

# 7-413

## EPOXY PRIMER

### PRODUCT DESCRIPTION

7-413 Epoxy Primer is a high build 2-pack epoxy primer which may be used in a wet on wet system. It is intended to protect ferrous substrates

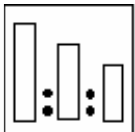
### SELECTION AND PREPARATION OF SUBSTRATES



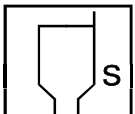
	<b>Sand</b>
Cast Iron	P80-120 (dry) or shot blast
Bare steel	P80-120 (dry)
Phosphated steel	Scotchbrite
Light alloys	P280-320 (dry)
Sandblasted steel	

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

### APPLICATION GUIDE



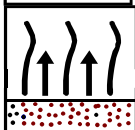
	AIRLESS		CONVENTIONAL	
<i>Mixing ratio (by weight):</i>	7-413 tinted	1000	7-413 tinted	1000
	9-010 *	200	9-010 *	200
	1-410	250-300	1-410	250-300
<i>Mixing ratio (by volume):</i>	7-413	3.5	7-413	3.5
	9-010 *	1	9-010 *	1
	1-410	1.3 – 1.6	1-410	1.3 – 1.6
	*9-011 fast can be used		*9-011 fast can be used	



<i>Pot life 20 °C:</i>	6 hours	6 hours
<i>Spray viscosity:</i>	18-22 secs Din 4 20 °C	18-22 secs Din 4 20 °C

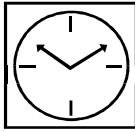


<i>Spray gun set up:</i>	13 – 15	1.6-1.8 mm
<i>Spray pressure:</i>	120-140 bar	3-4 bar



<i>Number of coats:</i>	2	2
<i>Flash off between coats:</i>	10-15 minutes 20 °C	10-15 minutes 20 °C

## APPLICATION GUIDE



*Drying times at 20 °C*

*Dust free:*

20-30 minutes

*Handling:*

6-8 hours



*Total dry film build:*

40-80 microns

*Flatting (if necessary):*

After 50-60 min 60 °C  
or 24 hours 20 °C

*Overcoat/recoat time with any SELEMIX  
SYSTEM topcoat*

2 hours min and 24 hours max 20 °C  
without flatting

## TECHNICAL DATA

*Theoretical coverage*

6.5 - 7 m<sup>2</sup> / l ready to spray giving 50µm  
dry film thickness

## 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

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