




Metalux™ 8816 Etch Primer




COMPONENTS
Metalux 8816 2K Etch Primer
8817 2K Etch Primer Activator




APPLICATION
1-2 coats
5-10 minute flash off between coats




MIX RATIO
1 : 1



DRY TIME
To Overcoat – 30 minutes
To Nib Sand – 30 minutes



VISCOSITY
ZAHN #3
10-18 seconds



VOC
252 grams / liter
2.1 lbs / gallon



GENERAL

DESCRIPTION

8816 Etch Primer was designed for use on aluminum, galvanized, and steel surfaces for its anti-corrosive properties. This product is chromate-free and meets the most stringent VOC regulations.

COMPATIBLE SUBSTRATES

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

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



MIXING

COMPONENTS

Mix 1 part Metalux™ 2K Etch Primer to 1 part Metalux 2K Etch Primer Activator. Maximum RFU VOC = 5.5

Component	Volume
Metalux 8816 2K Etch Primer	1
Metalux 8817 2K Etch Primer Activator	1

Package Sizes

- 1 Gallon (3.75 Liters)

INITIAL APPLICATION VISCOSITY

ZAHN #3 Viscosity 10-18 seconds



APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.3 - 1.4 mm	1.0 - 1.5 (Bar)	6 - 8 PSI	*At the cap
High Efficiency	1.3 - 1.4 mm	1.0 - 1.5 (Bar)	17 - 19 PSI	At gauge

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

SURFACE PREPARATION

Degrease then sand with P180 – P320 grit sandpaper. Abrade steel with P80 – P180 grit sandpaper. Dry sand with P360 – P400 grit sandpaper . Existing surfaces (Featheredge) - use P180 – P400 grit sandpaper; Aluminum - use P320 grit sandpaper or finer.

APPLICATION

Apply 1 – 2 single coats with 5 – 10 minute flash off between coats @77°F/25°C.

NOTE: Must be coated with a Primer or Sealer prior to Top Coating.

DO NOT APPLY TOPCOAT DIRECTLY TO ETCH PRIMER.



DRY TIMES

AIR DRY

77°F (25°C)

Hand Slick	5 Minutes
Dust Free	10 Minutes
To Overcoat	30 Minutes
To Nib Sand	30 Minutes
Recoat Window	24 Hours

NOTE: Metalux 8816 2K Etch Primer must be over-coated within 12 hours. After 12 hours, scuff sand prior to applying additional primer.



PHYSICAL PROPERTIES

Recommended Film Thickness	± 18 microns / 0.7 mils per coat
VOC as Applied	2.1 lbs/gallon (RFU)
Mixed Volume Solids	50-55% (Average)
Theoretical Coverage	Approx. 800 SqFt @ 1 Mil DFT/mix gallon
Recommended Coats	2 (x1)
DFT per Coat	Approximately 1.0 mils
ZAHN #3 Viscosity	10-18 Seconds

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	252 grams/liter 2.1 lbs/gallon
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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.

Revised: July 2018

In the United States and Canada:
1.855.6.AXALTA
metalux.us

