



HIGH TECK TECHNICAL DATA SHEETS

7330/7331/7332

2K HIGH SOLIDS DIRECT TO METAL URETHANE PRIMER

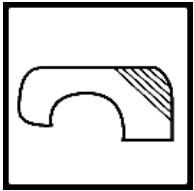
7330 High Solids Direct 2 Metal Urethane Primer is a quality 2K primer with direct to metal capabilities. It may be used as a high solids primer, a primer surfacer or a wet on wet tintable sealer. It is a fast drying, easy sanding primer that quickly fills sand scratches.

DESCRIPTION

7330 – 2K HIGH SOLIDS DIRECT 2 METAL URETHANE PRIMER - GRAY

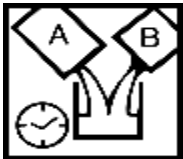
7331 – FAST 2K URETHANE ACTIVATOR

7332 – MEDIUM 2K URETHANE ACTIVATOR



SURFACE PREPARATION

- 1) Thoroughly clean surface using High Teck 7800 Wax and Grease Remover
- 2) Original paint: Wet sand P320 or Dry sand P280
Bare metal: P180
Aluminum, Zinc or Galvanized: sand with P180, apply etch primer
SMC, Fiberglass, Polyester Filler: Dry sand P240
E-Coat: direct application to un-sanded Factory E-coated panels
- 3) Thoroughly clean surface using High Teck 7800 Wax and Grease Remover
- 4) Apply as directed
- 5) Wet sand using P600 or Dry sand using P320 grit sandpaper. Thoroughly clean surface using High Teck 7801V Wax and Grease Remover. Gently wipe surface with a Tack Cloth.
- 6) Apply top coat.



MIXING RATIO (4:1) 10-20%

4 Parts – 7330

1 Parts – 7331, 7332 Super High Build Application

10% Reducer Reduction for Primer Surfacer Application

20% Reducer Reduction for a Wet on Wet Non Sanding Sealer Application

Reduce with High Teck 7710 (Fast), 7720 (Medium), or 7730 (Slow) Reducers

Tintable with up to 10% with urethane mixing base.

Can be applied direct to metal.



APPLICATION

- 1) Apply 2-3 full wet coats of 7330 using a good quality spray gun with a 1.3-2.0mm tip.
- 2) Allow 10-15 minutes flash time between coats.
- 3) Allow 1 Hour @ 68°F (20°C) air dry before sanding.



DRYING TIMES AT 68°F

Flash Time 5-10 Minutes

Allow 1 Hour @ 68° (20C)



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FORCE DRYING AT 140°

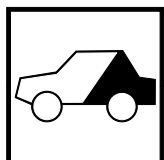
Flash Time 5-10 Minutes

Bake Time @ 140°F 20 Minutes

Or

Flash Time 10-15 Minutes

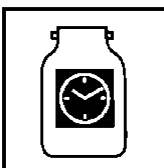
Infra Red Lamp 15 Minutes



RECOATING

7330 may be re-coated after a 30 minute dry time at 68°F.

After 8 hours dry time 7330 must be sanded before top-coating.



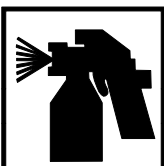
POT LIFE

11/2 Hours @ 68°F (20°C)



FISH EYE

Do not use fish eye eliminator in this product.

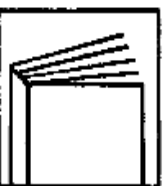


PAINTING FLEXIBLE PARTS

Do not use flexible additives in this product.

EQUIPMENT CLEAN-UP

Clean equipment immediately after use with a gun washing solvent or a high quality lacquer thinner.



TECHNICAL DATA

Gun Set-Up Gravity Feed

(HVLP) 1.3-2.0mm

Air Pressure @ Gun 8-10 psi

Conventional Pressure @ Gun 40-45 psi

V.O.C.

3.43 lbs/gal 4:1 mix

75% Solids by Weight

Coverage Sq. Ft. / gal @ 1 mil

720 sq. ft. 4:1 mix

NOTE: Products are not recommended for use in temperatures below 60° F. Use below these temperatures will effect dry times and performance.

FOR INDUSTRY USE ONLY Read MSDS Before Use

The contents of the package must be blended with other components before the product can be used. Any mixture of components will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions. The material is designed for application only by professionally trained personnel using proper equipment under controlled conditions, and is not intended for sale to the general public

SEE MSDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION

