

EPOXY PRIMER GREY

Dynacoat Epoxy Primer Grey provides the adhesion and anti-corrosion characteristics that are important to a long-lasting repair. Dynacoat Epoxy Primer Grey can be used as a primer sealer, primer surfacer, or as a foundation to other materials such as polyester body filler.

**SAFETY CONSIDERATIONS**

- Use suitable personal protection.
- When exposed to paint or solvents AkzoNobel recommends the use of a fresh air supply respirator.

**SURFACE PREPARATION**

- Existing finishes
 - #P320 to #P400 sandpaper dry
- Polyester body filler
 - #P150 to #P220 sandpaper dry
- Bare Steel
 - Final sanded with #P120 sandpaper dry
 - Red scuff pad
- Zinc coated steel
 - Red scuff pad
- Aluminum (5052)
 - #P150 to #P220 sandpaper dry

**SURFACE CLEANING**

- Use suitable surface cleaners and technique to ensure a clean surface.

**MIXING – AS A WET-ON-WET SEALER****Mix**

- | | |
|----------|--|
| 3 | Parts Dynacoat Epoxy Primer Grey |
| 1 | Part Dynacoat Epoxy Hardener |
| 1 | Part Dynacoat Epoxy Reducer 3.5 or Epoxy Reducer 2.1 |

BY VOLUME

- ✓ Other mixing ratios are available, see the complete TDS for detailed information.

**EQUIPMENT****Spray-Gun Set-Up for Sealer Mix:**

- 1.3 – 1.5 mm HVLP Gravity
- 1.3 – 1.5 mm Compliant Gravity

Application Air Pressure:

- HVLP – 10 psi (<0.7 bar) at cap maximum
- Consult manufacturer specifications.

**APPLICATION**

- Apply one to two single flowing coats.

**FLASH OFF****Flash Between Coats at 70°F (21°C)**

- 10 minutes

**FLASH AT 70°F (21°C) BEFORE TOPCOATING**

- 30 – 45 minutes
- Maximum 7 days at ambient temperature and protected from outside elements.
 - *Dependent on film weight and air flow*

**RECOATABILITY**

- Dynacoat Epoxy Primer Grey as a sealer may have polyester body filler or Dynacoat basecoats or topcoats applied.

Read the complete TDS and the product Safety Data Sheet (SDS) for detailed product information

EPOXY PRIMER GREY

DESCRIPTION

Dynacoat Epoxy Primer Grey provides the adhesion and anti-corrosion characteristics that are important to a long-lasting repair. Dynacoat Epoxy Primer Grey can be used as a primer sealer, primer surfacer, or as a foundation to other materials such as polyester body filler.



PRODUCT ASSORTMENT

- Dynacoat Epoxy Primer Grey – Item #567970 (Gallon)
- Dynacoat Epoxy Hardener – Item #567968 (Liter)
- Dynacoat Epoxy Reducer 3.5 – Item #570453 (Gallon)
- Dynacoat Epoxy Reducer 2.1 – Item #570455 (Gallon)
 - 2.1 Reducer is intended for VOC regulated areas.
- Stock unopened or used products in approved closed containers with proper labeling. Store in temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (21°C).
- Refer to price sheet for shelf life information.



SURFACE PREPARATION

Substrate

- Blasted steel
- Sanded steel
- Galvanized steel
- Aluminum (5052)
- Polyester body filler
- Fiberglass gelcoat (unbroken)
- Existing finishes (except acrylic lacquers)

Preparation

- Blow off to remove dust and debris
- Final sand with #P120 sandpaper dry
- Scuffed with a red scuff pad
- #P150 to #P180 sandpaper dry
- #P150 to #P220 sandpaper dry
- #P220 to #P320 sandpaper dry
- #P320 to #P400 sandpaper dry



- ✓ The minimum film thickness required over a blasted profile is >1.5 mils (>38 µm) for suitable protection.
- ✓ Adhesion and anti-corrosion performance can be enhanced by pre-coating metal surfaces with the AkzoNobel AutoPrep Pretreatment Wipe material before priming.
- ✓ Aluminum grades other than 5052 should be tested prior to refinishing.



Surface Cleaning

- Use suitable surface cleaners and technique to ensure a clean surface.



MIXING

Mix	High Build Surfacer Ratio
3	Parts Dynacoat Epoxy Primer Grey
1	Part Dynacoat Epoxy Hardener

BY VOLUME



Mix	Medium Build Wet-on-Wet Ratio
3	Parts Dynacoat Epoxy Primer Grey
1	Part Dynacoat Epoxy Hardener
0.5	Part Dynacoat Epoxy Reducer (3.5 or 2.1)

BY VOLUME



Mix	Wet-on-Wet Sealer Ratio
3	Parts Dynacoat Epoxy Primer Grey
1	Part Dynacoat Epoxy Hardener
1	Part Dynacoat Epoxy Reducer (3.5 or 2.1)

BY VOLUME

EPOXY PRIMER GREY

EZ ZAHN #3

VISCOSITY – READY TO SPRAY AT 70°F (21°C)**11.5 – 13.5 Seconds****9 – 11 Seconds****7.5 – 9.5 Seconds**

3:1 High Build Surfacer

3:1:0.5 Medium Build Wet-on-Wet

3:1:1 Wet-on-Wet Sealer

**POT-LIFE WHEN MIXED****Product Mix**

- Dynacoat Epoxy Primer Grey
- ✓ A shorter pot-life can be expected in higher temperatures.

At 70°F (21°C)

4 hours

**SPRAY-GUN SET-UP****Spray-Gun Set-Up (3:1 Ratio)**

- 1.7 – 1.9 mm HVLP Gravity
- 1.5 – 1.7 mm Compliant Gravity

Application Air Pressure:

- HVLP – 10 psi (<0.7 bar) at cap, maximum.
- Consult manufacturer specifications.

Spray-Gun Set-Up (3:1:0.5 Ratio)

- 1.5 – 1.7 mm HVLP Gravity
- 1.5 – 1.7 mm Compliant Gravity

Application Air Pressure:

- HVLP – 10 psi (<0.7 bar) at cap, maximum.
- Consult manufacturer specifications.

Spray-Gun Set-Up (3:1:1 Ratio)

- 1.3 – 1.5 mm HVLP Gravity
- 1.3 – 1.5 mm Compliant Gravity

Application Air Pressure:

- HVLP – 10 psi (<0.7 bar) at cap, maximum.
- Consult manufacturer specifications.

**APPLICATION****3:1 High Build Surfacer Mix**

- Apply two single flowing coats.
- Allow a 10-minute flash between coats.

3:1:0.5 or 3:1:1 Wet-on-Wet Mix

- Apply one or two single flowing coats.
- Allow a 10-minute flash between coats.

**FLASH DRYING****Flash Between Coats at 70°F (21°C)**

- 10 minutes

Flash at 70°F (21°C) Before Topcoating

- 30-45 minutes (7 days maximum)

- ✓ Flash time is dependent on temperature and application.
- ✓ Polyester body filler products: Flash dry for a minimum of 1 hour (maximum 7 days) before applying.
- ✓ Maximum times are based on the object maintaining an ambient temperature status and preventing extended exposure to the outside elements.

**DRYING / CURING – 3:1 HIGH BUILD SURFACER MIX****Drying / Curing at 70°F (21°C)**

- 24 Hours dry to sand.

Drying / Curing at 140°F (60°C)

- 1 – 1½ hours dry to sand.

- ✓ Drying times are stated at recommended application method, film thickness, and object temperature.

EPOXY PRIMER GREY**RECOATING**

- After observing proper flash time, Dynacoat Epoxy Primer Grey may be recoated with Dynacoat surfacers, sealers, basecoats, and topcoats. It may also be recoated with most polyester body filler products.

**VOC / REGULATORY INFORMATION**

- Notice: Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.

Dynacoat Epoxy Primer Grey Ready to spray VOC:

Product Mix	lb/gal	gr/L
Epoxy Primer Grey High Build (3:1)	2.1	250
Epoxy Primer Grey with Epoxy Reducer 2.1 (3:1:0.5)	2.1	250
Epoxy Primer Grey with Epoxy Reducer 2.1 (3:1:1)	2.1	250
Epoxy Primer Grey with Epoxy Reducer 2.1 (3:1:0.5)	2.8	326
Epoxy Primer Grey with Epoxy Reducer 3.5 (3:1:1)	3.2	384

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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 fulfill the demands set out in the local rules and legislation. Always read the Safety 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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