DYNACOAT

PROGRAMMED SYSTEM TECHNIQUE (PST)
PRIMER
NORTH AMERICA

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
• 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.

BY VOLUME

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

✓ 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

AkzoNobel

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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)
  - Item #567968 (Liter)
- Dynacoat Epoxy Hardener
  - Item #570453 (Gallon)
- Dynacoat Epoxy Reducer 3.5
  - Item #570455 (Gallon)
- Dynacoat Epoxy Reducer 2.1
  - 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	Preparation
• Blasted steel	– Blow off to remove dust and debris
• Sanded steel	– Final sand with #P120 sandpaper dry
• Galvanized steel	– Scuffed with a red scuff pad
• Aluminum (5052)	– #P150 to #P180 sandpaper dry
• Polyester body filler	– #P150 to #P220 sandpaper dry
• Fiberglass gelcoat (unbroken)	– #P220 to #P320 sandpaper dry
• Existing finishes (except acrylic lacquers)	– #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

BY VOLUME

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)

DYNACOAT

TECHNICAL DATA SHEET (TDS)
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EZ ZAHN #3

VISCOSITY – READY TO SPRAY AT 70°F (21°C)

11.5 – 13.5	**Seconds**	3:1 High Build Surfacer
9 – 11	**Seconds**	3:1:0.5 Medium Build Wet-on-Wet
7.5 – 9.5	**Seconds**	3:1:1 Wet-on-Wet Sealer

POT-LIFE WHEN MIXED

Product Mix — **At 70°F (21°C)**

- Dynacoat Epoxy Primer Grey — 4 hours
  - ✓ A shorter pot-life can be expected in higher temperatures.

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.

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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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