

PRIMAPOX 6041

2K Epoxy Primer

PRODUCTS

Primer	PRIMAPOX 6041	
Hardener	E-6325	4:1
Reducer	SOLV UNIVERSAL 5	0-20%
	SOLV UNIVERSAL 3	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

Appearance	Smooth	
Gloss	Matt	
Specific weight	14.1 lb/gal @ 68°F	
Solid content	72-77 % (weight)	55-59% (volume)
Solid content ready to use without reducer	68-72 % (weight)	52-56 % (volume)
Dry film thickness	3.9 mils (2 coats)	
Theoretical Coverage Per Gallon of binder @ 1 mil DFT	1050-1120 sq ft	
Theoretical Coverage Per Gallon of mixing without dilution @ 1 mil DFT	820-900 sq ft	
Corrosion category system 6041+800G (ISO 12944)	C4 Medium (9.4 mils+2.4 mils)	
Corrosion category system 6041+902G (ISO 12944)	C5 Medium (9.4 mils+2.4 mils)	



SUBSTRATE AND PREPARATION OF THE SURFACE





	CLEANING	SANDING	FINAL CLEANING
Old paints	DA93	P360/400	DA93
Steel	DA93	--	DA93
Galvanized steel	DA93	--	DA93
Aluminum	DA93	--	DA93

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

APPLICATION



T(°F)	SMALL SURFACE		LARGE SURFACE	
	Hardener	Reducer	Hardener	Reducer
64-77	E-6325	SOLV UNIVERSAL 5	E-6325	SOLV UNIVERSAL 5
>77	E-6325	SOLV UNIVERSAL 5	E-6325	SOLV UNIVERSAL 3

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

	Application	% reducer (Vol.)	Viscosity - 68°F (Ford Cup 4)	Pressure (psi)	Pressure of the Product (psi)	Nozzle (inches)	Number of Coats x mils dry	Flash off (min)
	Airless	10%	50-60 sec	---	2756	0.5-1.6	1x 3.1-3.9	---
	Airmix	10%	50-60 sec	29.0	1886	0.5-1.6	1x 2.8-3.5	---
	Gravity feed spray gun	20%	30-40 sec	43.5	---	0.06-0.07	2x 1.6-2.0	10-15
	Pot life	3 hrs						

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
68° F	3hrs min. – 7 days max. (P360/400)
140° F	30 min

The product develops its maximum properties after 15 days of air drying (ambient temperature 64-72°F) 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 +41°F and +86°F.

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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