

TECHNICAL DATASHEET

Issue date:
Feb 2020

SELEMIX[®] 2K EPOXY ZINC RICH PRIMER 2.704.0490

PRODUCT DESCRIPTION

Selemix 2.704.0490 is a grey/reddish grey two component Zinc Rich Epoxy Primer. The high zinc content of the primer film, gives a cathodic protection if the film is damaged, as it combines the toughness of an epoxy with the superior protection of zinc.

It has outstanding resistance to severe weathering.

Applied as part of a Selemix coating system 2.704.0490 provides superior performance in a wide range of corrosive environments. With suitable topcoats it withstands splash or spillage of water, solvents, chemicals and petroleum products.

It is recommended for use on structural steel, machinery, pipe and tank exteriors, and general maintenance.

PRODUCTS

2.704.0490 *Selemix* 2K Epoxy Zinc Rich Primer

Hardener:
9-050 Hardener for 2K Zinc Rich Epoxy Primer

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 maximum 35-65 µm Rz. Remove abrasive residues and dust from the surface. Apply 2.704.0490 as soon as possible after surface preparation to prevent any contamination. Do not leave blasted steel overnight.

MIXING


Thoroughly mix paint before activating and check colour before use

Features	Conventional	Airless or Air-Assisted Airless
 <p>By Volume: 2.704.0490 Primer 9-050 Hardener</p> <p>1-410 / 1-400 Thinner</p>	<p>4 1</p> <p>0.6 – 0.8 (15 - 20%)</p>	<p>4 1</p> <p>0 – 0.8 (0 – 20%)</p>
 <p>Viscosity (at 20°C):</p> <p>Pot Life (at 20°C):</p>	<p>12-14 secs DIN6</p> <p>4 hours</p>	<p>12 - 16 secs DIN6</p> <p>4 hours</p>
 <p>MIXING AND APPLICATION PROCEDURE</p>  <p>Important to follow this procedure carefully</p>	<ol style="list-style-type: none"> 1. Flush equipment thoroughly using clean solvent 2. Stir primer to an even consistency with a power stirrer. 3. Add hardener to primer and continue stirring for 5 minutes. 4. Strain through a 60 mesh filter to prevent possible clogging of equipment. 5. Thinning is not normally required for airless application. Up to 20% thinner may be added for workability. Stir during application to maintain uniformity of the material. Overlap each pass 50% to avoid bare areas, pinholes or sags. 6. Double coat all welds, rough spots, sharp edges and corners, rivets bolts etc. 7. Application at 120 microns wet film thickness will normally provide a dry film thickness of 75 microns. Avoid excessive film builds which can lead to cohesive failure. 8. Check thickness of dry coating, and if less than specified, apply additional material as needed. 9. Small damaged areas may be touched up by brush. Large areas by spray application. 10. In confined areas, ventilate with clean air during the application and drying processes until all solvents are removed. The temperature and humidity of the ventilating air must be such that moisture condensation will not form on the primer surface. 11. Clean all application equipment immediately after use, or at least at the end of each working day. 	
<p>APPLICATION BY CONVENTIONAL OR PRESSURE POT</p>	<p>This material may be applied by conventional spray gun or pressure pot by adding 15 – 20% thinner 1-410 or 1-400. Separate air and fluid pressure regulators, mechanical pot agitator and a moisture / oil trap in the main compressed air supply line are recommended. Large fluid tips – 2.0 / 2.2mm will be needed.</p>	
 <p>BRUSH/ROLLER APPLICATION</p>	<p>Suitable for small areas only, such as touch-up, repairs and stripe coating.</p>	

APPLICATION

Features	Conventional	Airless or Air-Assisted Airless
 Spraygun setup:	Nozzle: Gravity: 2-2.2mm Suction: 2.0-2.2mm	Tip: 17-23 thou (0.43-0.58 mm)
Air Pressure:	Standard: 2.5-3 Bar	N/A for Airless (2,5 bars for AAA)
 Fluid Pressure:	N/A	100-140 Bar
Number of coats:	2	1-2
Flash-off between coats:	10 - 15 mins	10 - 15 mins
 Drying:	1 hour or bake at 60°C or 3 hours at 20°C or 2 hours at 40°C	1 hour or bake at 60°C or 3 hours at 20°C or 2 hours at 40°C
Flash-off before bake:	10-15 mins	10-15 mins
Wet Film Thickness:	120-150 microns	120-150 microns
Dry Film Thickness:	75-100 microns	75-100 microns

DRYING TIMES

 Touch Free Hard Dry at 20°C	3 hours 24 hours
Stoving:	60 minutes @60°C or 2 hours @40°C (according to film thickness)
Overcoating time:	Minimum: 4 hours at 20°C Safest: 4 hours in case of uncertain film build and low temperature Maximum: 3 months without sanding on clean surface with any 2K <i>Selemix</i> Primer or 2K DTM 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):	151-286 g/L (according to dilution)
Zinc content in dry film (weight):	81%
Solvent content (weight):	77-88 %
Solid content (volume):	43-63 %
Specific gravity (Ready for use)	2.18 – 2.75 Kg/L
Theoretical coverage:	5.8 - 8.3 m ² per litre at 75 microns DFT
Gloss:	Matt rough metallic finish

PRODUCT CODES AND DESCRIPTIONS

Selemix Code	Short Code	Product Description	Packsize	
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
1.959.4050/E1.6	9-050	Hardener for 2K Zinc Rich Epoxy Primer	1.6	Lt
2.704.0490/E6.4	4-0490	2K Epoxy Zinc Rich Primer	6.4	Lt

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