primer filler spray	READY FOR USE	/	/	/	/	/	/	/	✕	SPRAYING DISTANCE 15–25 cm	2–3 coats 50–100 µm	2–3 min until matt	15–20 min	5 min	5 min	Fe - 2 OEM - 1 Zn - 2 PP - 3 Alu - 2 Old - 1
9900 M9 Surfacer Universal HS primer filler	3:1 FAST SYSTEM	STANDARD APPLICATION	← 3950 →			7030 10–20%	7050 10–20%	/	✓	1.4–1.8 mm 1.5–2.0 bar	1–2 coats 60–120 µm	5–10 min until matt	60 min (60–120 µm) 90 min (120–180 µm)	5–7 min (60–100 µm)	3–5 min (60–100 µm)	Fe - 1 OEM - 1 Zn - 1 PP - 3 Alu - 1 Old - 1
	5:1 STANDARD SYSTEM	STANDARD APPLICATION	9220, 9230	← 9250, 9270 →		7030 10–20%	7050 10–20%	7070 10–20%	✓	1.4–1.8 mm 1.5–2.0 bar	1–2 coats 60–180 µm	5–10 min until matt	6–8 h	25–30 min	20–25 min	
		HIGH BUILD APPLICATION				7030 0–10%	7050 5–10%	7070 5–10%		1.8–2.2 mm 1.5–2.0 bar	3–5 coats 240–350 µm		>12 h	40 min	30 min	
7080 M8 Acryfill Universal HS primer filler	4:1	STANDARD APPLICATION	9082, 9085			7030 0–10%	7050 0–10%	7070 0–10%	✓	1.4–1.8 mm 1.5–2.0 bar	1–2 coats 60–180 µm	5–10 min until matt	2.5–3 h	10–15 min	5–7 min	Fe - 1&2 OEM - 1 Zn - 1&2 PP - 3 Alu - 1&2 Old - 1
		HIGH BUILD APPLICATION									3–5 coats 240–350 µm		3–4 h	20–25 min	25–40 min	
7100 M10 2K Sealer Wet-on-wet & E-coat primer-sealer	4:1	DIRECT TO E-COAT DIRECT TO METAL	9220, 9230	← 9250, 9270 →		7030 10–20%	← 7050 10–20% →		✓	1.2–1.4 mm 1.5–2.0 bar	1–2 coats 30–35 µm	5 min	>30 min flash-off before overcoating Up to 4 days of recoatability			Fe - 1 OEM - 0 Zn - 1 PP - 3 Alu - 1 Old - 1
7025 DTP Primer Direct-to-plastic 1K primer	/	WET ON WET	/	/	/	7030 50%	7050 50%	7070 50%	✓ WITHOUT ADDITIVE	1.2–1.4 mm 1.8–2.0 bar	1–1.5 coats 20–40 µm	10 min	>10 min flash-off before overcoating Up to 24 hours of recoatability			Fe - / OEM - / Zn - / PP - 0&1 Alu - / Old - /
7026 DTP Primer Direct-to-plastic 1K primer	/	WET ON WET	/	/	/	/	/	/	✓ WITHOUT ADDITIVE	SPRAYING DISTANCE 15–20 cm	1–1.5 coats	10–15 min	>10 min flash-off before overcoating Up to 24 hours of recoatability			Fe - / OEM - / Zn - / PP - 0&1 Alu - / Old - /
1818 Fast-Prime High build primer filler spray	READY FOR USE	/	/	/	/	/	/	/	✕	SPRAYING DISTANCE 25–30 cm	1–3 coats 20–45 µm	3–5 min until matt	>10–30 min flash-off before overcoating Up to 12 hours of recoatability			Fe - 1 OEM - 1 Zn - 1 PP - 3 Alu - 1 Old - 1
7020 M2 Compact Rapid 1K acrylic primer filler	/	STANDARD APPLICATION WET ON WET	/	/	/	← 7050 5% →			✕	1.4–1.8 mm 1.5–2.0 bar	1–3 coats 30–50 µm	5–10 min until matt	>30–60 min flash-off before overcoating Up to 48 hours of recoatability			Fe - 1 OEM - 1 Zn - 1 PP - 3 Alu - 1 Old - 1
7220 M22 Wash Primer 2K chromate-free wash primer	1:1	WET ON WET	← 7225 →			/	/	/	✕	1.2–1.4 mm 1.5–2.0 bar	1 closed coat 10–20 µm	10–15 min	>10–15 min flash-off before next coating			Fe - 1 OEM - / Zn - 1 PP - / Alu - 1 Old - /
4110 Etch-Prime 1K etch primer spray	READY FOR USE	/	/	/	/	/	/	/	✕	SPRAYING DISTANCE 25–30 cm	2–3 coats 20–30 µm	3–5 min until matt	>15–20 min flash-off before overcoating Up to 24 hours of recoatability			Fe - 1 OEM - 1 Zn - 1 PP - / Alu - 1 Old - /
2110 Epo-Prime High build epoxy primer	2:1 FAST SYSTEM	STANDARD APPLICATION	← 2130 →			2115: 20% STANDARD APPLICATION 2115: 40% WET-ON-WET APPLICATION			✓	STANDARD 1.4–1.8 mm 1.5–2.0 bar	STANDARD 1–3 coats 50–150 µm	5–10 min until matt	DRY TO SAND: 16–24 h / 20°C >30 min flash-off before overcoating 24 h of recoatability			Fe - 1 OEM - 1 Zn - 1 PP - 3 Alu - 1 Old - 1
	3:1 STANDARD SYSTEM	WET ON WET	← 2120 →			2115, 7050: 10% STANDARD APPLICATION 30% WET-ON-WET APPLICATION				WET ON WET 1.2–1.4 mm 1.5–2.0 bar	WET ON WET 1 coat 30–50 µm	10–20 min until matt	DRY TO SAND: 90–120 min / 20°C >20 min flash-off before overcoating 24 h of recoatability			
2100 Epo-Prime Epoxy primer spray	READY FOR USE	STANDARD APPLICATION WET ON WET	/	/	/	/	/	/	✕	SPRAYING DISTANCE 10–15 cm	2 coats 60 µm	5 min until matt	>20–30 min flash-off before overcoating Up to 12 hours of recoatability			Fe - 1 OEM - 1 Zn - 1 PP - 3 Alu - 1 Old - 1
4020 Z-Prime Zinc protection spray	READY FOR USE	/	/	/	/	/	/	/	✕	SPRAYING DISTANCE 20–25cm	2–3 coats 20–30 µm	2–3 min until matt	>20–30 min flash-off before overcoating Up to 48 hours of recoatability			Fe - 1 OEM - / Zn - 1 PP - / Alu - / Old - /
7015 Adhesion Promoter 1K plastic primer (transperent or silver)	READY FOR USE	/	/	/	/	/	/	/	✕	1.2–1.4 mm 1.8–2.0 bar	1 coat 5–7 µm	5–10 min	>15–20 min flash-off before overcoating Up to 2 hours of recoatability			Fe - / OEM - / Zn - / PP - 1 Alu - / Old - /
7014 Adhesion Promoter Plastic primer spray	READY FOR USE	/	/	/	/	/	/	/	✕	SPRAYING DISTANCE 20–35 cm	1–2 coats 5–7 µm	5–10 min	>15–20 min flash-off before overcoating Up to 2 hours of recoatability			Fe - / OEM - / Zn - / PP - 1 Alu - / Old - /

1 Choice of hardener and thinner speed depends on size of substrate and application temperature and has an influence on time to polish.
* Thinner values marked with * are not compliant with VOC regulation.

** ADHESION COMPARISON TO DIFFERENT SUBSTRATE MATERIALS
/ – Not applicable
0 – Can be applied directly without sanding
1 – Can be applied directly after sanding/matting
2 – Prime larger sand-throughs/bare metal substrates with Ecoat primer or Etch primer
3 – Prime plastic substrates with 7014, 7015 or use 7035 additive

Fe - Steel
Zn - Galvanized Steel
Alu - Aluminium
OEM - New parts with E-coat
PP - Plastic Parts (PP-EPDM, PE. ABS ...)
Old - Old paintwork

9900, 7120, 7080, 7100, 7025 GREYSHADE SYSTEM CHART

	F1	F3	F3	F5	F5	F6	F6	F7
XXXX-A	100%	95%	75%	/	80%	/	35%	/
XXXX-B	/	5%	/	/	20%	50%	65%	100%
XXXX-C	/	/	25%	100%	/	50%	/	/

GREYSHADE COLOR IDENTIFICATION

F1 F3 F5 F6 F7

For more info scan the code

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2024 / Prod. Nr. 7252-ENG

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