

PRIMAPOX 6041 tintable

2K Epoxy Primer

PRODUCTS

Primer	PRIMAPOX 6041 tintable	
Hardener	E-6325	4:1
Thinner	SOLV UNIVERSAL 5	0-25%
	SOLV UNIVERSAL 3	0-25%

DESCRIPTION AND PROPERTIES

- Tinting primer with the pigmented bases of the Disolac system.
- Designed to give a color tone to the primer and consequently optimize the savings in the finishing coat. It is recommended to apply in a color similar or equal to that of the finishing coat of paint to improve the coverage.
- 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 2010/75/EU.

CHARACTERISTICS OF PRIMAPOX 6041 tintable

Appereance	Smooth	
Gloss	Matt	
Specific weight	1,5 kg/l a 20°C	
Solid content (unpainted primer)	72-76 %(weigh)	52-56% (volumen)
Solid content ready to use tinted and catalyzed, without dilution	68-72 %(weigh)	50-54% (volumen)
Dry film thickness	80-100 microns (2 layers)	
Theoretical yield 1 µm per litre of Primapox 6041 tintable	550-750 m²/l	
Theoretical yield 1 µm per litre of mixing without thinner (A+B)	500-540 m²/l	
Corrosion category system 6041+800G (ISO 12944)	C3medium/C4 low (85µm+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




	SMALL SURFACE		LARGE SURFACE	
T(°C)	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

	Mixable Primapox 6041 mix ratio: Disolac bases (weight ratio)	98-90:2-10
	Mixing ratio Hardener (in volume)	4:1 (volumen) 100:15 (weigh)
	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	0-15%	50-60"	---	190	11/40	1x 80-100	---
	Airmix	0-15%	50-60"	2	130	13/40	1x 70-90	---
	Gravity feed spray gun	20%	30-40"	2-3	---	1.6-1.8	2x 40-50	10'-15'
	Air Gun	5-25%	25-45"	2-3	---			
	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	 INSULATING
20° C	4 h min. – 7 days max. (P360/400)	1 h
60° C	30'	30'

*In a wet on wet processes, if you want to increase the final finish, it is advisable to wait 4 to 8 hours to repaint.
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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For any additional technical information please consult with our Customer Service or our Technical Department.