



Description

7320-1 2K HI BUILD URETHANE PRIMER SURFACER - GRAY

7324-4 2K PRIMER ACTIVATOR

**Insert
Product
Image Here**

7320 is a medium build production style urethane primer. 7320 offers easy sanding and excellent build for automotive refinish industry.



Surface Preparation

For best results pre clean objects to be painted before sanding. To “pre clean” an object to be painted wash thoroughly with soap and water, then, follow with a Pre-Prep Wax & Grease Remover using clean paper towels.

Steel

1. Clean panel with appropriate surface cleaner based on local regulatory compliance.
2. Final sand with P180 grit or finer.
3. Re-clean panel with appropriate surface cleaner based on local regulatory compliance.
4. Apply appropriate Epoxy Primers prior to application of 7320 on any bare metal substrates.

Aluminum

1. Clean panel with Low VOC Cleaner/Degreaser.
2. Final sand with P180 grit or finer.
3. Re-clean panel with Low VOC Cleaner/Degreaser.
4. Apply appropriate Epoxy Primers prior to application of 7320 on any bare metal substrates.

Fiberglass (Gel coated or SMC surface)

1. Clean panel with appropriate surface cleaner based on local regulatory compliance.
2. Final sand with P180 grit or finer.
3. Re-clean panel with appropriate surface cleaner based on local regulatory compliance.

Body Filler

1. Body filler should be final sanded with P180 grit or finer.
2. Re-clean panel with appropriate surface cleaner based on local regulatory compliance

Existing OEM Finishes

1. Clean panel with appropriate surface cleaner based on local regulatory compliance.
2. Sand the existing OEM finish with P180 grit or finer.
3. Re-clean panel with surface cleaner based on local regulatory compliance.
4. The 7320 application should be kept within the sanded area of the existing finishes.

OEM E-Coat

1. Clean panel with appropriate surface cleaner based on local regulatory compliance.
2. Final sand with P180 grit or finer.
3. Re-clean panel with appropriate surface cleaner based on local regulatory compliance.



Mixing Directions

Mix four (4) parts 7320 2K HI Build Urethane Primer Surfacer - Gray with one (1) part of 7324 2K Primer Activator



Application

Apply 2-3 medium coats. Allow each coat to flash completely dull before applying next coat.

***Tech Tip:** Inadequate flash times may result in product failure including loss of adhesion, shrinkage, sand scratch swelling and pin holing.



Bake Times

Force Drying @ 140°F (60°C)

Purge Time	15 minutes
Bake Time	20 minutes

Infrared Cure

6-8 minutes

NOTE: For detailed curing information refer to equipment manufacturers recommendations.



Dry Times

A properly flashed surface will appear dull and dry to touch. Times are approximate.

Air Dry @ 77°F (25°C)

Flash (after 1st coat)	10-15 minutes or until dull
Flash (after 2nd coat)	15-20 minutes or until dull
To Sand	2-4 Hours
To Topcoat	After sanding within 24 hours*

Tech Tip: Surface must be re-scuffed if sanded primer is not top coated within 24 hours



Pot Life

Pot life is 1-2 hours at 77°F

NOTE: Pot life will shorten as temperatures increase. High Teck™ products are no recommended for use in temperatures below 65°F



Suitable Substrates

- Steel
- Aluminum
- Fiberglass
- Body filler
- OEM E-Coat
- OEM Finishes
- Plastic & flexible substrates



Personal Protection

See Product SDS.



Technical Data

Mixing Ratio: 4:1
 Viscosity (RTS): 18 - 22 seconds #2 Zahn
 Weight Solids (RTS): 54.51% - 58.53%
 Volume Solids (RTS): 34.08% - 37.90%
 Film Build: 1.0 - 1.5 mils per full wet coat
 Coverage: 537 - 571 sq. ft. per gallon @ 1 dry mil

V.O.C. as Delivered:	Regulatory VOC in LBS./GAL.	Regulatory VOC in G./L.	Material VOC in LBS./GAL.	Material VOC in G./L.
7320	4.4	531	4.4	530
7325	4.1	488	4.1	488
7324	6.2	738	6.2	738
V.O.C. (RTS):				
7320/7324	4.8	572	4.8	572
7325/7324	4.5	538	4.5	538

Disposal/Safety: see SDS for this product
 Humidity Resistance: Excellent
 Salt Spray Resistance: Excellent
 Volume Solids (RTS): 34.6%

SEE SDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.

NOTE: High Teck products are not recommended for use in temperatures below 65°F. Using High Teck products below these temperatures will effect dry times and product performance characteristics. Check with all State, local and National rules for compliance before use.