



Technical Data Sheet

Date of issue	Revision Date	Version
03/12/2006	28/1/2021	1.7
Product Code	Product Name	

EP _ - 2K Epoxy Primer

DNA® 2K Epoxy Primer available in grey and black, is a High Solid, zinc chromate free, 2K anti corrosion primer suitable for all kinds of finishes. Designed for use on most substrates such as ferrous and non-ferrous metals, aluminium, fiberglass and many other surfaces. DNA® Epoxy Primer accepts all topcoats, may be used wet on wet and dries to a satin matte finish. DNA® Epoxy Primer possesses excellent corrosion and chemical resistance with excellent adhesion on properly prepared metal substrates for this versatile easy to use primer

Always check the [DNA® website](#) that you have the latest TDS ([Technical Data Sheet](#)) and SDS ([Safety Data Sheet](#))

APPLICATION GUIDE:



SDS: Observe all safety precautions in relation to this product. Always wear appropriate PPE such as gloves, spray suit, breathing mask etc.



THEORETICAL COVERAGE: 8 sq m per litre @ 60um dry film



PREPARATION: Surface must be clean & dry. Sand using P180~320 dry. Wipe with suitable tack cloth.



CLEANING: Thoroughly clean the surface using DNA® Wax & Grease Remover then finish with DNA® Prep Clean X™.



SUBSTRATE: For use over Galvanized Steel, Mild Steel, Aluminum and Fiberglass (Gelcoat). All substrate coatings must be cleaned and suitable prepared.



MIXING RATIO: 3:1 with DNA® Epoxy Primer Hardener. Reduce if required. Use only DNA® Epoxy Primer Reducer up to a maximum of 40%.



SPRAYING VISCOSITY: Ford 4 Cup 20-30 sec



POT LIFE: Up to 8 Hours @ 20°C



CONVENTIONAL GUN SET UP:
1.5~1.8 Fluid tip
40~60 psi Air pressure
15~25 cm Spray distance
15~20 cm Fan size



HVLP GUN SET UP:

1.2~1.6 Fluid tip
40 psi Air pressure
10~15cm Spray distance
15~25 cm Fan size



SPRAYING: Strain mixed primer into paint gun. Allow flash time between each coat. Apply 1 to 2 medium wet coats with a 50% spray overlap. Recommended film build 20 µm.



CURING TIMES @ 25°C:

Dust Free: 30-45 min
Dry to Handle 90-120min
Baking: 40min @ 60°C
Sanding: 8 Hours
Recoating with topcoats after 2 hours



FLASH OFF @ 25°C: 10~15 min between coats.



RECOATING: Can be recoated without sanding after 2 hours. Apply your chosen DNA® BaZecoat™ or Special effects product as per the product TDS. If left for prolonged periods sand with P800 and clean before further application.



CLEAN UP: Clean equipment with Gun wash, Reducer or Thinners

STORAGE: 1 Year in cool, dry conditions

Important:

- Always check you have the latest [Technical Data Sheet](#)
- Always buy enough product to complete the entire job.
- If using more than one container of the same colour, always mix all container contents together to ensure consistency of colour
- Products are for Professional Use Only

Warranty: DNA® will replace any faulty or defective goods.

Goods are guaranteed for 12 months if stored in cool dry conditions. All information and data provided is given in good faith and intended as a general guide only. Given the many variables, including but not limited to; conditions of substrates, lack of or unsuitable preparation, application or use of product, mixing or straining, use of incompatible materials, different surface preparations, previous coatings and repairs, the effects of storage, equipment failure or use of incorrect equipment, air quality, humidity, or any other reason beyond the control of DNA®, and DNA® reserves the right to make changes to formulations. On occasion batches may have slight variations such as colour or tone, these are not covered by warranty. This is among the many reasons the user must always test the product(s) prior to commencing any job to determine suitability and check in case there is an adverse reaction. You must also always do a spray out test panel to check the final finish and appearance. Furthermore DNA® offers no warranties of whatever nature and will not accept liability because of any failure express or implied as to merchantability or fitness for a particular use or purpose and will not accept liability for any specific or consequential damage because of using these products. If any goods are defective, you must not commence the job and must immediately contact your distributor or DNA®. Any faulty goods must be returned at the customers expense to the place of purchase with a copy of the original invoice or other proof of purchase to be eligible for the replacement of the faulty product or at the discretion of DNA® for a refund of the cost of goods only. Our goods come with guarantees that cannot be excluded under the Australian Consumer Law. You are entitled to a replacement or refund for a major failure and compensation for any other reasonably foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of acceptable quality and the failure does not amount to a major failure. The benefits provided to the consumer by the warranty are in addition to other rights and remedies available to the consumer under the law.

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