

## TECHNICAL DATASHEET

Issue date:  
March 2022

# SELEMIX® 2K WB EPOXY GREY PRIMER 5-8016 2.704.8016

### PRODUCT DESCRIPTION

*Selemix* 5-8016 Waterborne Epoxy Primer, is a Light Grey (RAL 7032), 2-pack primer with high filling and good anticorrosive properties, with good adhesion to a variety of substrates.

It is fast drying and easy to apply. It can be used with *Selemix* waterborne 2-pack topcoats.

It is recommended for use on industrial and agricultural equipment and machinery where a durable, low VOC or waterborne product is required.

1.959.8450 (9-450) Hardener must be properly shaken before use.

### PRODUCTS

5-8016 *Selemix* WB Epoxy Primer

**Hardener:**

9-450 Hardener for Epoxy Primer

**Thinner:**

Water Drinkable quality water or deionized water should be used

### 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.

**Shake 9-450 Hardener well before use.**

	Features	Conventional	Air-Assisted Airless
	<b>By Weight:</b> 5-8016 Primer 9-450 Hardener Water	1000 170 230 - 250	1000 170 60 - 150
	<b>By Volume:</b> 5-8016 Primer 9-450 Hardener Water	5 1 1.15 - 1.25	5 1 0.3 - 0.75
	Viscosity (at 20°C):  Induction:  Pot Life (at 20°C):	30 – 40 secs DIN4  After mixing allow to stand for at least 5 minutes before checking viscosity  1.5 - 2 hours	>60 secs DIN4  After mixing allow to stand for at least 5 minutes before checking viscosity  1.5 - 2 hours

## APPLICATION

	Features	Conventional	Air-Assisted Airless
	Spraygun setup:	Nozzle: Gravity: 1.6 - 1.8 mm Suction: 1.8 - 2.0 mm Pressure feed: 1.2 - 1.4 mm	Nozzle: 09 - 11 thou 0.23 – 0.28 mm
	Air Pressure:	HVLP: 2 Bar Standard: 2.5-3 Bar	2 - 3 Bar
	Fluid Pressure:	N/A	70 - 100 Bar
	Number of coats:	2-3 medium	1 Light Dry + 1 Full
	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 50 mins	Air dry 5-6 hours or bake at 60°C for 50 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:	40-60 microns	60-80 microns

## DRYING TIMES



at 20°C

Dust Free  
Touch Free  
Handleable  
Hard Dry

15 - 20 mins  
2 - 3 hours  
5 - 6 hours  
24 hours

Stoving:

50 minutes @60°C  
(according to film thickness)

Overcoating time:

After bake, or after a minimum: 5-6 hours air dry  
(depending on film thickness drying temperature)  
Maximum: 72 hours without sanding on clean surface  
with any *Selemix* Waterborne 2K epoxy or polyurethane topcoats

Note:

Lower temperature or film thickness higher than 80µm  
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):  
Solid content (weight):  
Solid content (volume):  
Theoretical coverage:  
Specific gravity (Ready for use)

193 g/L  
43-51 %  
30-37 %  
6.1-7.3 m² per litre at 50 microns DFT  
1.22-1.26 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	
2.704.8016/E20K	5-8016	2K Epoxy Primer - RAL 7032	20	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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