



## TECHNICAL DATASHEET

Issue date: January 2021

# 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 perfomance 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 Hardener9-011 Fast Epoxy Hardener

Thinners:

1-410 Epoxy Thinner1-400 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			
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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.

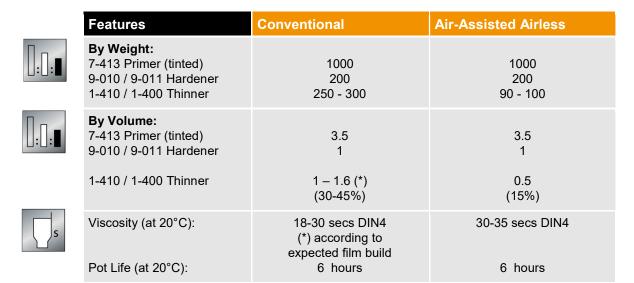






## **MIXING**

Thoroughly mix paint before activating and check colour before use



## **APPLICATION**

	Features	Conventional	Air-Assisted Airless
>2000 -	Spraygun setup:	Nozzle: Gravity: 1.6-1.8mm Suction: 1.8-2.0mm Pressure feed:1.2-1.4mm	Tip: 13-15 thou (0.33-0.38 mm)
	Air Pressure:	HVLP: 2 Bar Standard: 2.5-3 Bar	2.5 Bar
	Fluid Pressure:	N/A	100-120 Bar
	Number of coats:	2	2
	Flash-off between coats:	10-15 mins	10-15 mins
$\frac{\langle t \rangle \langle t \rangle}{\langle t \rangle \langle t \rangle}$	Drying:	Air dry 2 hours at 20°C or bake at 60°C for 50-60 mins	Air dry 2 hours at 20°C or bake at 60°C for 50-60 mins
	Flash-off before bake:	10-15 mins	10-15 mins
	Wet Film Thickness:	100-200 microns	100-200 microns
	Dry Film Thickness:	40-80 microns	40-80 microns





## **DRYING TIMES**

at 20°C

 $\begin{array}{ccc} \text{Dust Free} & 20\text{-}30 \text{ mins} \\ \text{Handleable} & 6-8 \text{ hours} \\ \text{Hard Dry} & 24 \text{ hours} \end{array}$ 

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 Selemix Topcoat

Before recoating for Selemix 7-540 Basecoat, primer must be air

dried for at least 16 hours, or baked.

Note: Lower temperature or film thickness higher than 80µm

will extend drying times

## **TECHNICAL DATA**

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

Solid content (weight): Solid content (volume): Solvent content (weight): Specific gravity (Ready for use)

Theoretical coverage:

VOC (g/L):

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541-559 g/L (depending on colour and dilution)

55-57 % 36-38 % 43-45 % 1.21-1.27 Kg/L

7.1-7.5 m² per litre at 50 microns DFT

Gloss: Matt Finish





## PRODUCT CODES AND DESCRIPTIONS

Selemix Code	Short Code	<b>Product Description</b>	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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