TECHNICAL DATASHEET

SELEMIX® 1K SYNTHETIC PRIMER
GREY   3-0800
RED   3-0801

PRODUCT DESCRIPTION

Selemix 3-080x 1K primer is a fast drying synthetic anti-rust primer with good adhesion on bare steel.

It can be recoated with all Selemix 1K Topcoats and 2K Polyurethane and Acrylic Topcoats

It is particularly recommended for agricultural and building site machinery, carpentry and items made of ferrous metal.

PRODUCTS

3-0800	*Selemix* 1K Primer Grey
3-0801	*Selemix* 1K Primer Red

Thinners:

1-610	Synthetic Thinner
1-215	Nitro Thinner
1-205	Aromatic Free Thinner

SUBSTRATES AND PREPARATION

	Bare Steel	Machine sand with P80-120-150 discs and degrease
	Painted Surfaces Polyurethane or Polyester Fillers	Machine sand with P320-400 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 diluting

Features	Conventional	Air-Assisted Airless
By Weight:		
3-080x Primer	1000	1000
1-610/1-215/1-205 Thinner	0 - 50	0
By Volume:		
3-080x Primer	10	10
1-610/1-215/1-205 Thinner	0 – 0.5 (0 to 5%)	0 (no thinner)
Viscosity (at 20°C):	20-25 secs DIN4	35-40 secs DIN4
Pot Life (at 20°C):	unlimited	unlimited

APPLICATION

Features	Conventional	Air-Assisted Airless
Spraygun setup:	Nozzle: Gravity: 1.4-1.8mm Suction: 1.6-1.8mm Pressure feed:1.0-1.2mm	Tip: 11 thou (0.28 mm)
Air Pressure:	HVLP: 2 Bar Standard: 2.5-3 Bar	2.5 Bar
Fluid Pressure:	N/A	70-100 Bar
Number of coats:	2	2
Flash-off between coats:	5-7 mins	5-7 mins
Drying:	Air dry	Air dry
Wet Film Thickness:	125-150µm	125-150µm
Dry Film Thickness:	50-60 microns	50-60 microns

DRYING TIMES

at 20°C

Dust Free:	10-15 mins
Handleable:	30 – 60 mins
Hard Dry:	24 hours
Stoving:	Not recommended
Overcoating time:	Minimum: 1 hour
	Maximum: 1 month without sanding on clean surface with any 1K and 2K *Selemix* Topcoat except epoxies
Note:	Lower temperature or film thickness higher than 60µm will extend drying times

TECHNICAL DATA

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

VOC (g/L):	479-498 g/L (depending on dilution)
Solid content (weight):	67-69 %
Solid content (volume):	43-46 %
Solvent content (weight):	31-33 %
Specific gravity (Ready for use)	1.52-1.56 Kg/L
Theoretical coverage:	8.7-9.1 m² per litre at 50 microns DFT
Gloss:	Matt Finish

PRODUCT CODES AND DESCRIPTIONS

Selemix Code	Short Code	Product Description	Packsize	
2.708.0800/E25K	3-800	1K Primer Light Grey	25	Kg
2.708.0801/E25K	3-801	1K Primer Red	25	Kg
1.911.5610/E5	1-610	Synthetic Thinner	5	Lt
1.921.3215/E5	1-215	Nitro Thinner	5	Lt
1.991.1205/E25	1-205	Aromatic Free Thinner	25	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.

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