

Dynacoat 2K Epoxy Primer – D2.05.01



Degreaser

Product Name:

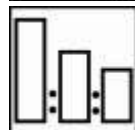
Dynacoat 2K Epoxy Primer (sanding version)



P280-P320

Description:

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



100:50:40

Products and Additives:

Dynacoat 2K Epoxy Primer
 Dynacoat Hardener Epoxy Primer
 Dynacoat Thinners Fast / Medium / Slow



6

Basic Raw Materials:

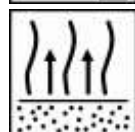
Epoxy Primer : Epoxy resins
 Epoxy Primer Hardener : Amine resins
 Dynacoat thinners : A blend of organic solvents



(gravity)
 1.8 mm
 2-4 bar

Suitable Substrates:

Existing Finishes
 Polyester Putties, Polyester Spraying Filler,
 Steel, Zinc coated Steel, Aluminium
 Polyester Laminates
 Wood, Ply wood



5-10 min

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



45 minutes
 at 60°C

Mixing Ratio:

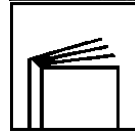
100 parts by volume of Dynacoat 2K Epoxy Primer
 50 parts by volume of Dynacoat Hardener Epoxy Primer
 40 parts by volume of Dynacoat Thinners



All topcoats
 Primer/Fillers
 Putties

Spray viscosity:

25 - 30 sec. DC 4 at 20°C.



Potlife:

6 hours at 20°C



Spray gun fluid tip and working pressure :

Spray gun:	Fluid tip:	Pressure :
Gravity feed:	1.6-2.0 mm	2-4 bar

Process:

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.
 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.

Film Thickness:

30-35 µm per coat.



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Mixing by weight:

	2K Epoxy Primer	Hardener Epoxy Primer	Dynacoat thinner
Sanding	100gr	28gr	22gr

Theoretical use per ltr/m²:

At a layer thickness of 1 micron 405 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

Cleaning of equipment:

Use Guncleaner or a nitrocellulose thinner

Drying time / application time:

	20°C	60°C
Hard dry	8 hrs	45 mins
Polyester Putties after	45 mins	15 mins
Polyester Spraying filler after	45 mins	15 mins
Fillers/Topcoats after	30 mins	10 mins

Recommended sand paper before topcoat:

P400-P500 for dry sanding
P800-P1000 for wet sanding

Recoatibility:

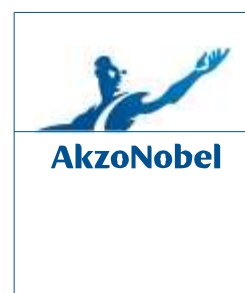
Dynacoat topcoats
Dynacoat Primers and Fillers
Dynacoat Putties and Polyester Spraying Filler

Tinting:

If required, Dynacoat 2K Epoxy Primer can be tinted up to 5% by volume with Dynacoat 2K Topcoat MM and Dynacoat Topcoat 420
-Dynacoat Epoxy Primer mixed with any of the topcoat colours must be stirred thoroughly before adding the Epoxy Primer Hardener and Thinner

Brushing:

If Dynacoat 2K Epoxy Primer will be applied by brush, mix the Epoxy Primer only with Hardener, do not add any thinner



TECHNICAL INFORMATION

Shelf life:	Dynacoat 2K Epoxy Primer: 18 months Dynacoat Hardener Epoxy Primer: 1 Year
Note:	Do not apply over etch primers
VOC:	2004/42/II B(c)(540)535 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 this product in ready to use form is max: 535 g/liter.

