

# PRIMAPOX 6041

## 2K Epoxy Primer

### PRODUCTS

Primer	<b>PRIMAPOX 6041</b>	
Hardener	<b>E-6325</b>	4:1
Thinner	<b>SOLV UNIVERSAL 5</b>	0-20%
	<b>SOLV UNIVERSAL 3</b>	0-20%

### DESCRIPTION AND PROPERTIES

- Anticorrosive.
- High film thickness.
- Allows wet/wet application.
  - The product must be applied in installations that comply with Directive 2010/75/EU.
- Direct adhesion to iron, stainless steel, galvanized, electrozinc, aluminium, ABS, PVC and methacrylate.

### CHARACTERISTICS OF PRIMAPOX 6041

<b>Appereance</b>	Smooth	
<b>Gloss</b>	Matt	
<b>Specific weight</b>	1,7 kg/l a 20°C	
<b>Solid content</b>	72-77 % (weight)	55-59% (volumen)
<b>Solid content ready to use without thinner</b>	68-72 % (weight)	52-56 % (volumen)
<b>Dry film thickness</b>	100 microns (2 layers)	
<b>Theoretical yield 1 µm per litre of Primapox 6041</b>	650-700 m <sup>2</sup> /l	
<b>Theoretical yield 1 µm per litre of mixing without thinner (A+B)</b>	510-560 m <sup>2</sup> /l	
<b>Corrosion category system 6041+800G (ISO 12944)</b>	C5 High (240µm+60µm)	
<b>Corrosion category system 6041+902G (ISO 12944)</b>	C5 Medium (240µm+60µm)	

### SUBSTRATE AND PREPARATION OF THE SURFACE





	CLEANING	SANDING	FINAL CLEANING
Old paints	DA93	P360/400	DA93
Steel	DA93	--	DA93
Galvanised steel	DA93	--	DA93
Aluminium	DA93	--	DA93

For other kind of substrate consult the Technical Service (SAT).

### APPLICATION



T(°C)	SMALL SURFACE		LARGE SURFACE	
	Hardener	Thinner	Hardener	Thinner
18-25	E-6325	SOLV UNIVERSAL 5	E-6325	SOLV UNIVERSAL 5
>25	E-6325	SOLV UNIVERSAL 5	E-6325	SOLV UNIVERSAL 3

	Mixing ratio Hardener (in volume)	4:1
	Electrostatic application (in volume)	

	Application	% thinner (Vol.)	Viscosity - 20°C (Ford Cup 4)	Pressure (BAR)	Pressure of the Product (BAR)	Nozzle (mm)	Number of Coats x µm dry	Flash off (min)
	Airless	10%	50-60"	---	190	13/40	1x 80-100	---
	Airmix	10%	50-60"	2	130	13/40	1x 70-90	---
	Gravity feed spray gun	20%	30-40"	3	---	1.6-1.8	2x 40-50	10'-15'
	Pot life	3 hours						

If the application requires the use of an additive, it should be taken into account in the addition of solvent.

**DRYING**

 <b>TEMPERATURE</b>	 <b>HIGH BUILD FILLER</b>
<b>20° C</b>	3h min. – 7 days max. (P360/400)
<b>60° C</b>	30'

*The product develops its maximum properties after 15 days of air drying (ambient temperature 18-22°C) or after less time in higher temperatures*

**SAFETY**

- Follow instructions of product label.
- For more information check the Safety Data Sheets.
- Complaint with the National Statutory Regulation for Health and Safety at Work and Waste Disposal.

**STORAGE**

- Store the product in a ventilated place far from direct exposure to sunlight.
- Keep between +5°C and +30°C.

**GUARANTEE**

- One year in original unopened packaging.



*These products are for professional use only. The Safety Data Sheet should be consulted before use and the precautionary warnings on the product packaging should be observed. Its correct use, according to its purpose and respecting its technical and security data, provided in these documents, is the sole and exclusive responsibility of the user. ROBERLO S.A.U declines any liability due to the incorrect use of any product.*

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