



Technical data sheet

2024-2

7100 M10 2K Sealer, Gray

Top-quality primer suitable for wet-on-wet application directly on new unsanded ecoated panels. With easy application it delivers smooth surface finish. 2K sealer 7100 M10 enables fast repair process with elimination of sanding and drying times. The primer can be overcoated wet-on-wet after minimum 30 minutes from application and even after 4 days from application without sanding.

- application directly to new ecoated parts without sanding
- direct to metal application, adhesion on Zinc-platted and Aluminium substrates
- minimum flash-off before topcoat application: 30 minutes
- maximum flash-off without sanding: 4 days
- smooth surface delivers top finish results
- 4:1 mixing ratio (hardeners: 9220, 9230, 9250, 9270)

Substrate preparation

Clean, dry, and degrease the surface with a suitable anti-silicone cleaner (art. 9515). Before application of the primer filler on bare steel/metal, sand the surface. Bare steel should be lightly abraded and completely rust free before application.

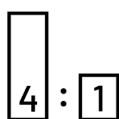
- New ecoated (factory primed) parts/panels: use anti-silicone cleaner
- Steel parts: sand with P400/dry or P800/wet.
- Old coatings sand with P280 - P320/dry or P800/wet.
- GRP or Fiberglass sand with P320/dry.
- Polyester Fillers sand with P120-P320/dry.
- Zn and Alu: Scuffing pad + matting paste

The primer can be applied directly, but a 2K Epoxy primer is recommended where optimum adhesion and corrosion resistance is required. It is recommended to use appropriate primer to optimize adhesion and corrosion protection on aluminium and galvanized steel surfaces.

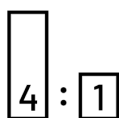
⁽¹⁾ Application over wash/etch primers is not recommended.

Substrate preparation


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|  | | By volume | By weight |
|---|---------------------------------|-----------|-----------|
| | 7100 M10 2K Sealer, Gray | 4 | 1000 |
| | 9220/9230/9250/9270 HS Hardener | 1 | 170 |
| | 7030/7050 Acrylic Thinner | 10 - 20 % | 65 - 130 |

Application on plastic

|  | | By volume | By weight |
|--|---------------------------------|-----------------|-----------------------|
| | 7100 M10 2K Sealer, Gray | 4 | 1000 |
| | 9220/9230/9250/9270 HS Hardener | | 170 |
| | 7035 4Plastic Adhesion additive | 10 % | 65 |
| | 7030/7050 Acrylic Thinner | 0 - 10 % (1) | 0 - 65 ⁽¹⁾ |
| (1) Add more thinner to adjust spray viscosity. | | | |

Spray gun setup

| | | |
|---|--------------------------|----------------------------|
|  | Nozzle | 1,2 - 1,4 mm |
| | Pressure (gravity feed): | 1.5 - 2.0 bar |
| | Pressure (suction feed): | Verify manufacturer's info |

Application

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| | | |
|---------------------------|--|--|
| Number of coats: | 1 – 2 coats (Apply 1 full single coat or 1 light + 1 full to give a film thickness of 30 – 35 microns) | |
| Flash-off between layers: | 5 min | |
| Total dry film build: | 30 – 35 µm | |

Overcoating



| | | |
|--|----------|--|
| MIN flash-off before next coating (20°C/68°F): | 30 min | |
| MAX flash-off before next coating (20°C/68°F): | < 96 h * | |
| After 4 days thorough sanding with P400 – P500 is needed before topcoat system can be applied. | | |
| * This time can be shorter if faster hardener speed is used. | | |

| Hardener speed | MAX flash-off time | MIN flash-off time |
|----------------|--------------------|--------------------|
| 9220 | Same working day | 20 min |
| 9230 | < 24 h | 30 min |
| 9250 | 96 h | 30 min |
| 9270 | 96 h | 30 min |

Drying



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Dry to sand
(20°C)

Next day

Potlife (20°C)

60 min

Complementary products

- 9220/9230/9250/9270 Hardener
- 7030/7050 Acrylic Thinner
- 7035 4Plastic Adhesion additive

Application on plastic parts

In case of coating plastics: Before application, reheat the object to be painted for 60 minutes at 60 °C/140 °F. Degrease the surface with Silco antisilicone degreaser. Sand/matt with matting paste. Clean again with Silco antisilicone degreaser. Allow parts to dry completely. ATTENTION: Sanded material must be removed completely! After this preparation we recommend doing a wetting test with water. If the water rolls off quickly repeat the pre-treatment. Additionally, use of Antistatic Degreasing Wipe (art.no. 2215) is recommended. Due to the most different kinds of plastic and compounds on the market we recommend pre-testing the product on original plastic parts (application and adhesion).

Packaging

| Product no. | Description | Volume/Weight | Packaging [pcs/box] |
|-------------|-------------|---------------|------------------------|
| 7100-A-1 | Blue | 1 L | 6 |
| 7100-A-3,5 | | 3,5 L | 2 |
| 7100-B-1 | Dark grey | 1 L | 6 |
| 7100-B-3,5 | | 3,5 L | 2 |
| 7100-C-1 | Light grey | 1 L | 6 |
| 7100-C-3,5 | | 3,5 L | 2 |

Volatile organic compounds



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The VOC value for this product is 540 g/L

The product category is VOC 2004/42/IIIB(c)(540).

Additional information

Spray viscosity: 15 – 16 s DIN4

Density: 1,43 – 1,48 kg/L

Theoretical coverage (ready to spray): 14 m²/ 30 mm

Testing of material

Any kind of testing of the applied material (adhesion test, stone-chip test, chemical resistance, salt chamber test ...) has to be done at least 15 days after the application.

Shelf life

Min. 24 months from the production date under normal storage conditions and unopened can.

Additional information

FOR PROFESSIONAL USE ONLY!

Always read the instructions.

IMPORTANT: This product contains hazardous substances at work so it is necessary to always use/wear appropriate protective equipment. For further instructions, check the label on the product and safety data sheet. A person who uses the product for any purpose other than recommended in this technical data sheet, acts at his own risk. It is the user's responsibility to take all necessary steps to fulfil the local legislation.

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public.

Information and methods described are based on the best information and practices known to us and serve merely as guidelines for optimal use, without liability to performance, results or fitness for any intended use. We do not accept any responsibility for the behaviour of the product or damage arising from the use of the product. Before using the product, the user must check if this is the latest version.

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Notes, other information



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(1) Acidic etch/wash primers contain phosphoric acid to etch the metal surface and promote adhesion. Residual acidity can interfere with the curing process of the epoxy. The acid residue can react with the amines in the epoxy, potentially leading to poor adhesion and compromised coating integrity.

Because M10 primer also consists partially of epoxy resin, the application over wash/etch primers is not recommended.