

TECHNICAL DATASHEET

Issue date:
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SELEMIX® HIGH SOLIDS ZINC PHOSPHATE EPOXY PRIMER 4-0498

PRODUCT DESCRIPTION

Selemix 4-0498 is a grey 2K high solids epoxy primer containing zinc phosphate anticorrosive pigments.

It has a low VOC and is recommended for use on blast-cleaned steel, providing excellent protection against corrosion, and a very high film build (75-250 microns dry film thickness).

It can still cure at low temperatures (down to -5C), but please note that recoat times will be extended at low temperatures.

PRODUCTS

4-0498 *Selemix* High Solids Zinc Phosphate Epoxy Primer (Grey)

Hardener:

9-058 Hardener for Zinc Phosphate Epoxy Primer

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 40-70 µm Rz

Steel/Cast Iron

Machine sand with P80-120 discs and degrease



Galvanised Steel

Abrade with SCOTCHBRITE® and degrease

Stainless Steel

Sweep blast, or machine sand with P80-120 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
	By Weight: 4-0498 Primer 9-058 Hardener 1-410 / 1-400 Thinner	1000 190 300 - 400	1000 190 0 - 100
	By Volume: 4-0498 Primer 9-058 Hardener 1-410 / 1-400 Thinner	3 1 0.9 – 1.2 (30 - 40%)	3 1 0 – 0.3 (0 – 10%)
	Viscosity (at 20°C):	35-45 secs DIN4	Thixotropic – not measurable
	Pot Life (at 20°C):	1 - 2 hours	1 hour

APPLICATION

	Features	Conventional	Air-Assisted Airless
	Spraygun setup:	Nozzle: Gravity: 1.8-2.0mm Suction: 2.0mm Pressure feed: 1.4mm	Tip: 15-21 thou (0.38-0.53 mm)
	Air Pressure:	Standard: 2.5-3 Bar	2.5-3 Bar
	Fluid Pressure:	N/A	100-150 Bar
	Number of coats:	2 (1 light + 1 full)	1 full coat
	Flash-off between coats:	2-5 mins	-
	Drying:	Minimum 2 hours at 20°C or bake at 60°C for 30-45 mins	Minimum 2 hours at 20°C or bake at 60°C for 30-45 mins
	Flash-off before bake:	10-15 mins	10-15 mins
	Wet Film Thickness:	125-210 microns	95-310 microns
	Dry Film Thickness:	75-125 microns	75-250 microns

DRYING TIMES



at 20°C

Dust Free
 Touch Free
 Tape Free
 Handleable
 Hard Dry

30 mins
 1 hours
 4 hours
 4 hours
 24 hours

Stoving:

30-45 minutes at 60°C
 (depending on film thickness)

Overcoating time:

Minimum: 1 hours at 30C
 Minimum: 2 hours at 20C
 Minimum: 4 hours at 10C
 Minimum: 14 hours at 0C
 Minimum: 24 hours at -5C

Note:

Maximum: Unlimited
 with *Selemix 7-53X 2K Direct Topcoat*

Lower temperature or film thickness higher than 125µm
 will extend drying times

TECHNICAL DATA

Based on ready-for-use mixed paint
 unthinned:

VOC (g/L):
 Solid content (weight):
 Solid content (volume):
 Solvent content (weight):
 Specific gravity (Ready for use)

Conventional Spray

403-431 g/L
 68-71%
 51-54 %
 29-32 %
 1.36-1.39 Kg/L

Air-Assisted Airless Spray

296-337 g/L
 77-80%
 62-66 %
 20-23 %
 1.46-1.51 Kg/L

Theoretical coverage:

4.1-4.3 m² per litre at 125
 microns DFT

4.9-5.3 m² per litre at 125
 microns DFT

Gloss:

Semi Gloss Finish

Semi Gloss Finish

PRODUCT CODES AND DESCRIPTIONS

Selemix Code	Short Code	Product Description	Packsize	
4-0498/E15	4-0498	High Solids Zinc Phosphate Epoxy Primer	15	Lt
9-058/E5	9-058	Hardener for Zinc Phosphate Epoxy Primer	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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