

TECHNICAL DATASHEET

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SELEMIX® 2K EPOXY PRIMER 7-413

PRODUCT DESCRIPTION

Selemix 7-413 primer is a tintable 2K Epoxy primer that can be used on a wide range of substrates.

Its fast drying performance allows 7-413 Epoxy Primer to be used in a wet on wet system when recoated with 2K Topcoats.

It has good anticorrosive properties making it suitable for the finishing and protection of machinery, agricultural and construction equipment, and many other industrial painting applications.

PRODUCTS

7-413 *Selemix* 2K Epoxy primer
 NPxx *Selemix* NP Tinters

Hardeners:

9-010 Epoxy Hardener
 9-011 Fast Epoxy Hardener

Thinners:

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 40 µm Rz
Steel/Cast Iron	Machine sand with P80-120 discs and degrease
Galvanised Steel	Abrade with SCOTCHBRITE® and degrease
Phosphated Steel	Degrease
Aluminium and Light Alloys	Machine sand with P240-320 discs and degrease
GRP	Machine sand with P240 discs and degrease
Painted Surfaces	Machine sand with P240-320 discs and degrease






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
	By Weight: 7-413 Primer (tinted) 9-010 / 9-011 Hardener 1-410 / 1-400 Thinner	1000 200 250 - 300	1000 200 90 - 100
	By Volume: 7-413 Primer (tinted) 9-010 / 9-011 Hardener 1-410 / 1-400 Thinner	3.5 1 1 – 1.6 (*) (30-45%)	3.5 1 0.5 (15%)
	Viscosity (at 20°C): Pot Life (at 20°C):	18-30 secs DIN4 (*) according to expected film build 6 hours	30-35 secs DIN4 6 hours

APPLICATION

	Features	Conventional	Air-Assisted Airless
	Spraygun setup: Air Pressure: Fluid Pressure:	Nozzle: Gravity: 1.6-1.8mm Suction: 1.8-2.0mm Pressure feed: 1.2-1.4mm HVLP: 2 Bar Standard: 2.5-3 Bar N/A	Tip: 13-15 thou (0.33-0.38 mm) 2.5 Bar 100-120 Bar
	Number of coats: Flash-off between coats:	2 10-15 mins	2 10-15 mins
	Drying: Flash-off before bake: Wet Film Thickness: Dry Film Thickness:	Air dry 2 hours at 20°C or bake at 60°C for 50-60 mins 10-15 mins 100-200 microns 40-80 microns	Air dry 2 hours at 20°C or bake at 60°C for 50-60 mins 10-15 mins 100-200 microns 40-80 microns

DRYING TIMES



at 20°C

Dust Free	20-30 mins
Handleable	6 – 8 hours
Hard Dry	24 hours
Stoving:	50-60 minutes @60°C (according to film thickness)
Overcoating time:	Minimum: 2 hours Maximum: 3 weeks without sanding on clean surface with any 2K <i>Selemix</i> Topcoat
Note:	Before recoating for Selemix 7-540 Basecoat, primer must be air dried for at least 16 hours, or baked. Lower temperature or film thickness higher than 80µm will extend drying times

TECHNICAL DATA

Based on ready-for-use mixed paint including thinner:	
VOC (g/L):	541-559 g/L (depending on colour and dilution)
Solid content (weight):	55-57 %
Solid content (volume):	36-38 %
Solvent content (weight):	43-45 %
Specific gravity (Ready for use)	1.21-1.27 Kg/L
Theoretical coverage:	7.1-7.5 m ² per litre at 50 microns DFT
Gloss:	Matt Finish

PRODUCT CODES AND DESCRIPTIONS

Selemix Code	Short Code	Product Description	Packsize	
1.774.1300/E4.25K	7-413	Epoxy Primer	4.25	Kg
1.774.1300/E17K	7-413	Epoxy Primer	17	Kg
1.959.4010/E5	9-010	Epoxy Hardener	5	Lt
1.959.4011/E1	9-011	Fast Epoxy Hardener	1	Lt
1.959.4011/E5	9-011	Fast Epoxy 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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