NCP Coatings Inc.

DynaMatch® Spray Fill

DMP-7524 A **Gray Fill Primer**

Technical Data Sheet

225 Fort St.
Niles, MI
49120

Phone:
(800) 627-1948
(616) 683-3377

Fax:
(616) 683-3305

Product Description

DynaPrime® Spray Fill is a two-component, polyurethane filler designed to fill and/or hide profile and surface imperfections on metal, castings, structural foam plastics such as FRP, SMC, and wood. It is versatile as a filler, primer surfacer, or as a primer. DynaPrime® Spray Fill is designed for heavy film applications and also promotes adhesion of topcoats to the substrate.

Surface Preparation:

General: See General Surface Preparation Guide
Aluminum or Galvanized Steel: If untreated, prime with Dyna Prime® Wash Primer.
Machine Tool Castings: Apply a light coat to highlight imperfections. Then apply multiple coats until the desired fill is achieved. Up to 15 mils dry film can be applied in multiple steps.
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.
Polystyrene and Polycarbonate: When coating these plastics, use accelerated catalyst with MEK. This faster evaporating system has much less effect on the plastics. Do not exceed 4 mils dry film.
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 Dynathan® DMR series reducer, MEK, MIBK, or MAK.

Technical Data:

Gloss: Flat

Volume Solids: 38 +/- 2%
(Catalyzed and reduced)

Viscosity: Catalyzed and reduced
20 - 25 seconds # 3 Zahn cup

Recommended Film Thickness:

Mils Wet	4.0 – 6.0
Mils Dry	1.5 – 2.5

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

Drying (1.5 mils. Dft, 77˚ F, 45% RH)

To Touch:	15 minutes
To Handle:	1 hour
To Recoat:	1 hour
To Sand:	4 hours
Force Dry:	20 - 30 min. at 140˚ F

Do not exceed heat distortion temperature of the substrate.

Flash Point 40 ˚ F

Mix Ratio:

13 parts	DynaPrime®Spray Fill
1 part	DTA 7520
2 parts	DMR reducer or MAK

Pot Life 6 - 8 hours
Less reduction or higher temperatures will shorten pot life.

Package Life 3 years unopened

VOC (as packaged)
4.2 lb/gl (504 g/l)
(Catalyzed and reduced as above)
4.6 lb/gl (552 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.

For more information, please contact NCP Coatings Inc. at (616) 683-3377 or visit our website at www.ncpcoatings.com.