

TECHNICAL DATASHEET

Issue date:
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SELEMIX® 2K EPOXY STRUCTURED TOPCOAT 7-411

PRODUCT DESCRIPTION

Selemix 7-411 2K Epoxy Structured Topcoat is a textured 2-pack Epoxy finish for solid colours. It has a gloss finish, and gives a hard and chemically resistant film.

It is compatible with *Selemix* Epoxy primers, giving a durable and hard-wearing paint system.

It is suitable for the coating of industrial equipment and machinery, especially those situated in an aggressive environment. It should not be used on exterior surfaces exposed to sunlight if a good level of colour stability is required.

PRODUCTS

7-411 *Selemix* Epoxy Structured Topcoat
 NPxx *Selemix* NP Tinters

Hardener:

9-015 Epoxy Textured Hardener

Thinners:

1-400 Slow Epoxy Thinner
 1-410 Epoxy Thinner

SUBSTRATES AND PREPARATION



Steel (use a primer in corrosive environments)

Machine sand with P80-120 discs and degrease






Selemix Epoxy Primers

Refer to Primer TDS for recoat time

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
Apply one smooth coat followed by one textured coat

	Features	Conventional Smooth Coat	Conventional Textured Coat
	By Weight: 7-411 Topcoat 9-015 Hardener 1-410 / 1-400 Thinner	1000 200 300 - 400	1000 200 0 - 100
	By Volume: 7-411 Topcoat 9-015 Hardener 1-410 / 1-400 Thinner	7 2 3 - 4 (40-60%)	7 2 0 - 1 (0-15%)
	Viscosity (at 20°C): Pot Life (at 20°C):	18-22 secs DIN4 6-8 hours	High Viscosity 2-4 hours

APPLICATION

	Features	Conventional Smooth Coat	Conventional Textured Coat
	Spraygun setup:	Nozzle: Gravity: 1.6-2.5mm Suction: Not recommended Pressure feed: 1.4-1.8mm	Nozzle: Gravity: 1.8-2.5mm Suction: Not recommended Pressure feed: 1.4-1.8mm
	Air Pressure:	HVLP: 2 Bar Standard: 2-3 Bar	HVLP: 0.3 – 0.65 Bar Standard: 0.3 – 0.65 Bar
	Fluid Pressure:	N/A	N/A
	Number of coats:	2 smooth coats	1 smooth coat and 1 textured coat
	Flash-off between coats:	10-15 mins	10-15 mins
	Drying:	Air dry or bake at 60°C for 60 mins	Air dry or bake at 60°C for 60 mins
	Flash-off before bake:	10 mins	10 mins
	Wet Film Thickness:	100-125 microns	100-125 microns
	Dry Film Thickness:	40-50 microns	40-50 microns

DRYING TIMES



at 20°C

Dust Free:	20-30 mins
Touch Free:	3-4 hours
Tape Free:	16-24 hours
Handleable:	16-24 hours
Hard Dry:	36-48 hours or after bake
Overcoating Time:	Minimum: 3 hours Maximum: 24 hours by itself without sanding

Lower temperature or film thickness higher than 50µm will extend drying times

TECHNICAL DATA

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

VOC (g/L):	351-531 g/L (depending on colour and dilution)
Solid content (weight):	54-75 %
Solid content (volume):	39-60 %
Solvent content (weight):	40-61 %
Specific gravity (Ready for use)	1.16-1.37 Kg/L
Theoretical coverage:	10-14 m ² /L at 40 microns DFT
Gloss:	Gloss

PRODUCT CODES AND DESCRIPTIONS

Selemix Code	Short Code	Product Description	Packsize	
1.774.1100/E17K	7-411	Epoxy Structured Topcoat	17	Kg
1.959.4015/E1	9-015	Epoxy Textured Hardener	1	Lt
1.959.4015/E5	9-015	Epoxy Textured Hardener	5	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

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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