

Product Description:

Dynathane® HS Polyurethane Enamel is a 2.8 VOC, two-component coating providing high gloss and excellent exterior durability. Dynathane® HS has high resistance properties along with high volume solids. Dynathane® HS is available in a full range of colors, gloss levels, and has a high spreading rate. Dynathane® HS gives an exceptional appearance and is ideal for many types of metal and plastics. It is free of lead and chromate hazards and has excellent mar, abrasion, and impact resistance.

Surface Preparation:

General: See General Surface Preparation Guide

Aluminum or Galvanized Steel: Prime with DynaPrime® Wash Primer followed by DynaPrime® Sealer, Spray Fill or 2.8 VOC catalyzed Epoxy Primer.

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. For untreated metal, prime with DynaPrime® Wash Primer followed by DynaPrime® Sealer, Spray Fill or 2.8 VOC catalyzed Epoxy Primer.

Wood (interior only): Must be clean, dry, and finish sanded. Seal with a full coat of DynaPrime® 2.8 Spray Fill Sealer.

Application

Note: Maximum total reduction is 12% by volume to maintain 3.5 VOC.

Conventional Spray:

Air Pressure.....40 - 50 psi
 Fluid Pressure.....5 - 10 psi
 Tip......047

Airless Spray:

Pressure..... 2000 - 2800 psi
 Tip......009" - .011"

Air Assisted Airless:

Air Pressure..... 10 - 30 psi
 Fluid Pressure..... 600 - 900 psi
 Tip......009" - .011"

Electrostatic Spray:

Conductivity is 0.2-0.8 me ohms resistance, which is suitable for all hand-held electrostatic spray setups.

HVLP:

Atomizing air pressure at the cap..... 3 - 5 psi
 Fluid Pressure..... 5 - 10 psi
 Tip......040

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

Technical Data:

Gloss: Full, 90+units
Volume Solids: 63 +/- 2%
 Catalyzed and reduced may vary by color

Viscosity: Catalyzed and reduced
 18-20 seconds #2 Zahn cup

Recommended Film Thickness:
 Mils Wet 2.0 - 2.5
 Mils Dry 1.25 - 1.5

Spreading Rate: (no application loss)
 650 - 760 sq. ft. at 1.25 - 1.5 mil dft.

Drying

Catalyzed with DMC 7519
 (1.5 mils. Dft, 77° F, 50% RH)
 To Touch: 20 minutes
 To Handle: 8 hours
 Tack Free: 30 minutes
 To Recoat: no critical recoat
 Force Dry: 30 min. at 160 - 180° F
 Catalyzed with DMC 7521
 To Touch: 60 - 90 minutes
 To Handle: 10 - 12 hours
 Tack Free: 8 hours
 To Recoat: 5 - 6 hours
 Force Dry: 30 min. at 160 - 180° F

Do not exceed heat distortion temperature of the substrate.

Flash Point 25° F
Mix Ratio: 2 parts Dynathane® HS
 1 part DTA 7520 / 7521
 10 - 14% DMR reducer

Pot Life 2 - 3 hours
Package Life 3 years unopened
VOC (as packaged) 2.8lb/gal (360 g/l)

Performance Tests

Substrate: Bonderite 1000 20guage panels, 1.5 mil dft.,
 30 minutes at 180° F, 14 days cure time.
 Salt Spray Test (1/8 rust at scribe).....250 hours
 Humidity 100% RH, 100°F.....250 hours
 Pencil Hardness..... 3H
 Water Immersion.....24 hours

Gloss Adjustments

Gloss can be lowered by intermixing with Dynathane® DTC 7325 Flattening base.

Mixing ratio	Parts			
Dynathane	2	1½	1	
DTC 9325	0	1	1½	2
Catalyst	1	1	1	1

Gloss level Full 60-75 40-50 20-30
 All gloss ranges are approximate. Flattening does reduce hiding, Film thickness, flash off time, and cure schedules also affect gloss.

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