

TECHNICAL DATASHEET

8-450

2K WATERBORNE EPOXY PRIMER

PRODUCT DESCRIPTION

8-450 is two components waterborne epoxy primer designed for aluminium, bare steel and galvanized steel surfaces in epoxy and polyurethane solventborne and waterborne paint systems. Suitable to be used in moderate aggressive environments providing good resistance to water, solvents and good resistance to abrasion. 8-450 Epoxy primer have been developed to combine corrosion protection that is equal or better than performance solvent-borne coatings with cost and environmental benefits.

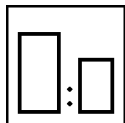
SELECTION AND PREPARATION OF SUBSTRATES



	Sand
Aluminium	P80-100 (dry)
Bare steel	P80-100 (dry)
Galvanized steel	P80-100 (dry)

Degrease thoroughly prior to painting. All substrates should be free from any supports contamination such as oil, grease and rust.

APPLICATION GUIDE



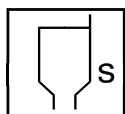
	AIRMIX		CONVENTIONAL	
<i>Mixing ratio (by weight):</i>	8-450 tinted	1000	8-450 tinted	1000
	9-450	400	9-450	400
<i>Mixing ratio (by volume):</i>	8-450 tinted	2	8-450 tinted	2
	9-450	1	9-450	1

HARDENER 9-450 MUST BE PROPERLY SHAKED BEFORE USE

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Thinning: 2-8% with water 2-10% with water

Pot life 20°C: 2 hours 2 hours



Spray viscosity: 40-45 sec Din 4 at 20°C 40-45 sec DIN4 at 20°C

Spray gun set up: 11-13 1.6-2.0 mm

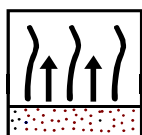
Spray pressure: 70-100 bar 2-3 bar



Number of coats: 2 normal coats * 2 normal coats

* if the substrate temperature is below 15°C, apply one light coat to enhance the sag resistance

APPLICATION GUIDE



Flash off between coats:

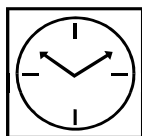
15 minutes at 20°C or until matt

Flash off before stoving:

20 minutes at 20°C or until matt

Drying times at 60°C:

45 minutes



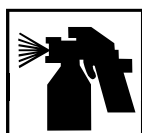
Drying times at 20°C:

Dust free :

15-20 minutes

Touch free:

2-3 hours



Handling:

3-4 hours

Recommended thickness:

50-60 microns

Overcoatable with:

Any Selemix Aqua 2K epoxy and polyurethane topcoats and Selemix solvent-borne epoxy and polyurethane topcoats

Overcoat time at 20°C:

After 5-6 hours

TECHNICAL DATA

Theoretical coverage: 6.6-7.6 m²/l of paint ready to use for 50µm of thickness

Storage: STORE FREE FROM FROST ABOVE 4°C.
Prolonged exposure to high temperatures or direct sources of heat should be avoided

HEALTH AND SAFETY

These products are for professional painting only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

For Health and Safety information please refer to the material Safety Data Sheet, also available at: http://www.selemix.com/selemix_MSDS

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