

**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

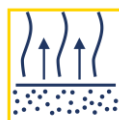
**EQUIPMENT**

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.

<b>PRODUCT AND ADDITIVES</b>	Dynacoat 2K Epoxy Primer Dynacoat Hardener Epoxy Primer Dynacoat Thinner Fast Dynacoat Thinner Medium Dynacoat Thinner Slow	
<b>BASIC RAW MATERIALS</b>	Epoxy Primer:	Epoxy resins
	Epoxy Primer Hardener:	Amine resins
<b>SUITABLE SUBSTRATES</b>	Existing finishes Polyester Putties, Polyester Spraying Filler, Steel Galvanized steel Aluminium Polyester Laminates Wood Ply wood OEM Electrocoat	
<b>SURFACE PREPARATION</b>	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
<b>MIXING</b>	<p><b>Sanding</b> 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</p> <p><b>Non sanding</b> 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?</p>	
<b>VISCOSITY</b>	<b>Sanding:</b>	25-30 seconds DIN Cup 4 at 20°C
	<b>Non sanding:</b>	23-27 seconds DIN Cup 4 at 20°C
<b>POTLIFE</b>	<b>Sanding:</b>	4 hours at 20°C
	<b>Non sanding:</b>	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:  
Gravity feed: 1.6 – 2.0 mm

**Pressure:**  
1.7 – 2.2 bar (see user manual spray gun)  
HVLP max 0.7 at aircap

#### Non sanding

**Spray gun:** Fluid tip:  
Gravity feed: 1.3 – 1.6 mm

**Pressure:**  
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 m<sup>2</sup> /liter ready for use mixture

Non sanding version:

At a layer thickness of 1 micron 398 m<sup>2</sup> /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

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

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

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**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*

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

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

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**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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