

2K Etch Primer

Adhesion Primers

01/09/2025

L2.03.02

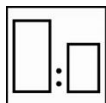
DESCRIPTION

Two-pack primer with washprimer properties, which is suitable for most substrates in vehicle refinishes.

It offers excellent adhesion properties and corrosion protection, especially on steel and aluminum.

The target use of this product is refinishing and refurbishment of existing vehicles.

Mixing ratio



10
2
5

2K Etch Primer
2K Etch Primer Hardener
2K Etch Reducer

Mixing by weight



G

Equipment



Spray gun set up:
1.4-1.6 mm

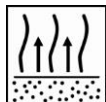
Application pressure:
1.7-2.2 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap

Application



1 x 1 coat

Flash-off



20 minutes at 20°C

Recoat between
20 minutes and 72 hours at 20°C

Recoatability



2K Ultimate Filler
2K Filler 540
2K Graphite Filler

2K High Build Filler
2K HS Primer Filler
Topcoat HS 420

2K Topcoat

Protection



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator

Read complete technical data sheet for detailed product information

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PRODUCT AND ADDITIVES

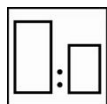
Product	2K Etch Primer	
	2K Etch Primer Hardener	
	2K Etch Primer Reducer	
Chemical Basis	2K Etch Primer	Polyester/ acrylate combination
	2K Etch Primer Hardener	Polyisocyanate resin
	2K Etch Primer Reducer	Organic Solvents/ catalyst

METHOD OF USE

Substrates	Steel
	Galvanized steel
	Aluminum
	Existing finishes
	Lesonal Polyester Bodyfillers
	OEM Electro Coat

Substrate preparation Sand with P220-P320 grit dry
See TDS L8.06.02 for substrates and preparation

Mixing ratio



10	2K Etch Primer
2	2K Etch Primer Hardener
5	2K Etch Primer Reducer

Spraying viscosity 14 – 17 sec. DIN Cup 4 at 20°C

Potlife After mixing, 90 minutes @ 20°C (70°F)

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Spray gun set up



Sanding

Spray gun:

HVLP Gravity

LVLP/HR Gravity

Fluid opening:

1.4-1.6 mm

1.4-1.6 mm

Spraying pressure:

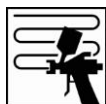
0.7 bar (at air cap)

1.7-2.2 bar (at air inlet)

Refer to user manual spray gun used

APPLICATION TECHNIQUE

Application



Apply one single coat.

Minimum application temperature: 15°C

Maximum application temperature: 35°C

Maximum relative humidity: 75%

Equipment cleaning

Use Multi Thinners or nitro cellulose thinner

Drying



Recoat after

20 minutes at 20°C

Recoat between

20 minutes at 20°C

72 hours at 20°C

Layer thickness

20 –25 microns

Material usage

Ready for use mixture at 1 µm layer thickness:

±440m²/liter

The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances

Recoatability

2K Ultimate Filler

2K Filler 540

2K Graphite Filler

2K High Build Filler

2K HS Primer Filler

Topcoat HS 420

2K Topcoat

Except: UV Filler, 2K Epoxy Primer, 1K Primer WB, Lesonal Basecoats

Product storage

Avoid extreme temperature fluctuation and high humidity levels

Shelf life

1 year at 20°C

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VOC**2004/42/II B(c)(540)505**

The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540 g/l VOC.

The VOC content of this product in ready to use form is max. 505 g/liter.

item

FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

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 fulfill 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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