

TECHNICAL DATASHEET

Issue date:
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SELEMIX® 2K EPOXY HB ANTICORROSIVE PRIMER

GREY **2.704.0440**

WHITE **2.704.0441**

PRODUCT DESCRIPTION

Selemix 2.704.044X is a 2K high build epoxy primer containing anticorrosive pigments. It is available in grey and white.

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 when used with Selemix 2K Topcoats, gives a high performance coating system suitable for aggressive industrial environments.

PRODUCTS

2.704.0440 *Selemix 2K Epoxy HB Anticorrosive Primer Grey*
 2.704.0441 *Selemix 2K Epoxy HB Anticorrosive Primer White*

Hardeners:

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

Thinner:

1-410 Epoxy Thinner
 1-400 Slow Epoxy Thinner

SUBSTRATES AND PREPARATION



Steel (Blast Cleaned)	Blast clean to ISO 8501-1 SA 2.5 with a blast profile of max.40 µm Rz
Steel/Cast Iron	Machine sand with P80-120 discs and degrease
Phosphated Steel	Abrade with SCOTCHBRITE® and degrease
Galvanised Steel	Abrade with SCOTCHBRITE® and degrease
Aluminium	Machine sand with P280-320 discs and degrease
Painted Surfaces	Machine sand with P240-320 discs and degrease






Do not use over wash primers or 1K synthetic primers.




Apply only on a clean and dry surface with a temperature above the dew point to avoid condensation. In confined spaces, provide adequate ventilation during application and drying.

MIXING

Thoroughly mix paint before activating and check colour before use

Features	Conventional	Air-Assisted Airless
 <p>By Weight: 2.704.044x Primer 9-020 / 9-025 Hardener 1-410 / 1-400 Thinner</p>	<p>1000 150 90 - 120</p>	<p>1000 150 0 - 30</p>
 <p>By Volume: 2.704.044x Primer 9-020 / 9-025 Hardener 1-410 / 1-400 Thinner</p>	<p>4 1 0.6 – 1 (15 - 25%)</p>	<p>4 1 0 – 0.2 (0 – 5%)</p>
 <p>Viscosity (at 20°C): Pot Life (at 20°C):</p>	<p>25 - 35 secs DIN4 3 - 4 hours</p>	<p>50 - 55 secs DIN4 3 - 4 hours</p>

APPLICATION

Features	Conventional	Air-Assisted Airless
 <p>Spraygun setup:</p>	<p>Nozzle: Gravity: 1.8mm Suction: 1.8-2.0mm Pressure feed: 1.2-1.4mm</p>	<p>Tip: 11-13-15 thou (0.28-0.33-0.38 mm)</p>
<p>Air Pressure:</p>	<p>Standard: 2.5-3 Bar</p>	<p>2.5-3 Bar</p>
<p>Fluid Pressure:</p>	<p>N/A</p>	<p>70 -100 Bar</p>
 <p>Number of coats:</p>	<p>2</p>	<p>2</p>
<p>Flash-off between coats:</p>	<p>10 - 15 mins at 20°C</p>	<p>10 - 15 mins at 20°C</p>
 <p>Drying:</p>	<p>bake at 60°C for: 45 mins with 9-025 hardener 60 mins with 9-020 hardener</p>	<p>bake at 60°C for: 45 mins with 9-025 hardener 60 mins with 9-020 hardener</p>
<p>Flash-off before bake:</p>	<p>10-15 mins</p>	<p>10-15 mins</p>
<p>Wet Film Thickness:</p>	<p>225-275 microns (110-135 microns per coat)</p>	<p>200-250 microns (100-150 microns per coat)</p>
<p>Dry Film Thickness:</p>	<p>100-120 microns</p>	<p>120-150 microns</p>

DRYING TIMES



at 20°C

Dust Free
Touch Free
Hard Dry

10-15 mins

4 hours

8 - 10 hours

Stoving:

45-60 minutes @60°C

(according to film thickness and hardener selection)

Overcoating time:

Minimum: 1 hour for low to medium film build

Safest: 3 hours in case of uncertain film build

Maximum: 2 months without sanding on clean surface
with any 2K *Selemix* Topcoat

Note:

Lower temperature or film thickness higher than 150µm
will extend drying times

TECHNICAL DATA

Based on ready-for-use mixed paint
including thinner:

VOC (g/L):

299-369 g/L (according to dilution)

Solid content (weight):

64-72 %

Solid content (volume):

45-54 %

Solvent content (weight):

28-36 %

Specific gravity (Ready for use)

1.33-1.42 Kg/L

Theoretical coverage:

4.5-5.3 m² per litre at 100 microns DFT

Gloss:

Matt Finish

PRODUCT CODES AND DESCRIPTIONS

Selemix Code	Short Code	Product Description	Packsize
1.959.4020/E4K	9-020	Hardener for Epoxy Primer	4 Kg
1.959.4020/E150	9-020	Hardener for Epoxy Primer	150 Lt
1.959.4025/E4K	9-025	Fast Curing Hardener	4 Kg
1.959.4025/E150	9-025	Fast Curing Hardener	150 Lt
1.911.4400/E5	1-400	Slow Epoxy Thinner	5 Lt
1.911.4410/E1	1-410	Epoxy Thinner	1 Lt
1.911.4410/E5	1-410	Epoxy Thinner	5 Lt
2.704.0440/E25K	4-0440	2K Epoxy HB Anticorrosive Primer Grey	25 Kg
2.704.0440/E150	4-0440	2K Epoxy HB Anticorrosive Primer Grey (on request)	150 Lt
2.704.0441/E25K	4-0441	2K Epoxy HB Anticorrosive Primer White	25 Kg

HEALTH AND SAFETY

For comprehensive Health, Safety and Environmental advice, please refer to the relevant Material Safety Data Sheets and Product can labels.

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.

FOR FURTHER INFORMATION PLEASE CONTACT:

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