

SEEVENAX® Grundierung 313-69

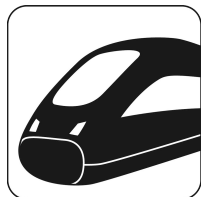
Technical Datasheet 313-69

Characteristics



- Water-dilutable, two-component primer based on epoxy resin
- Quick initial drying and curing
- Excellent adhesion promoting and corrosion protection properties
- Outstanding chemical and mechanical resistance

Range of Application

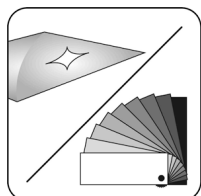


For the efficient corrosion protection of rail vehicles

Approved in acc. with:

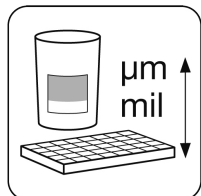
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Color and Gloss



Color: light ivory, beige-red, light grey, signal grey

Theoretical Coverage



Area	Quantity	Film thickness
5.3 m ²	1 kg	70 µm
90 sqft.	1 lb	1 mil

Recommended dry film thickness: 70 - 90 µm (2.76 - 3.54 mil)

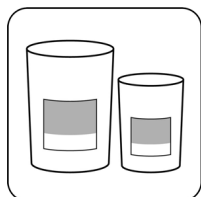
The film thickness must be adjusted to the degree of sandblasting of the components to be painted.

Surface Pre-treatment



- Is applied directly onto the appropriately cleaned / pre-treated metal substrate.
- In order to achieve optimal resistance values on steel and aluminium pre-treatment, i.e. sandblasting, is necessary.

Trade Names and Packaging



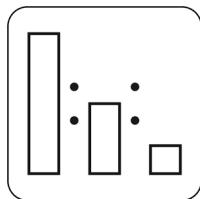
Material	Trade name	Container size [net]
Base material	SEEVENAX Grundierung 313-69	12 kg, 24 kg, 2 gal
Hardener	SEEVENAX Härter 315-69	3 kg, 6 kg, 1 gal



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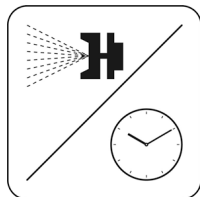
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Mixing



	Base	Hardener
Trade name	SEEEVENAX Grundierung 313-69	SEEEVENAX Härter 315-69
By weight	6	1
By volume	4.7	1

Pot Life

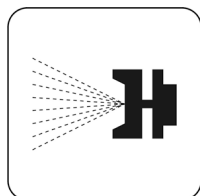


2 h at 20 °C / 50 % rh

Exceeding the pot life leads to a decrease in the technological values.

Note: End of pot life is not recognisable!

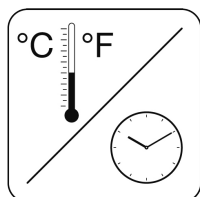
Application



	Compressed air spraying	Airmix	Airless
Addition of water	max. 5%	max. 5%	as delivered
Nozzle size	1.3 - 1.8 mm (0.051 - 0.078 inch)	0.23 - 0.33 mm (0.009 - 0.013 inch)	0.33 mm (0.013 inch)
Spraying pressure	3.0 - 3.5 bar (43.511 - 50.763 psi)	3.0 - 3.5 bar (43.511 - 50.763 psi)	-
Material pressure	-	100 - 150 bar (1450.377 - 2175.565 psi)	100 - 150 bar (1450.377 - 2175.565 psi)

Please review the technical recommendations of the equipment manufacturers.

Drying



	20 °C (68 °F) drying / 50 % rh	60 °C (140 °F) drying
Flash-off time at 20 °C	-	approx. 30 min
Assembly-dry	12 h	1 h
Recoatible	10 h	2 h

The temperature specified is the object temperature.

During the drying phase a minimum object temperature of 15 °C (59 °F) is required.





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Additional Details



- For further information on the application of water-dilutable materials please refer to our "GTI 46 - Water-dilutable coatings for industrial series production"
- Storage: Protect from frost.

The information contained in this document is based on our current state of research and development. Revisal by the user with regard to the intended purpose is necessary due to the variety of processing options and fields of application – please refer to the General Terms and Conditions of Sale.

