

TECHNICAL DATASHEET

Issue date:
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SELEMIX® HIGH SOLIDS ZINC PHOSPHATE EPOXY PRIMER 4-0498

PRODUCT DESCRIPTION

Selemix 4-0498 is a grey 2K high solids epoxy primer containing zinc phosphate anticorrosive pigments.

It has a low VOC and is recommended for use on blast-cleaned steel, providing excellent protection against corrosion, and a very high film build (75-250 microns dry film thickness).

PRODUCTS

4-0498 *Selemix* High Solids Zinc Phosphate Epoxy Primer (Grey)

Hardener:

9-058 Hardener for Zinc Phosphate 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 40-70 µm Rz
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Steel/Cast Iron	Machine sand with P80-120 discs and degrease
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Galvanised Steel	Abrade with SCOTCHBRITE® and degrease
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Stainless Steel	Sweep blast, or machine sand with P80-120 discs and degrease
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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: 4-0498 Primer 9-058 Hardener 1-410 / 1-400 Thinner</p>	<p>1000 190 300 - 400</p>	<p>1000 190 0 - 100</p>
 <p>By Volume: 4-0498 Primer 9-058 Hardener 1-410 / 1-400 Thinner</p>	<p>3 1 0.9 – 1.2 (30 - 40%)</p>	<p>3 1 0 – 0.3 (0 – 10%)</p>
 <p>Viscosity (at 20°C): Pot Life (at 20°C):</p>	<p>35-45 secs DIN4 1 - 2 hours</p>	<p>Thixotropic – not measurable 1 hour</p>

APPLICATION

Features	Conventional	Air-Assisted Airless
 <p>Spraygun setup:</p>	<p>Nozzle: Gravity: 1.8-2.0mm Suction: 2.0mm Pressure feed: 1.4mm</p>	<p>Tip: 15-21 thou (0.38-0.53 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>100-150 Bar</p>
 <p>Number of coats:</p>	<p>2 (1 light + 1 full)</p>	<p>1 full coat</p>
<p>Flash-off between coats:</p>	<p>2-5 mins</p>	<p>-</p>
 <p>Drying:</p>	<p>Minimum 2 hours at 20°C or bake at 60°C for 30-45 mins</p>	<p>Minimum 2 hours at 20°C or bake at 60°C for 30-45 mins</p>
<p>Flash-off before bake:</p>	<p>10-15 mins</p>	<p>10-15 mins</p>
<p>Wet Film Thickness:</p>	<p>125-210 microns</p>	<p>95-310 microns</p>
<p>Dry Film Thickness:</p>	<p>75-125 microns</p>	<p>75-250 microns</p>

DRYING TIMES



at 20°C

Dust Free	30 mins
Touch Free	1 hours
Tape Free	4 hours
Handleable	4 hours
Hard Dry	24 hours
Stoving:	30-45 minutes at 60°C (depending on film thickness)
Overcoating time:	Minimum: 2 hours Maximum: Unlimited with <i>Selemix 7-53X 2K Direct Topcoat</i>
Note:	Lower temperature or film thickness higher than 125µm will extend drying times

TECHNICAL DATA

Based on ready-for-use mixed paint unthinned:	
VOC (g/L):	230 g/L
Solid content (weight):	84.7%
Solid content (volume):	78-82 %
Solvent content (weight):	15.3%
Specific gravity (Ready for use)	1.5 Kg/L
Theoretical coverage:	6.4 m ² per litre at 125 microns DFT
Gloss:	Semi Gloss Finish

PRODUCT CODES AND DESCRIPTIONS

Selemix Code	Short Code	Product Description	Packsize	
4-0498/E15	4-0498	High Solids Zinc Phosphate Epoxy Primer	15	Lt
9-058/E5	9-058	Hardener for Zinc Phosphate Epoxy Primer	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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