DYNACOAT

TECHNICAL INFORMATION
DYNACOAT 2K EPOXY PRIMER
— D2.05.01

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 20ºC
45 minutes at 60ºC

RECOATABLE WITH
All topcoats
Primer/Fillers
Putties

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

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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.

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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 20ºC
Non sanding: 6 hours at 20ºC

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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** 3 minutes	**Full power** 9 minutes

THEORETICAL COVER RATE

Sanding version:
At a layer thickness of 1 micron 405 m² /liter ready for use mixture

Non sanding version:
At a layer thickness of 1 micron 398 m² /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

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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	15 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/IIB(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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