

## TECHNICAL DATASHEET

Issue date:  
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# SELEMIX<sup>®</sup> 2K EPOXY HB ANTICORROSIVE PRIMER GREY **4-0440** WHITE **4-0441**

### PRODUCT DESCRIPTION

*Selemix* 4-044x is a 2K high build epoxy primer containing anticorrosive pigments. It is available in grey and white. It is recommended for use on steel, zinc plated steel and aluminium providing excellent protection against corrosion. It has outstanding chemical resistance, low VOC content and when used with *Selemix* 2K Topcoats, gives a high performance coating system suitable for aggressive industrial environments.

### PRODUCTS

4-0440 *Selemix* 2K Epoxy HB Anticorrosive Primer Grey  
 4-0441 *Selemix* 2K Epoxy HB Anticorrosive Primer White

#### Hardeners:

9-020 Hardener for Epoxy Primer  
 9-025 Fast Curing Hardener

#### 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 max.40 µm Rz
Steel/Cast Iron	Machine sand with P80-120 discs and degrease
Phosphated Steel	Degrease
Galvanised Steel	Abrade with SCOTCHBRITE <sup>®</sup> and degrease
Stainless Steel	Machine sand with P80-180 discs and degrease
Aluminium	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
	<b>By Weight:</b> 4-044x Primer 9-020 / 9-025 Hardener 1-410 / 1-400 Thinner	1000 150 85 - 150	1000 150 0 - 30
	<b>By Volume:</b> 4-044x Primer 9-020 / 9-025 Hardener  1-410 / 1-400 Thinner	4 1  0.6 – 1 (15 - 25%)	4 1  0 – 0.2 (0 – 5%)
	Viscosity (at 20°C): Pot Life (at 20°C):	25 - 35 secs DIN4 3 - 4 hours	50 - 55 secs DIN4 3 - 4 hours

## APPLICATION

	Features	Conventional	Air-Assisted Airless
	Spraygun setup:  Air Pressure: Fluid Pressure:	Nozzle: Gravity: 1.8mm Suction: 1.8-2.0mm Pressure feed: 1.2-1.4mm  Standard: 2.5-3 Bar N/A	Tip: 11-13-15 thou (0.28-0.33-0.38 mm)  2.5-3 Bar 70 -100 Bar
	Number of coats: Flash-off between coats:	2 10 - 15 mins at 20°C	2 10 - 15 mins at 20°C
	Drying:  Flash-off before bake: Wet Film Thickness: Dry Film Thickness:	Bake at 60°C for: 45 mins with 9-025 hardener 60 mins with 9-020 hardener  10-15 mins 225-275 microns (110-135 microns per coat) 100-120 microns	Bake at 60°C for: 45 mins with 9-025 hardener 60 mins with 9-020 hardener  10-15 mins 200-250 microns (100-150 microns per coat) 120-150 microns

## DRYING TIMES



at 20°C

Dust Free	10-15 mins
Touch Free	4 hours
Hard Dry	8 - 10 hours
Stoving:	45-60 minutes @60°C (according to film thickness and hardener selection)
Overcoating time:	Minimum: 1 hour for low to medium film build Safest: 3 hours in case of uncertain film build Maximum: 2 months without sanding on clean surface with any 2K <i>Selemix</i> Topcoat
Note:	Lower temperature or film thickness higher than 150µm will extend drying times

## TECHNICAL DATA

Based on ready-for-use mixed paint including thinner:	
VOC (g/L):	406-485 g/L (according to dilution)
Solid content (weight):	63-71 %
Solid content (volume):	45-54 %
Solvent content (weight):	29-37 %
Specific gravity (Ready for use)	1.32-1.41 Kg/L
Theoretical coverage:	4.5-5.4 m <sup>2</sup> per litre at 100 microns DFT
Gloss:	Matt Finish

## PRODUCT CODES AND DESCRIPTIONS

Selemix Code	Short Code	Product Description	Packsize	
1.959.4020/E4K	9-020	Hardener for Epoxy Primer	4	Kg
1.959.4025/E4K	9-025	Fast Curing Hardener	4	Kg
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
2.704.0440/E25K	4-0440	2K Epoxy HB Anticorrosive Primer Grey	25	Kg
2.704.0441/E25K	4-0441	2K Epoxy HB Anticorrosive Primer White	25	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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