

TECHNICAL DATASHEET

2.704.0440 / 2.704.0441

HB ANTICORROSIVE EPOXY PRIMER – GREY / WHITE

PRODUCT DESCRIPTION

SELEMIX 2.704.0440 is a grey 2K high build epoxy primer containing anticorrosive pigments, 2.704.0441 is the white version.

It is recommended for use on steel, zinc plated steel and aluminium providing excellent protection against corrosion. It has outstanding chemical resistance, low VOC content and ensures a high performance coating systems in aggressive industrial environments.

SELECTION AND PREPARATION OF SUBSTRATES



Cast Iron
Bare steel
Phosphated steel
Light alloys
Sandblasted steel
Zinc coated steel

Sand
P80-120 (dry) or shot blast
P80-120 (dry)
Scotchbrite
P280-320(dry)

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

PRODUCTS

2 Primers :

2.704.0440 HB ANTICORROSIVE EPOXY PRIMER – GREY
2.704.0441 HB ANTICORROSIVE EPOXY PRIMER – WHITE

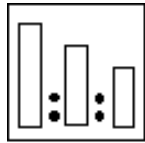
2 Hardeners :

9-020 Epoxy Hardener
9-025 Fast Curing Epoxy Hardener

2 Thinners :

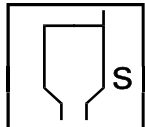
1-410 Medium Epoxy Thinner
1-400 Slow Epoxy Thinner

APPLICATION GUIDE



Mixing ratio:
Primer 2.704.0440:
Hardener 9-020 or 9-025:
Thinner 1-410 or 1-400:

AIRMIX / AIRLESS		CONVENTIONAL	
<i>by weight</i>	<i>by volume</i>	<i>by weight</i>	<i>by volume</i>
1000	4	1000	4
150	1	150	1
0-5%	0-5%	10-15%	15-20%



Pot life 20°C:

3 – 4 hours

3 – 4 hours

Spray viscosity:

50-55 seconds DIN 4

25-35 seconds DIN 4



Spray gun set up:

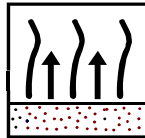
Tip Airless: 0.33 mm
 Tip Air mix: 0.28 – 0.38mm

Tip: 1.8

Spray pressure:

Airless: 160 bar
 Air mix: 70 - 100 bar
 Air cup (Air mix): 3.5

3.0 bar



Number of coats:

2

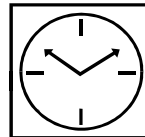
2

Flash off between coats:

3-5 min at 20 °C

3-5 min at 20 °C

APPLICATION GUIDE



Drying times at 20°C

- Dust free:

10-15 minutes

- Touch free::

4 hours

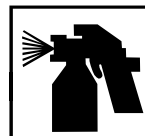
- Hard dry:

8-10 hours

Drying times at 60°C:

45 minutes with 9-025 hardener

60 minutes with 9-020 hardener



Overcoat time with any 2K SELEMIX SYSTEM topcoats at 20 °C:

After at least 1 hour minimum for low to medium film build, 3 hours being the safest when film build is uncertain.

After 2 months maximum without sanding, but after 24 hours a thorough clean of the surface is recommended.

Wet on wet in no sanding process is always possible.

Total dry film build:

100-150 microns

TECHNICAL DATA

<i>Theoretical coverage:</i>	4.2 – 5.1 m ² /l (ready to spray giving 100µm dry film thickness)
<i>Solid content (by weight):</i>	72 % as supplied
<i>Solid content (by volume):</i>	52 % as supplied
<i>RFU VOC gr/l:</i>	420-500 g/l
<i>Density:</i>	1.5 g/l

Slow Epoxy Thinner 1-400 may be used at high temperatures or for large areas to improve overspray absorption.

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

Selemix Customer Service and Sales Group, Needham Road, Stowmarket, Suffolk, IP14 2AD, England, Tel: 01449 773993, Fax: 01449 771547