





Metacryl 7394 2K Etch Primer



7394 2K Etch Primer
7364 Converter

COMPONENTS




1 - 2 medium wet coats
5 – 10 minute flash time
between coats

APPLICATION




1 : 1

MIX RATIO




Hand Slick: 5 Minutes
Dust Free: 10 Minutes
Dry to Nib Sand: 30 Minutes per coat
Dry to Topcoat: 30 Minutes

DRY TIME



ZAHN #3
18 – 20 Seconds

VISCOSITY



5.6 lbs/gal
671 g/L

VOC



GENERAL

DESCRIPTION

Metacryl 7394 2K Etch Primer is a chromate-free metal pretreatment. 7394 provides a fast drying barrier coat that etches bare metal substrates preparing them for additional topcoats. This primer provides excellent etching and adhesion to aluminum, galvanized and bare steel surfaces.

COMPATIBLE SUBSTRATES

- Properly prepared steel, aluminum and galvanized steel
- Thoroughly sanded OEM finishes adjoining metal
- Thoroughly sanded and cured paint adjoining metal
- Cured body filler

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



MIXING

COMPONENTS

Mix 1 part 7394 2K Etch Primer to 1 part 7364 Converter.

Component	Volume
Metacryl 7394 2K Etch Primer	1
Metacryl 7364 Converter	1



POT LIFE

12 Hours at 77°F/24°C / 50% R.H.



APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.4 - 1.6 mm	6 - 10 PSI	*At the cap
High Efficiency	1.4 - 1.6 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 1 – 2 medium wet coats, allow 5-10 minutes flash time between coats.

*Do not use in combination with epoxy primers, as this will result in poor adhesion properties.

*Must seal or prime prior to applying color topcoat.



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

Hand Slick	5 Minutes
Dust Free	10 Minutes
To Nib Sand	30 Minutes per coat
To Topcoat	30 Minutes
Recoat Window	24 Hours



PHYSICAL PROPERTIES

RTS VOC	5.6 lbs/gallon
RTS Volume Solids	12.5%
ZAHN #2 Viscosity	18-20 Seconds
DFT per Coat	Approximately 0.3 mil
Theoretical Coverage	Approx. 200 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

671 grams/liter | 5.6 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

