

TECHNICAL DATASHEET

Issue date:
Feb 2020

SELEMIX® 2K EPOXY TOPCOAT 7-410

PRODUCT DESCRIPTION

Selemix 7-410 2K Epoxy Topcoat is a 2-pack Epoxy finish for solid colours and single-layer metallic finishes. It has a gloss finish, and gives a hard and chemically resistant film.

It is compatible with Selemix Epoxy primers, giving a durable and hard wearing paint system. Application can be by conventional or air-assisted airless spray.

It is suitable for the coating of equipment and machinery, especially those situated in an aggressive environment. It should not be used on exterior surfaces exposed to sunlight if a good level of colour and gloss stability is required.

PRODUCTS

7-410 Selemix Epoxy Topcoat
NPxx Selemix NP Tinters

Hardener:

9-010 Epoxy Hardener
9-011 Fast Epoxy Hardener

Thinner:

1-400 Slow Epoxy Thinner
1-410 Epoxy Thinner

SUBSTRATES AND PREPARATION

	Steel (use a primer in corrosive environments)	Machine sand with P80-120 discs and degrease
	Selemix Epoxy Primers	Refer to Primer TDS for recoat time
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: 7-410 Topcoat 9-010 / 9-011 Hardener 1-410 / 1-400 Thinner	1000 500 400 - 500	1000 500 400-500
	By Volume: 7-410 Topcoat 9-010 / 9-011 Hardener 1-410 / 1-400 Thinner	3 2 2-2.5 (65-80%)	3 2 2-2.5 (65-80%)
	Viscosity (at 20°C): Pot Life (at 20°C):	18-22 secs DIN4 6-8 hours	18-22 secs DIN4 6-8 hours

APPLICATION

	Features	Conventional	Air-Assisted Airless
	Spraygun setup: Nozzle: Gravity: 1.3-1.4mm Suction: 1.6-1.8mm Pressure feed: 0.85-1.2mm		Nozzle: 9-11 thou 0.23-0.28mm
	Air Pressure: HVLP: 2 Bar Standard: 2-3 Bar		2.5 Bar
	Fluid Pressure: N/A		80-100 Bar
	Number of coats: Flash-off between coats:	2 10-15 mins	2 10-15 mins
	Drying: Flash-off before bake: Wet Film Thickness: Dry Film Thickness:	Air dry or bake at 60°C for 60 mins 10 mins 130 microns 50 microns	Air dry or bake at 60°C for 60 mins 10 mins 130 microns 50 microns

DRYING TIMES

 at 20°C	Dust Free: Touch Free: Tape Free: Handleable: Hard Dry: Overcoating Time:	30-40 mins 3-4 hours 12-18 hours 6-8 hours 12-18 hours or after bake Minimum: 3 hours Maximum: 24 hours by itself without sanding
Lower temperature or film thickness higher than 50µm will extend drying times		

TECHNICAL DATA

Based on ready-for-use mixed paint including thinner:	
VOC (g/L):	529-551 g/L (depending on colour and dilution)
Solid content (weight):	44-49 %
Solid content (volume):	36-39 %
Solvent content (weight):	51-56 %
Specific gravity (Ready for use)	0.97-1.04 Kg/L
Theoretical coverage:	7.2-7.7 m²/L at 50 microns DFT
Gloss:	Gloss

PRODUCT CODES AND DESCRIPTIONS

Selemix Code	Short Code	Product Description	Packsize
1.774.1000/E3.5K	7-410	Epoxy Topcoat	3.5 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
1.991.4410/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:

Selemix Customer Service and Sales Group

Needham Road
Stowmarket, Suffolk
IP14 2AD, England
Tel: 01449 771771