

TECHNICAL DATASHEET

Issue date:
October 2020

SELEMIX® 2K POLYURETHANE DIRECT PRIMER

GREY 2.705.0500 BLACK 2.705.0502
WHITE 2.705.0501 RED 2.705.0503

PRODUCT DESCRIPTION

Selemix 2.705.050X PUR Primer is a high build 2K polyurethane primer which may be used in a wet on wet system. It gives good corrosion resistance and can be used on a range of different substrates. It uses the same Hardeners and thinners as Selemix 2K Acrylic and Polyurethane topcoats, giving a simple and compact system that is suitable for the finishing and protection of machinery, agricultural and construction equipment, and many other industrial painting applications.

PRODUCTS

2.705.0500	<i>Selemix</i> PU PRIMER GREY RAL 7035
2.705.0501	<i>Selemix</i> PU PRIMER WHITE
2.705.0502	<i>Selemix</i> PU PRIMER BLACK
2.705.0503	<i>Selemix</i> PU PRIMER RED

Hardeners:

9-060	Extra PU Hardener
9-065	Slow Hardener
9-070	Direct Hardener
9-080	Acrylic Hardener

Thinners:

1-430	Acrylic Thinner
1-420	Polyurethane Thinner
1-208	Slow Thinner
1-470	Slow Direct 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
Steel/Cast Iron	Machine sand with P80-120 discs and degrease
Galvanised steel	Abrade with Scotchbrite® and degrease
Light Alloys and Aluminium	Machine sand with P280-320 discs and degrease
Painted Surfaces	Machine sand with P240-320 discs and degrease
Fiber Reinforced Plastic	Machine sand with P240 discs and degrease






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 Standard System	Conventional	Air-Assisted Airless
	By Weight: 2.705.050x Primer 9-060 / 9-065 Hardener Listed Thinner	1000 130 130 - 150	1000 130 100 - 150
	By Volume: 2.705.050x Primer 9-060 / 9-065 Hardener Listed Thinner	5 1 0.65 – 0.75 (13 - 15%)	5 1 0.5 – 0.75 (10 – 15%)
	Features 9-080 Hardener	Conventional	Air-Assisted Airless
	By Weight: 2.705.050x Primer 9-080 Hardener Listed Thinner	1000 160 80 - 120	1000 160 0 - 80
	By Volume: 2.705.050x Primer 9-080 Hardener Listed Thinner	4 1 0.5 – 0.8 (13 - 20%)	4 1 0 – 0.5 (0 – 13%)
	Features 9-070 Hardener	Conventional	Air-Assisted Airless
	By Weight: 2.705.050x Primer 9-070 Hardener Listed Thinner	1000 140 110 - 130	1000 140 100 - 130
	By Volume: 2.705.050x Primer 9-070 Hardener Listed Thinner	5 1 0.65 – 0.75 (13 - 15%)	5 1 0.5 – 0.75 (10 – 15%)
	Features with any hardener	Conventional	Air-Assisted Airless
	Viscosity (at 20°C): Pot Life (at 20°C):	20 - 35 secs DIN4 3 hours	35 - 45 secs DIN4 3 hours

APPLICATION

Features	Conventional	Air-Assisted Airless
 Spraygun setup:	Nozzle: Gravity: 1.6-1.8mm Suction: 1.8-2.0mm Pressure feed: 1.2-1.4mm	Tip: 11-13-15 thou (0.28-0.33-0.38 mm)
Air Pressure:	Standard: 2.5-3 Bar	2.5-3 Bar
Fluid Pressure:	N/A	70 -100 Bar
 Number of coats:	2	1 - 2
Flash-off between coats:	10 - 15 min	5 - 10 min
 Drying:	bake at 60°C for 30-45 min	bake at 60°C for 30-45 min
Flash-off before bake:	10-15 min	10-15 min
Wet Film Thickness:	175-250 microns (90-150 microns per coat)	150-250 microns (75-125 microns per coat)
Dry Film Thickness:	70-100 microns	70-120 microns

DRYING TIMES

 at 20°C	Dust Free Touch Free Handleable Sandable after Hard Dry	20-30 min 1 hour 2 – 3 hours 4 – 6 hours 24 hours
Stoving:		30-45 minutes @60°C (according to film thickness and hardener selection)
Overcoating time:		Minimum: 2 hours (according to film thickness and hardener selection) Maximum: 72 hours without sanding on clean surface with any 2K <i>Selemix</i> Topcoat
Note:		Lower temperature or film thickness higher than 120µm will extend drying times

TECHNICAL DATA

Based on ready-for-use mixed paint including thinner:	
VOC (g/L):	347 -603 g/L (according to colour and dilution)
Solid content (weight):	53-67 %
Solid content (volume):	35-47 %
Solvent content (weight):	33-47 %
Specific gravity (Ready for use)	1.22 -1.42 Kg/L
Theoretical coverage:	7.1- 9.3 m ² per litre at 50 microns DFT
Gloss:	Matt Finish

PRODUCT CODES AND DESCRIPTIONS

Selemix Code	Short Code	Product Description	Packsize	
1.959.5060/E5	9-060	Extra PU Hardener	5	Lt
1.959.5065/E5	9-065	Hardener for Large Surfaces	5	Lt
1.959.5080/E5	9-080	Acrylic Hardener	5	Lt
1.991.5070/E5	9-070	Direct Hardener	5	Lt
1.991.3208/E5	1-208	Slow Thinner	5	Lt
1.911.4420/E5	1-420	PU Thinner	5	Lt
1.911.4430/E5	1-430	Acrylic Thinner	5	Lt
1.991.1470/E5	1-470	Slow Direct Thinner	5	Lt
2.705.0500/E20K	4-0500	PU Direct Primer Grey RAL7035	20	Kg
2.705.0501/E20K	4-0501	PU Direct Primer White	20	Kg
2.705.0502/E20K	4-0502	PU Direct Primer Black	20	Kg
2.705.0503/E20K	4-0503	PU Direct Primer Bright Red	20	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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