

Primanyl 5401

Anticorrosive 1K primer

Epoxy-ester 1K anticorrosive shop primer with direct adhesion to metal, ABS, PVC, methacrylate and gel coat. Recoatable with 1K topcoats, PUR 800 and PUR 840.

PRODUCT

Primer	PRIMANYL 5401		
Reducer	SOLV SYNTHETIC 5 - medium		0-45% (v)
	SOLV SYNTHETIC 3 - slow		0-45% (v)
	R225 – exempt VOC & 0 HAPS reducer		0-35% (v)

CHARACTERISTICS OF PRIMANYL 5401

Appearance	Smooth	
Gloss	Matt	
Specific weight	11.6-12.3 lb/gal @68°F	
Solid content primer	66-70% (weight)	41-45% (volume)
Solid content RFU (with 35% reducer in volume)	52-56% (weight)	30-34% (volume)
Solid content RFU (with 45% reducer in volume)	50-54% (weight)	28-32% (volume)
Dry film thickness	1.2-1.6 mils (2 coats)	
Theoretical coverage per Gallon of mixing without dilution @ 1 mil DFT	570-670 ft ²	

VOC

% Reducer	VOC REGULATORY SOLV SYNTHETIC 5		VOC ACTUAL SOLV SYNTHETIC 5		VOC REGULATORY R225		VOC ACTUAL R225	
	lb/gal	g/L	lb/gal	g/L	lb/gal	g/L	lb/gal	g/L
0	3,4	407,4	2,8	335,5	3,4	407,4	2,8	335,5
10	3,8	455,3	3,2	383,4	3,4	407,4	2,6	311,5
20	4,2	503,3	3,6	431,4	3,4	407,4	2,4	287,6
35	4,6	551,2	4,0	479,3	3,4	407,4	2,1	251,6
45	4,8	575,2	4,2	503,3	3,4	407,4	-	-

*VOC in the table is average, for specific colors check on iCrom



SUSTRATE AND PREPARATION OF THE SURFACE

	CLEAN	SANDED	FINAL CLEAN
Old paint	DA93	P180/240	DA93
Steel	DA93	--	--
Galvanized steel	DA93	--	--
Aluminum	DA93	--	--

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






APPLICATION

	PIECE	BIG SURFACE
T(°F)	Reducer	Reducer
64-77	SOLV UNIVERSAL 5 / R225	SOLV UNIVERSAL 5 / R225
77-90	SOLV UNIVERSAL 5 / R225	SOLV UNIVERSAL 3 / R225
>90	SOLV UNIVERSAL 3 / R225	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	OPTION 1 35-45% (SYNTHETIC 3 or SYNTHETIC 5) OPTION 2 25-35% (R225)	20-25"	43.5	---	1.4-1.6	2x1.6-2	10-15' (68°F)

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

DRYING

 TEMPERATURE	 TO TOUCH	 TO HANDLE	 DRY THROUGH	 TO RECOAT
68° F (air dry)	30 min	-	-	-
86°F	5 min	10 min	20 min	2h

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.

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