

PRIMAPOX 6041

2K Epoxy Primer

PRODUCTS

Primer	PRIMAPOX 6041	
Hardener	E-6325	4:1
Thinner	PU74 standard	0-20%
	PU74L slow	0-20%

DESCRIPTION AND PROPERTIES

- Anticorrosive.
- High film thickness.
- 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.

CHARACTERISTICS OF PRIMAPOX 6041

Appereance	Smooth	
Gloss	Matt	
Specific weight	1,6 kg/l a 20°C	
Solid content	72-77 % (weight)	55-59% (volumen)
Solid content ready to use without thinner	68-72 % (weight)	52-56 % (volumen)
VOC ready to use without thinner	< 500 g/l - 2004/42/EC - IIA(j)(455)	
VOC ready to use 20% dilution	> 500 g/l	
Dry film thickness	100 microns (2 layers)	
Theoretical yield 1 µm per litre of Primapox 6041	650-700 m ² /l	
Theoretical yield 1 µm per litre of mixing without thinner (A+B)	510-560 m ² /l	
Corrosion category system 6041+800G (ISO 12944)	C4 Medium /C5M Low (100µm+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	PU74	E-6325	PU74
>25	E-6325	PU74	E-6325	PU74L

	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 secas	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

 TEMPERATURE	 HIGH BUILD FILLER
20° C	3h min. – 7 days max. (P360/400)
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 Customer Attention Service or our Technical Department.
ROBERLO SA declines any responsibility due to an incorrect use of the product.*

