

**TECHNICAL DATASHEET**

# 2.704.0490

## SELEMIX 2K ZINC RICH EPOXY PRIMER

### PRODUCT DESCRIPTION

2.704.0490 is a grey/reddish grey two component Zinc Rich Epoxy Primer. The high Zinc content of the primer film, gives a cathodic protection if the film is damaged, as it combines the toughness of an epoxy with the superior protection of Zinc. It has outstanding resistance to severe weathering. Applied as part of a Selemix coating system 2.704.0490 provides superior performance in a wide range of corrosive environments. With suitable topcoats it withstands splash or spillage of water, solvents, chemicals and petroleum products. It is recommended for use on Structural steel, machinery pipes and tank exteriors and general maintenance.

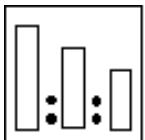
### SELECTION AND PREPARATION OF SUBSTRATES



For best results, this primer should be applied over:-  
 Steel – blast in accordance with ISO 8501-1 SA 2.5 or SSPC – SP6 Blast to achieve a 35 – 65 micron profile (1.5 – 2.5 mils). Remove abrasive residues and dust from the surface.  
 Apply 2.704.0490 as soon as possible after surface preparation to prevent any contamination. Do not leave blasted steel overnight.

### APPLICATION GUIDE

**Thoroughly mix the primer with a power mixer before adding hardener**



*Mixing ratio:*

*Primer 2.704.0490:*  
*Hardener 1.959.4050:*

*Thinner 1.911.4410*

*Thinner 1.911.4400*

*Pot Life 20°C:*



*Spray gun set up:*

*Spray Pressure*

*Number of Coats*

#### AIRLESS SPRAY APPLICATION *by volume*

4  
 1

Thin only as needed for workability – 10% maximum

This slow thinner can be used as an alternative.

4 hours

Airless Tip 17 – 23 thou

140 bar minimum

1 - 2



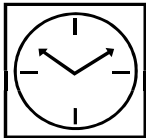
### APPLICATION BY CONVENTIONAL OR PRESSURE POT

This material may be applied by conventional spray gun or pressure pot by adding 10 – 15% thinner 1-410. Separate air and fluid pressure regulators, mechanical pot agitator and a moisture and oil trap in the main compressed air supply line are recommended. Large fluid tips – 2.0 / 2.2mm will be needed.



### BRUSH/ROLLER APPLICATION

Suitable for small areas only, such as touch-up, repairs and stripe coating.



*Drying times at 20°C for 75µm DFT:*

*Touch free:*

3 hours

*Minimum overcoating time:*

4 hours

*Minimum overcoating time @40°C:*

2 Hours

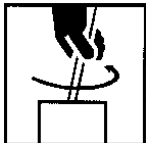
*Total dry film build:*

75 microns minimum

Drying times depend on air and steel temperature, applied film thickness, ventilation and other environmental conditions. Times are proportionally shorter at higher temperatures and longer at lower temperatures.

## MIXING AND APPLICATION PROCEDURE

**Important to follow this procedure carefully**



1. Flush equipment thoroughly using clean solvent
2. Stir primer to an even consistency with a **power stirrer**.
3. Add hardener to primer and **continue stirring** for 5 minutes.
4. Strain through a 60 mesh filter to prevent possible clogging of equipment.
5. Thinning is not normally required for airless application. 10% thinner may be added for workability. **Stir** during application to maintain uniformity of the material. Overlap each pass 50% to avoid bare areas, pinholes or sags.
6. Double coat all welds, rough spots, sharp edges and corners, rivets bolts etc.
7. Application at 120 microns wet film thickness will normally provide a dry film thickness of 75 microns. Avoid excessive film builds which can lead to cohesive failure.
8. Check thickness of dry coating, and if less than specified, apply additional material as needed.
9. Small damaged areas may be touched up by brush. Large areas by spray application.
10. In confined areas, ventilate with clean air during the application and drying processes until all solvents are removed. The temperature and humidity of the ventilating air must be such that moisture condensation will not form on the primer surface.
11. Clean all application equipment immediately after use, or at least at the end of each working day.

## TECHNICAL DATA

<i>Theoretical coverage:</i>	8.8 m <sup>2</sup> /l @ 75 microns
<i>RFU Solid content (by volume)</i>	66%
<i>Weight % of Zinc in Dry film</i>	81%
<i>Density:</i>	2.8 kg/l (mixed product)
<i>Temperature Resistance:</i>	205°C
<i>Flash Point:</i>	Both Primer and Hardener > 30°C

## RECOMMENDED OVERCOATING SYSTEMS

Selemix Epoxy Primers as intermediates coats followed by any PUR and Acrylic Selemix topcoats.

Selemix PUR or Acrylic topcoats.

## STORAGE LIMITATIONS

As this product contains the high amount of zinc powder, zinc sedimentation is expected when stored for a long time. In this case, turn over of container prior to use is recommendable to prevent the heavy sedimentation of zinc powder. When use this long stored paint, dissolve sediments of zinc powder with mechanical agitator to make paint to homogeneous state.

## 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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