

# PRIMAPOX 6121

## 2K Epoxy Primer

### PRODUCTS

Primer	PRIMAPOX 6121	
Hardener	E-6225/E-6325	
Thinner	PU74	0-40%

### DESCRIPTION AND PROPERTIES

- Low film thickness.
- Anticorrosive.
- Direct adhesion to metals (iron/steel, galvanised, aluminium...).
- Allows wet/wet application.
- The product must be applied in installations that comply with Directive 1999/13/EC depending on dilution.

### CHARACTERISTICS OF PRIMAPOX 6121

<b>Appereance</b>	Smooth	
<b>Gloss</b>	Matt	
<b>Specific weight</b>	1,5 kg/l a 20°C	
<b>Solid content</b>	65-73% (weight)	43-49% (volumen)
<b>Solid content ready to use without thinner (with E-6325)</b>	62-68 % (weight)	42-48% (volumen)
<b>VOC ready to use with E-6225 without thinner</b>	540g/L >500 g/l - 2004/42/EC - IIA(j)(500)	
<b>VOC ready to use with E-6325 without thinner</b>	480 g/L < 500 g/l - 2004/42/EC - IIA(j)(500)	
<b>VOC ready to use with E-6325 and 40% dilution</b>	565 g/L > 500 g/l - 2004/42/EC - IIA(j)(500)	
<b>Dry film thickness</b>	55-60 microns (2 layers)	
<b>Theoretical yield 1 µm per litre of Primapox 6121 (referring E-6225)</b>	500-600 m <sup>2</sup> /l	
<b>Theoretical yield 1 µm per litre of mixing without thinner (A+B) (referring E-6225)</b>	320-420 m <sup>2</sup> /l	
<b>Theoretical yield 1 µm per litre of Primapox 6121 (referring E-6325)</b>	460-560 m <sup>2</sup> /l	
<b>Theoretical yield 1 µm per litre of mixing without thinner (A+B) (referring E-6325)</b>	400-500 m <sup>2</sup> /l	



## 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

	SMALL SURFACE		LARGE SURFACE	
T(°C)	Hardener	Thinner	Hardener	Thinner
18-25	E-6225/E-6325	PU74	E-6225/E-6325	PU74
>25	E-6225/E-6325	PU74	E-6225/E-6325	PU74 SLOW

	Mixing ratio Hardener (in volume)	2:1 E-6225 / 4:1 E-6325
	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 secas	Flash off (min)
	Gravity feed spray gun	30% max	20-25"	3	---	1.6-1.8	2x30	10'-15'
	Gravity feed spray gun	0%	20-25"	3	---	1.6-1.8	2x30	10'-15'
	Pot life	20 hours						

## DRYING

 TEMPERATURE	 HIGH BUILD FILLER
20° C	24h min. – 7 days max. (P320/400)
60° C	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.

*For any technical information contact with our Costumer Attention Service or our Technical Department.  
ROBERLO SA declines any responsibility due to an incorrect use of the product.*