






Metacryl 7391 2K Primer Surfacer




COMPONENTS
7391X 2K Primer Surfacer
7360 or 7361 Hardener
7373 Reducer




APPLICATION
2 - 3 wet coats
5 - 10 minute flash time
between coats




MIX RATIO
8 : 1 : 2 - 3



DRY TIME
Dry to Sand: 1 Hour per coat
Sealer Option: 30 Minutes
IR Bake: 15 Minutes at full power, 36"



VISCOSITY
ZAHN #3
20 - 22 Seconds



VOC
2.1 lbs/gal
251 g/L



GENERAL

DESCRIPTION

Metacryl 7391 2K Primer Surfacer is a chromate-free, high build primer which provides excellent adhesion and corrosion protection. The easy sanding formula provides an excellent base for Metacryl top coat colors. Available in gray, black and white.

COMPATIBLE SUBSTRATES

- Metacryl 7398 Polypropylene Primer
- Metacryl 7394 2K Etch 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 8 parts 7391 2K Primer Surfacer to 1 part 7360 or 7361 Hardener to 2 - 3 parts 7373 Reducer.

| Component | Volume |
|----------------------------------|--------|
| Metacryl 7391 2K Primer Surfacer | 8 |
| Metacryl 7360 or 7361 Hardener | 1 |
| Metacryl 7373 Reducer | 2 - 3 |



PRIMER SURFACER SELECTION

- 7391A 2K Primer Surfacer Gray
- 7391B 2K Primer Surfacer Black
- 7391W 2K Primer Surfacer White

HARDENER SELECTION

- 7360 Fast 65 – 75°F/18 – 24°C
- 7361 Medium 75 – 85°F/24 – 29°C

SPECIALTY COMPONENTS

- 7376 Fisheye Eliminator: Max 2%
- 7377 Accelerator: NOT RECOMMENDED. It can lead to loss of adhesion or corrosion protection properties.

POT LIFE

90 Minutes at 77°F/24°C / 50% R.H.



APPLICATION

APPLICATION EQUIPMENT

| | | | |
|-----------------|--------------|------------|-------------|
| HVLP Gravity | 1.5 – 1.8 mm | 6 – 10 PSI | *At the cap |
| High Efficiency | 1.5 – 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 -3 wet coats, allow 5 – 10 minutes flash time between coats.

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.

DRY TIMES

AIR DRY

@ 75°F/23°C

| | |
|----------------------------|-------------------------------|
| To Sand | 1 Hour per coat |
| Sealer Option (small area) | 30 Minutes |
| IR Bake | 15 Minutes at full power, 36" |



PHYSICAL PROPERTIES

| | |
|--------------------------------|--------------------------------------------|
| RTS VOC | 2.1 lbs/gallon |
| RTS Volume Solids | 35.0% |
| ZAHN #3 Viscosity | 20 – 22 Seconds |
| DFT per Coat | Approximately 2.0 mil |
| Theoretical Coverage | Approx. 570 SqFt at 1 Mil DFT/mixed gallon |
| ASTM B117 Salt Fog (500 Hours) | No corrosion on scribe No blisters |
| 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).

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.

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

