

Dynacoat 2K Epoxy Primer (sanding version)

Two-pack Epoxy based primer with good corrosion protection for car refinishing and light commercial vehicles, medium build or lower build for non sanding purpose.

**MIXING RATIO**

100 2K Epoxy Primer
50 Hardener Epoxy Primer
40 Dynacoat Thinners

**MIXING STICK**

Use Dynacoat mixing stick D6

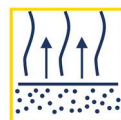
**EQUIPMENT**

Spray gun set-up: 1.6-2.0 mm
Application pressure: 1.7-2.2 bar at the air inlet*

*See user manual spray gun

**APPLICATION**

1-3 x 1 coat

**FLASH-OFF**

5-10 minutes between coats
5-10 minutes before bake

**DRYING**

8 hours at 20°C
45 minutes at 60°C

**RECOATABLE WITH**

All topcoats
Primer/Fillers
Putties

**PROTECTION**

Use suitable respiratory protection. AkzoNobel Vehicle Refinishes recommends the use of a fresh air supply respirator.

Dynacoat 2K Epoxy Primer (non sanding version) non compliant**MIXING RATIO**

100 2K Epoxy Primer
50 Hardener Epoxy Primer
50 Dynacoat Thinners

**MIXING STICK**

Use Dynacoat mixing stick

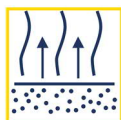
**EQUIPMENT**

Spray gun set-up: 1.3-1.6 mm
Application pressure: 1.7-2.2 bar at the air inlet*

*See user manual spray gun

**APPLICATION**

1 x 1 coat

**FLASH-OFF**

30 min. before topcoat

**RECOATABLE**

All topcoats
Primer/Fillers
Putties

**PROTECTION**

Use suitable respiratory protection. AkzoNobel Vehicle Refinishes recommends the use of a fresh air supply respirator.

PRODUCT AND ADDITIVES

Dynacoat 2K Epoxy Primer
 Dynacoat Hardener Epoxy Primer
 Dynacoat Thinner Fast
 Dynacoat Thinner Medium
 Dynacoat Thinner Slow

BASIC RAW MATERIALS

Epoxy Primer: Epoxy resins
 Epoxy Primer Hardener: Amine resins

SUITABLE SUBSTRATES

Existing finishes
 Polyester Putties, Polyester Spraying Filler,
 Steel
 Galvanized steel
 Aluminium
 Polyester Laminates
 Wood
 Ply wood
 OEM Electrocoat

SURFACE PREPARATION

Existing Finishes	P280-P320
Polyester Putties, Polyester Spraying Filler	P280-P320
Steel, Zinc coated Steel	P280-P320
Aluminium	Scotch brite red
Polyester Laminates	P280-P320
Wood, Ply wood	P180-P220

MIXING
Sanding

100 parts by volume of Dynacoat 2K Epoxy Primer
 50 parts by volume of Dynacoat Hardener Epoxy Primer
 40 parts by volume of Dynacoat Thinners
 Use mixing stick D6

Non sanding

100 parts by volume of Dynacoat 2K Epoxy Primer
 50 parts by volume of Dynacoat Hardener Epoxy Primer
 50 parts by volume of Dynacoat Thinners
 Use mixing stick D?

VISCOSITY

Sanding: 25-30 seconds DIN Cup 4 at 20°C
Non sanding: 23-27 seconds DIN Cup 4 at 20°C

POTLIFE

Sanding: 4 hours at 20°C
Non sanding: 6 hours at 20°C

TECHNICAL INFORMATION DYNACOAT 2K EPOXY PRIMER — D2.05.01

SPRAY GUN FLUID TIP AND WORKING PRESSURE	Sanding	Spray gun:	Fluid tip:	Pressure:
		Gravity feed:	1.6 – 2.0 mm	1.7 – 2.2 bar (see user manual spray gun) HVLP max 0.7 at aircap
	Non sanding	Spray gun:	Fluid tip:	Pressure:
		Gravity feed:	1.3 – 1.6 mm	1.7 – 2.2 bar (see user manual spray gun) HVLP max 0.7 at aircap
APPLICATION	Sanding	Apply 1-3 single coats, allowing for 5 to 10 minutes flash off time between coats. If force dried, allow for a minimum flash-off time of 5-10 minutes before bake.		
	Non sanding	Apply 1 flowing coat		
		If applied by brush, do not add thinner. Apply only one coat of 2K Epoxy Primer if a Polyester Body Filler or Polyester Spraying Filler will be applied.		
CLEANING OF EQUIPMENT	Use Guncleaner or a nitrocellulose thinner			
FILM THICKNESS	Sanding:	30-35 µm per coat		
	Non sanding:	20-25 µm per coat		
DRYING	Dry to sand	20°C	60°C	
		Hard dry	8 hours	45 minutes
	Infra red drying	Half power	Full power	
		3 minutes	9 minutes	
THEORETICAL COVER RATE	Sanding version:	At a layer thickness of 1 micron 405 m ² /liter ready for use mixture		
	Non sanding version:	At a layer thickness of 1 micron 398 m ² /liter ready for use mixture		
	Note: The practical coverage depends on several factors, including shape of the construction, roughness of surface, method of application being used and conditions of application			
BRUSHING	If Dynacoat 2K Epoxy Primer will be applied by brush, mix the Epoxy Primer only with Hardener, do not add any thinner			

RECOMMENDED SAND PAPER P400-P500 for dry sanding
P800-P1000 for wet sanding

RECOAT TIME	Non sanding	20°C	60°C
		Polyester Putties after	45 min
	Polyester Spraying filler after	45 min	15 min
	Fillers/Topcoats after	30 min	10 min

RECOATABILITY Dynacoat topcoats
Dynacoat Primers and Fillers
Dynacoat Putties and Polyester Spraying Filler
Note: Do **not** apply on etch primers

TINTING If required, Dynacoat 2K Epoxy Primer can be tinted up to 5% by volume with Dynacoat 2K Topcoat Pro or Dynacoat Topcoat 420

Dynacoat Epoxy Primer mixed with any of the topcoat colors must be stirred thoroughly before adding the Epoxy Primer Hardener and Thinner

PRODUCT STORAGE Product shelf-life is determined when products are stored unopened at 20°C.
Avoid extreme temperature fluctuation.

SHELF LIFE Dynacoat 2K Epoxy Primer: 18 months
Dynacoat Hardener Epoxy Primer: 1 year

VOC **2004/42/II B(c)(540)540**
The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540 g/liter VOC.
The VOC content of the sanding version of this product in ready to use form is max:540 g/liter.
Non sanding version: 550 g/liter (**not VOC compliant**)

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FOR PROFESSIONAL USE ONLY

IMPORTANT NOTE: The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfil the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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