

**TECHNICAL DATASHEET**

# 2.704.040X

## EPOXY PRIMER BEIGE (2.704.0400) / GREY (2.704.0401)

### PRODUCT DESCRIPTION

SELEMIX Epoxy Primer 2.704.040X is a 2K high build epoxy primer suitable for conventional application and gives outstanding performance with high pressure spray equipment (airmix/airless). Robust application characteristics and good anti-corrosion properties make 2.704.040X ideal for wide industrial use. It is available in:  
2.704.0400 Beige and 2.704.0401 Light Grey (close to RAL 7035).

### SELECTION AND PREPARATION OF SUBSTRATES

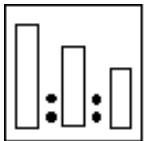


Steel, Blasted steel, Iron phosphated steel

Substrate preparation: sand blast and chemical pre-treatment

*Do not use over wash primers or synthetic primers.  
Degrease thoroughly prior to painting.*

### APPLICATION GUIDE



Mixing ratio (by volume):

Primer 2.704.040X:  
Hardener 1.959.4020:

**AIRMIX/AIRLESS**

6  
1

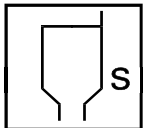
**CONVENTIONAL**

6  
1  
(0.5 - 2% 1-400 / 1-410  
thinner can be added)

Pot life 20°C:

4 hours

4 hours



Spray viscosity:

12s DIN6 at 20 °C

12s DIN6 at 20 °C

Spray gun set up:

Tip: 13 thou / 0.33mm

Tip: 1.8 mm



Spray pressure:

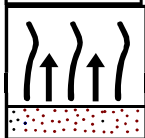
80 bar

2-3 bar

Number of coats:

2

2

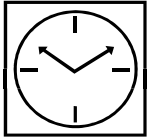


Flash off between coats:

15 min at 20 °C

15 min at 20 °C

## APPLICATION GUIDE



*Drying times at 20°C*

*Dust free:* 6-12 minutes  
*Touch free:* 60 minutes

*Drying times at 60°C:* 30 minutes



*Total dry film build:* 70-100 microns

*Overcoat time:* 60 minutes with any 2K Selemix topcoat.

## TECHNICAL DATA

**(Activated 6:1)**

<i>Theoretical coverage:</i>	5.2 m <sup>2</sup> /l (at 100 microns dry film thickness)
<i>Solid content (by weight):</i>	73%
<i>Solid content (by volume):</i>	53%
<i>RFU VOC gr/lit:</i>	438 g/lit
<i>Density (SG):</i>	1.5

## HEALTH AND SAFETY

Please refer to Material Safety Data Sheet for full health and safety details and storage regulations

**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.

**Selemix System** is a brand of PPG Group

**Selemix Customer Service and Sales Group, Needham Road, Stowmarket, Suffolk, IP14 2AD, England, Tel: 01449 773993, Fax: 01449 771547**