

# PRIMANYL 5501

## 1K Welding Primer

### PRODUCTS

Primer	<b>PRIMANYL 5501</b>	
Thinner	<b>DS238</b>	20-30%

### DESCRIPTION AND PROPERTIES

- Low thickness 1K epoxy primer.
- Direct adhesion to metals (iron/steel, galvanised, aluminium...).
- Anti-corrosion – Shop primer.
- Weldable (conductive and non-toxic smoke).
- It is necessary to be applied in installations that comply with Directive 1999/13/EC.

### CHARACTERISTICS OF PRIMANYL 5501

<b>Appearance</b>	Smooth	
<b>Gloss</b>	Glossy	
<b>Specific weight</b>	0,9-1,0 kg/l at 20°C	
<b>Solid content (binder)</b>	21-25 % (weight)	10-14% (volume)
<b>Solid content ready to use (30% dilution)</b>	17-21 % (weight)	8-12 % (volume)
<b>VOC ready to use</b>	> 500 g/l	
<b>Dry film thickness</b>	10-15 microns (1 coat)	
<b>Theoretical yield 1 µm per litre of Primanyl 5501</b>	100-140 m <sup>2</sup> /l	
<b>Theoretical yield 1 µm per litre of mixing</b>	80-120 m <sup>2</sup> /l	
<b>Corrosion category system 5501+902G (ISO 12944)</b>	C3 high / C4 medium (11µm+45µm)	

### SUBSTRATE AND PREPARATION OF THE SURFACE


	CLEANING	SANDING	FINAL CLEANING
Steel	DA93	P120 (opt.)	DA93
Galvanised steel	DA93	P360 (opt.)	DA93
Aluminium	DA93	P240 (opt.)	DA93

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





## APPLICATION

	SMALL SURFACE		LARGE SURFACE	
T(°C)	Hardener	Thinner	Hardener	Thinner
18-25	--	DS238	--	DS238
>25	--	DS238	--	DS238

	Application	% thinner (Vol.)	Viscosity - 20°C (Ford Cup 4)	Pressure (BAR)	Product Pressure (BAR)	Nozzle (mm)	Num. of Coats x µm dry	Flash off (min)
	Gravity feed spray gun	30%	15"-16"	1,5-2	---	1,4-1,6	1	10'-15' 20°C

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

## DRYING

 TEMPERATURE	 HANDLING
20° C	30'
60° C	15'

The product reaches its maximum performance after 15 days of drying in the air (ambient temperature 18-22°C) or in a shorter time at a higher temperature.

## ADDITIONAL ADDITIVES FOR SPECIAL USES

SITUATION	ADDITIVE	DESCRIPTION	EFFECT
Craters	Additive Anticrater Disolac	Film protection from outdoor polluting agents	Anticrater; film protection
Overspray sensitivity / Too fast drying of the film	Flow Additive	Improve the application, for example in the application of large surfaces or in dry conditions	Keeps the film opened for a longer time
Degreasing	DIS226 DA93	DIS226 for plastics and surfaces electrostatically chargeable. DA93 for greasy surfaces.	

For use and instructions of the additives consult the technical data sheet of each product.



#### REMARKS

- Recommended to be used in ventilated spray booth at 20°C.

#### EQUIPMENT CLEANING

- Use a cleaning thinner before the pot life has expired.

#### SAFETY

- Follow instructions of product label.
- For more information check the Safety Data Sheet.
- Compliant 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 unopened original 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.*

