





# Metacryl 7393A HS Urethane Primer




**COMPONENTS** 7393A HS Urethane Primer  
7360 or 7361 Hardener  
7373 Reducer




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



**MIX RATIO** 5 : 1 : 1



**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 7393A HS Urethane Primer is a chromate-free, direct to metal, high build primer that provides excellent adhesion and corrosion protection. This easy sanding formula provides an excellent base for Metacryl topcoat colors.

### 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 5 parts 7393A HS Urethane Primer to 1 part 7360 or 7361 Hardener to 1 part 7373 Reducer.

Component	Volume
Metacryl 7393A HS Urethane Primer	5
Metacryl 7360 or 7361 Hardener	1
Metacryl 7373 Reducer	1



**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	53.0%
ZAHN #3 Viscosity	20-22 Seconds
DFT per Coat	Approximately 2.5 mil
Theoretical Coverage	Approx. 848 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).

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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**

