

TECHNICAL DATASHEET

Issue date:
July 2020

SELEMIX® 2K EPOXY PRIMER

BEIGE 2.704.0400

GREY 2.704.0401

PRODUCT DESCRIPTION

Selemix Epoxy Primer 2.704.040X is a 2K high build anticorrosive epoxy primer which is especially suitable for application over blast-cleaned steel.

It can be applied by conventional spray, but is highly suited to application by high pressure spray equipment (airless and air-assisted airless spray). Its robust application characteristics and good anti-corrosive properties over ferrous substrates properties make 2.704.040X ideal for wide industrial uses.

It is compatible with all Selemix 2K Polyurethane and Acrylic Topcoats and is available in Beige and Light Grey (close to RAL7035) versions.

PRODUCTS

2.704.0400	<i>Selemix</i> 2K Epoxy Primer Beige
2.704.0401	<i>Selemix</i> 2K Epoxy Primer Grey

Hardener:

9-020 Hardener for Epoxy Primer

Thinner:

1-400 Slow Epoxy Thinner
 1-410 Epoxy Thinner

SUBSTRATES AND PREPARATION



Steel (Blast Cleaned)

Blast clean to ISO 8501-1 SA 2.5 with a blast profile of maximum 40 µm Rz

Phosphated Steel

Abrade with SCOTCHBRITE® 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: 2.704.040X Primer 9-020 Hardener 1-400 / 1-410 Thinner</p>	<p>1000 100 50-100</p>	<p>1000 100 0-50</p>
 <p>By Volume: 2.704.040X Primer 9-020 Hardener 1-400 / 1-410 Thinner</p>	<p>6 1 0.3-0.6 (5-10%)</p>	<p>6 1 0-0.3 (0-5%)</p>
 <p>Viscosity (at 20°C): Pot Life (at 20°C):</p>	<p>8-12 secs DIN6 4 hours</p>	<p>12 secs DIN6 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>15 mins at 20°C</p>	<p>15 mins at 20°C</p>
 <p>Drying:</p>	<p>60°C for 30 mins</p>	<p>60°C for 30 mins</p>
<p>Flash-off before bake:</p>	<p>10-15 mins</p>	<p>10-15 mins</p>
<p>Wet Film Thickness:</p>	<p>150-175 microns (75-90 microns per coat)</p>	<p>150-175 microns (75-90 microns per coat)</p>
<p>Dry Film Thickness:</p>	<p>70-100 microns</p>	<p>70-100 microns</p>

DRYING TIMES



at 20°C

Dust Free	10-15 mins
Touch Free	60 mins
Hard Dry	24 hours
Stoving:	30 minutes at 60°C (according to film thickness)
Overcoating time:	Minimum: 1 hour Maximum: 1 month without sanding on clean surface with any 2K <i>Selemix</i> Topcoat
Note:	Lower temperature or film thickness higher than 100µm will extend drying times

TECHNICAL DATA

Based on ready-for-use mixed paint including thinner:	
VOC (g/L):	349-357 g/L
Solid content (weight):	69-70 %
Solid content (volume):	47-49 %
Solvent content (weight):	30-31 %
Specific gravity (Ready for use)	1.49-1.52 Kg/L
Theoretical coverage:	4.7 - 4.8 m ² per litre at 100 microns DFT
Gloss:	Semi-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
1.911.4400/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
2.704.0400/E25K	4-0400	2K Epoxy Primer Beige	25	Kg
2.704.0401/E25K	4-0401	2K Epoxy Primer Grey	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:

Selemix Customer Service and Sales Group
 Needham Road
 Stowmarket, Suffolk
 IP14 2AD, England
 Tel: 01449 771771