

7-413

EPOXY PRIMER

PRODUCT DESCRIPTION

7-413 Epoxy Primer is a high build 2-pack epoxy primer which may be used in a wet on wet system. It is intended to protect ferrous substrates



SELECTION AND PREPARATION OF SUBSTRATES



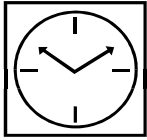
Cast Iron	Sand
Bare steel	P80-120 (dry) or shot blast
Phosphated steel	P80-120 (dry)
Light alloys	Scotchbrite
Sandblasted steel	P280-320 (dry)

*Do not use over wash primers or synthetic primers.
Degrease thoroughly prior to painting.*

APPLICATION GUIDE

	AIRLESS		CONVENTIONAL	
	Mixing ratio (by weight):	7-413 tinted 1000	7-413 tinted 1000	
		9-010 * 200	9-010 * 200	
		1-410 ** 250-300	1-410 ** 250-300	
	Mixing ratio (by volume):	7-413 3.5	7-413 3.5	
		9-010 * 1	9-010 * 1	
		1-410 ** 1	1-410 ** 1.3 – 1.6	
	* 9-011 Fast Hardener can be used	* 9-011 Fast Hardener can be used		
	** For large areas use 1-400 Slow Thinner	** For large areas use 1-400 Slow Thinner		
	Pot life 20°C: 6 hours	Pot life 20°C: 6 hours		
	Spray viscosity: 18-22 secs Din 4 20°C	Spray viscosity: 18-22 secs Din 4 20°C		
	Spray gun set up: 13 – 15	Spray gun set up: 1.6-1.8 mm		
	Spray pressure: 120-140 bar	Spray pressure: 3-4 bar		
	Number of coats: 2	Number of coats: 2		
	Flash off between coats: 10-15 minutes 20°C	Flash off between coats: 10-15 minutes 20° C		

APPLICATION GUIDE



Drying times at 20°C

Dust free: 20-30 minutes

Handling: 6-8 hours



Total dry film build: 40-80 microns

Flatting (if necessary): After 50-60 min 60°C
or 24 hours 20°C

Overcoat/recoat time with any SELEMIX SYSTEM topcoat 2 hours min and 24 hours max 20°C
without flatting

TECHNICAL DATA

Theoretical coverage 6.5 - 7 m² / l ready to spray giving 50µm
dry film thickness

HEALTH AND SAFETY

Please refer to Material Safety Data Sheet for full health and safety details and storage regulations

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further enquiries as to the stability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of our experience and our policy of continuous product development. Drying times quoted are average times at 20°C. Film thickness, humidity and shop temperature can all affect drying times.

Selemix System is a brand of PPG Group

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