

# PRIMAPOX 6041

## Epoxy primer 2K

High build 2K epoxy primer with superior anticorrosive protection and direct adhesion to metal and some plastics. VOC compliant according VOC Regulatory 3.5 lb/gal if using E-6325 LV and R225. Designed for both maintenance and OEM applications where a high protection of the substrate is required. Available in grey and tintable version.

### PRODUCT

Primer	<b>Primapox 6041</b>	
Hardener	<b>E-6325 / E-6325 LV</b>	4:1 (v) / 7:1 (v)
Reducer	<b>SOLV UNIVERSAL 5 - medium</b>	0-35% (v)
	<b>SOLV UNIVERSAL 3 - slow</b>	0-35% (v)
	<b>R225 – exempt VOC &amp; 0 HAPS reducer</b>	0-35% (v)

### CHARACTERISTICS OF PRIMAPOX 6041

Appearance	Smooth	
Gloss	Matt	
Specific weight	13.8-14.2 lb/gal @68°F	
Solid content (primer)	72-77% (weight)	55-59% (volume)
Solid content RFU (without reducer) (E-6325)	68-72 % (weight)	52-56 % (volume)
Solid content RFU (without reducer) (E-6325 LV)	72-76% (weight)	51-55%(volume)
Dry film thickness	3.2-4 mils (2 coats)	
Theoretical coverage per Gallon of mixing without dilution @ 1 mil DFT	820-900ft <sup>2</sup>	
Corrosion category system 6041 + 800-G (ISO 12944)	C5 Medium (9.5+2.4 mils)	
Salt spray resistance	720 h	
Humidity resistance	480 h	

## VOC

E-6325								
% reducer	VOC REGULATORY universal reducer		VOC ACTUAL universal reducer		VOC REGULATORY R225		VOC ACTUAL R225	
	lb/gal	g/L	lb/gal	g/L	lb/gal	g/L	lb/gal	g/L
0	4,30	515,3	4,30	515,3	4,30	515,3	4,30	515,3
10	4,54	544,0	3,91	468,5	4,30	515,3	3,98	476,9
20	4,75	569,2	3,57	427,8	4,30	515,3	3,71	444,6

\*VOC in the table is an average

E-6325 LV				
% reducer	VOC REGULATORY R225		VOC ACTUAL R225	
	lb/gal	g/L	lb/gal	g/L
0	3,4	410,3	3,4	410,3
10	3,4	410,3	3,2	377,3
20	3,4	410,3	2,9	349,2
30	3,4	410,3	2,7	325,0
35	3,4	410,3	2,6	314,1

\*VOC in the table is an average





## SUSTRATE AND PREPARATION OF THE SURFACE

	CLEAN	SANDED	FINAL CLEAN
Old paint	DA93	P360/400	DA93
Steel	DA93	--	DA93
Galvanized steel	DA93	--	DA93
Aluminum	DA93	--	DA93


For other substrates consult with the Technical Assistance (SAT).

## APPLICATION

	PIECE		BIG SURFACE	
T(°F)	Hardener	Reducer	Hardener	Reducer
64-77	E-6325/E-6325 LV	SOLV UNIVERSAL 5 / R225	E-6325/E-6325 LV	SOLV UNIVERSAL 5 / R225
77-90	E-6325/E-6325 LV	SOLV UNIVERSAL 5 / R225	E-6325/E-6325 LV	SOLV UNIVERSAL 3 / R225
>90	E-6325/E-6325 LV	SOLV UNIVERSAL 3 / R225	E-6325/E-6325 LV	SOLV UNIVERSAL 3 / R225






	Application	% Reducer (Vol.)	Viscosity – 68°F (Ford Cup 4)	Pressure (psi)	Product pressure (psi)	Nozzle (mm)	Num. Of coats x dry mil	Flash off (min)
	Gravity feed spray gun	5-15% (E-6325) 20-30% (E-6325 LV)	30-40"	20-30	---	1.6-2	2x2-2.5	10-15'
	Airless	0-10% (E-6325) 10-15% (E-6325 LV)	50-60"	---	1500-2500	11-15	2x2-3	10-15'
	Airmix	0-10% (E-6325) 10-15% (E-6325 LV)	50-60"	5-15	1500-2200	11-15	2x2-3	10-15'
	Pressure pot	5-15% (E-6325) 20-30% (E-6325 LV)	30-40"	5-15	20-30	---	2X2-3	10-15'

If the application requires the use of an additive, it should be taken into account in the addition of solvent  
Tixo's additive 5% addition is recommended to improve sagging resistance.

Pot life	59°F	68°F	86°F
	4h 30'	4h	3h 30'

\*Hardener: E-6325

## DRYING

 TEMPERATURE	 DUST DRY	 TO HANDLE	 DRY THROUGH	 TO RECOAT
<b>68° F (air dry)</b>	10-15'	80-100'	4h	4h min – 7 day max. (P360/400)
<b>86 °F</b>	5-10'	70-90'	4h	4h min – 7 day max. (P360/400)
<b>140° F (30' forced dry)</b>	---	---	30'	24h

*Drying at lower temperature or higher thickness increases drying time.  
The product reaches its maximum performance after 15 days of drying in the air (ambient temperature 64-72°F) or in a shorter time at higher temperature.*

## REMARKS

- Recommended to be used in ventilated spray booth at 68°F.

## EQUIPMENT CLEANING

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

## SAFETY

- Follow instructions on 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 41 and 86°F.

## SHELF LIFE

- One year in unopened original 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.*

*The information included in this documentation is based on our scientific and technical knowledge on the date of its issuance. ROBERLO reserves the right to modify and/or discontinue all or part of the information at any time and without prior notice. It is the user's responsibility to verify the update of the information. The latest version of this document replaces all previous versions.*

*All clauses contained herein apply to any future changes or modifications.  
For any additional technical information please consult with our Customer Service or our Technical Department.*