





# Metacryl 7396 Epoxy Primer



**7396X Epoxy Primer**  
7365 or 7366 Hardener

COMPONENTS




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

APPLICATION




1 : 1

MIX RATIO




Dry to Sand: Overnight  
Dry to Topcoat: 1 Hour per coat

DRY TIME



ZAHN #3  
10 – 15 Seconds

VISCOSITY



4.6 lbs/gal  
551 g/L

VOC



## GENERAL

### DESCRIPTION

Metacryl 7396 Epoxy Primer is a two-component, chromate-free medium fill primer that provides optimum adhesion and excellent corrosion protection to bare metal substrates. This epoxy primer will ensure greater inter-coat adhesion, chemical resistance and color holdout. The 7396 epoxy primers utilize a non-induction catalyst to increase productivity and is available in gray, black, white and red.

### 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 1 part 7396 Epoxy Primer to 1 part 7365 or 7366 Hardener.

Component	Volume
Metacryl 7396 Epoxy Primer	1
Metacryl 7365 or 7366 Hardener	1



**EPOXY PRIMER SELECTION**

- 7396A Epoxy Primer Gray
- 7396B Epoxy Primer Black
- 7396R Epoxy Primer Red
- 7396W Epoxy Primer White

**POT LIFE**

16 Hours at 77°F/24°C / 50% R.H.



**APPLICATION**

**APPLICATION EQUIPMENT**

HVLP Gravity	1.4 – 1.8 mm	6 – 10 PSI	*At the cap
High Efficiency	1.4 – 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 1 - 2 wet coats, allow 5 – 10 minutes flash time between coats.

\*All topcoat colors must be catalyzed.

**DO NOT APPLY OVER 2K ETCH PRIMER.**

**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	Overnight
To Topcoat	1 Hour per coat
Primer Open Time	24 Hours Before Sanding



**PHYSICAL PROPERTIES**

RTS VOC (using 7365)	4.6 lbs/gallon
RTS VOC (using 7366)	3.5 lbs/gallon
RTS Volume Solids	32.9%
ZAHN #3 Viscosity	10 – 15 Seconds
DFT per Coat	Approximately 1.0 mil
Theoretical Coverage	Approx. 529 SqFt at 1 Mil DFT/mixed gallon
ASTM B117 Salt Fog (500 Hours)	MEK pass 100 rubs Xylene pass 1000 rubs
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

551 grams/liter | 4.6 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.

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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**

