

**TECHNICAL DATASHEET**

# 2.704.040X

## EPOXY PRIMER BEIGE (2.704.0400) / GREY (2.704.0401)

### PRODUCT DESCRIPTION

SELEMIX Epoxy Primer 2.704.040X is a 2K high build epoxy primer suitable for conventional application which gives outstanding performance with High Pressure Spray equipment (Airmix / Airless). It is available in Beige and Light Grey (close to RAL7035) versions. Robust application characteristics and good anti-corrosion properties make 2.704.040X ideal for wide industrial uses.

### SELECTION AND PREPARATION OF SUBSTRATES

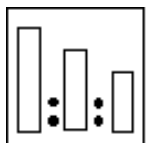


Steel, Blasted steel, Iron phosphated steel

Substrate preparation: sand blast and chemical pre-treatment

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

### APPLICATION GUIDE



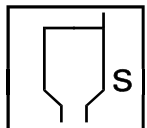
Mixing ratio:

Primer 2.704.040x:  
Hardener 1.959.4020:

	AIRMIX/AIRLESS		CONVENTIONAL	
	<u>by weight</u>	<u>by volume</u>	<u>by weight</u>	<u>by volume</u>
Primer 2.704.040x:	1000	6	1000	6
Hardener 1.959.4020:	100	1	100	1

Thinner:

Not needed.  
0,5-1% of thinner 1-410 can be used to reduce the viscosity with conventional spray equipment.



Pot life 20°C:

4 hours

4 hours



Spray viscosity:

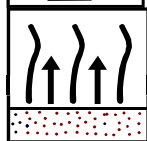
12 sec. DIN 6 at 20 °C

12 sec. DIN 6 at 20 °C

Spray gun set up:

Tip airmix: 11-15 thou  
Tip airless: 13 thou

Nozzle 1.8 mm



Spray pressure:

70 - 100 bar (Airmix)

Number of coats:

2

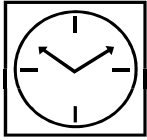
2

Flash off between coats:

15 min at 20 °C

15 min at 20 °C

## APPLICATION GUIDE



*Drying times at 20°C*

*Dust free:* 6-12 minutes  
*Touch free:* 60 minutes

*Drying times at 60°C:* 30 minutes



*Total dry film build:* 70-100 microns

*Overcoat time:* After 60 minutes minimum , or up to  
1 month maximum  
with any 2K Selemix topcoats

## TECHNICAL DATA (blended)

<i>Theoretical coverage:</i>	5.2 m <sup>2</sup> /l (to achieve 100 microns dry film thickness and assuming 100% transfer efficiency)
<i>Solid content (by weight):</i>	73%
<i>Solid content (by volume):</i>	53%
<i>RFU VOC gr/lit:</i>	438 g/lit
<i>Density:</i>	1.6 g/lit

## 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**