

Product Description

DynaPrime® Sealer is a two-component polyurethane filler as a primer or as a primer-sealer over fillers and putties. DynaPrime® Sealer is designed to promote adhesion of topcoats to the substrate.

Advantages:

- **Excellent impact resistance**
- **Excellent chemical resistance**
- **Excellent adhesion to cast iron and steel**
- **Excellent resistance to machine tool cutting oils**
- **Easy sanding**
- **Excellent hold for full gloss topcoats**
- **Air dry or force dry**
- **Ideal for use as a crankcase sealer**
- **Intermediate coat for machine tool finishing system**
- **Free of lead and chromate hazards**

Surface Preparation:

General: See General Surface Preparation Guide

Cast Iron: Fill with DynaPrime® Spray Fill. Sand and seal with DynaPrime® Primer-Sealer.

Plastic: Due to the diverse nature of plastic substrates, a coating or coating system should be tested for acceptable adhesion to the substrate prior to use in production. A filler or barrier coat may be required. Please check with your NCP Coatings Technical representative for system recommendations.

Steel or Iron: Remove rust, mill scale and oxidation products. For best results, treat the surface with a surface chemical treatment of zinc or iron phosphate to improve corrosion protection.

Wood (interior only): Must be clean, dry, and finish sanded. Do not exceed 2.5 mils dry film.

Application**Conventional Spray:** Pressure Feed System

Air Pressure..... 50 psi
 Fluid Pressure..... 10 psi
 Gun..... DeVilbiss MBC
 Needle..... E or FF
 Air Cap..... 704
 Pressure..... 1800-2100 psi
 Tip..... .011" - .015"

HVLP: (Binks Mach 1)

Atomizing air pressure at the cap..... 8 - 9 psi
 Fluid Pressure..... 10 psi
 Tip..... 905P

Dip, FloCoat, and Brushing are not recommended.

Clean tools / equipment immediately after use with Dynathane® DMR series reducer, MEK, MIBK, or MAK.

Technical Data:

Gloss: Flat

Volume Solids: 22 +/- 2%
(Catalyzed and reduced)

Viscosity: Catalyzed and reduced
17-23 seconds # 3 Zahn cup

Recommended Film Thickness:

Mils Wet 3.5 - 4.5
 Mils Dry 1.0 - 1.25

Spreading Rate: (no application loss)
370 sq. ft. at 1 mil dft.

Drying (1.5 mils. Dft, 77° F, 45% RH)

To Touch: 5-15 minutes
 To Handle: 40 - 60 minutes
 To Recoat: 30 - 60 minutes
 To Sand: 2 hours
 Force Dry: 10 - 30 min. at 140-180° F

Do not exceed heat distortion temperature of the substrate.

Flash Point 25° F

Mix Ratio: 13 parts DynaPrime® Spray Fill
 1 part DTA 7520
 3.5 parts DMR reducer or MAK

Pot Life 8 hours at 77° F
 Less reduction or higher temperatures will shorten pot life.

Package Life 3 years unopened

VOC (as packaged)
 5.3 lb/gal (636 g/l)
 (Catalyzed and reduced as above)
 5.53 lb/gal (663 g/l)

Testing: Due to the wide variety of substrates, surface preparation methods, application methods and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.

VOC compliance limits vary from state to state; please consult local air quality rules and regulations.

Follow manufacturer's safety recommendations when using any solvent.