





# Metacryl 7390 HS Epoxy Primer Gray




**COMPONENTS**  
7390 HS Epoxy Primer Gray  
7385F Fast Hardener  
7373 Reducer




**APPLICATION**  
2 wet coats  
15 minute flash time  
between coats




**MIX RATIO**  
4 : 1 : 1



**DRY TIME**  
Dry to Sand: Overnight  
Dry to Topcoat: 1 Hour per coat



**VISCOSITY**  
ZAHN #3  
10 – 15 Seconds



**VOC**  
2.1 lbs/gal  
251 g/L



## GENERAL

### DESCRIPTION

Metacryl 7390 HS Epoxy Primer Gray is a two-component, chromate-free high build primer that provides optimum adhesion and excellent corrosion protection to bare metal substrates. This epoxy primer will ensure greater inter-coat adhesion, chemical resistance and color holdout. 7390 HS epoxy primer gray utilizes a non-induction catalyst to increase productivity.

### COMPATIBLE SUBSTRATES

- Metacryl 7398 Polypropylene Primer
- Properly prepared steel, aluminum and galvanized steel
- Thoroughly sanded OEM finishes
- Thoroughly sanded and cured paint
- Cured body filler

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



## MIXING

### COMPONENTS

Mix 4 parts 7390 HS Epoxy Primer Gray to 1 part 7385F Hardener to 1 part 7373 Reducer.

Component	Volume
Metacryl 7390 HS Epoxy Primer Gray	4
Metacryl 7385F Hardener	1
Metacryl 7373 Reducer	1



**POT LIFE**

8 Hours at 77°F/24°C / 50% R.H.




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**APPLICATION**

**APPLICATION EQUIPMENT**

HVLP Gravity	1.4 - 1.8 mm	6 - 10 PSI	*At the cap
High Efficiency	1.4 - 1.8 mm	30 PSI	At gauge
Pressure Pot	1.0 – 1.1 mm	6 - 10 PSI	*At the pot

NOTE: Refer to spray gun manufacturer for further information regarding HVLP Inlet Pressures

**APPLICATION**

Spray 2 wet coats, allow 15 minutes flash time between coats.  
**DO NOT APPLY OVER 2K ETCH PRIMER.**

**CLEAN-UP**

Clean spray equipment immediately following application with a quality thinner or spray gun cleaner. Dispose of all paint and paint related materials in accordance with state and local regulations.




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**DRY TIMES**

**AIR DRY**

@ 75°F/23°C

To Sand	Overnight
To Topcoat	1 Hour per coat
Primer Open Time	24 Hours Before Sanding




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**PHYSICAL PROPERTIES**

RTS VOC	2.1 lbs/gallon
RTS Volume Solids	53.0%
ZAHN #3 Viscosity	10 – 15 Seconds
DFT per Coat	Approximately 2.0 mil
Theoretical Coverage	Approx. 864 SqFt at 1 Mil DFT/mixed gallon
ASTM B117 Salt Fog	500 Hours Pass
Flexibility	Pass Conical Mandrel
Adhesion	5B, 2mm cross hatch
Product Class	Undercoat

**STORAGE CONDITIONS**

Store in a dry, well ventilated area. Storage temperatures should be between -30°F (-34°C) and 120°F (48°C).



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## VOC REGULATED AREAS

VOC as Applied

251 grams/liter | 2.1 lbs/gallon

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

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## SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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In the United States and Canada:

**1.855.6.AXALTA**  
**metacryl.us**

