

TECHNICAL DATASHEET

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SELEMIX® 2K WB EPOXY PRIMER 8-450

PRODUCT DESCRIPTION

Selemix 8-450 is a tintable two component waterborne epoxy primer designed for aluminium, bare steel and galvanized steel surfaces.

It is suitable for use in moderately aggressive environments and it gives good resistance to water and solvents and good resistance to abrasion. It is suitable for general industrial painting where a low VOC or a waterborne paint system is required.

PRODUCTS

8-450 *Selemix* Epoxy Primer
 WBxx *Selemix* Waterborne Tinters

Hardener:

9-450 Hardener for Epoxy Primer

Thinner:

Water Tap Water

SUBSTRATES AND PREPARATION






Steel	Machine sand with P80-120 discs and degrease
Galvanised steel	Abrade with Scotchbrite® and degrease
Aluminium	Machine sand with P240-320 discs and degrease
Painted Surfaces	Machine sand with P240-320 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.
 Shahe 9-450 hardener before use.

	Features	Conventional	Air-Assisted Airless
	By Weight: 8-450 Tinted Primer 9-450 Hardener Water	1000 400 20 - 100	1000 400 20 - 100
	By Volume: 8-450 Tinted Primer 9-450 Hardener Water	2 1 0.04 - 0.2 (2-10%)	2 1 0.04 - 0.2 (2-10%)
	Viscosity (at 20°C): Pot Life (at 20°C):	40 – 45 secs DIN4 2 hours	40 – 45 secs DIN4 2 hours

APPLICATION

	Features	Conventional	Air-Assisted Airless
	Spraygun setup:	Nozzle: Gravity: 1.6 - 2.0 mm Suction: 1.8 - 2.0 mm Pressure feed: 1.2 - 1.4mm	Nozzle: 11 - 13 thou 0.28 – 0.33 mm
	Air Pressure:	HVLP: 2 Bar Standard: 2.5-3 Bar	2 - 3 Bar
	Fluid Pressure:	N/A	70 - 100 Bar
	Number of coats:	2	2* * if the substrate temperature is below 15°C, apply one light coat to enhance the sag resistance
	Flash-off between coats:	15 mins minimum at 20°C or until matt	15 mins minimum at 20°C or until matt
	Drying:	Air dry 5-6 hours or bake at 60°C for 45 mins	Air dry 5-6 hours or bake at 60°C for 45 mins
	Flash-off before bake:	20 mins minimum at 20°C or until matt	20 mins minimum at 20°C or until matt
	Wet Film Thickness:	125-150 microns	125-150 microns
	Dry Film Thickness:	50-60 microns	50-60 microns

DRYING TIMES



at 20°C

Dust Free	15 - 20 mins
Touch Free	2 - 3 hours
Handleable	3 - 4 hours
Hard Dry	16 hours
Stoving:	45 minutes @60°C (according to film thickness)
Overcoating time:	After bake, or after a minimum 5-6 hours air dry (depending on film thickness and drying temperature) Maximum: 72 hours without sanding on clean surface with any <i>Selemix</i> waterborne 2K epoxy and polyurethane topcoats or any <i>Selemix</i> solvent-borne epoxy and polyurethane topcoats
Note:	Lower temperature or film thickness higher than 60µm will extend drying times. The drying times quoted are approximate times and will vary depending on drying conditions and film thickness. Poor ventilation, temperature below 20°C, humidity above 85% RH and excessive film thickness will extend the drying times.

TECHNICAL DATA

Based on ready-for-use mixed paint including water:	
VOC (g/L):	88 g/L
Solid content (weight):	53-59 %
Solid content (volume):	42-46 %
Theoretical coverage:	8.4 – 9.2 m ² per litre at 50 microns DFT
Specific gravity (Ready for use)	1.23-1.29 Kg/L
Gloss:	Matt Finish
Storage:	STORE FREE FROM FROST ABOVE 4°C. Prolonged exposure to high temperatures or direct sources of heat should be avoided

PRODUCT CODES AND DESCRIPTIONS

Selemix Code	Short Code	Product Description	Packsize
1.784.5000/E18K	8-450	Epoxy Primer	18 Kg
1.959.8450/E5	9-450	Hardener for Epoxy Primer	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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