



# AUTOMOTIVE

# TAMCO PAINT

## DIRECT TO ANYTHING EPOXY PRIMER HP661/HP662/HP663

The HP series epoxy primers are **DTA** (Direct to Anything) and provide exceptional chemical adhesion. Unlike many other epoxy primers these are very soft sanding and have outstanding color holdout properties with no shrinkage. It also may be used as a non- sanding primer-sealer and can be re coated without sanding for up to 14 days. This product was not designed for high build but rather to provide a solid maximum-adhesion and corrosion resistance foundation to your paint. It has been developed for strong bonding and coating on substrates that epoxy resin shows poor adhesion.

**DTA** is a high performance epoxy resin, which provides excellent adhesion to a wide range of substrates which includes: Metals, nonferrous metals, chrome, aluminum, steel, plastics , glass, ceramics, wood, fiber glass, and more. **DTA** also has direct to rust additives so you can apply it over surface rust, if need be.

Colors Available:

HP661 - Grey   HP662 - Black   HP663 - White

### Features & Benefits

- Truly direct to anything
- No induction time needed
- Up to 14 days to topcoat without sanding
- Direct to rust
- Excellent wet ability
- Excellent adhesion
- Outstanding leveling
- Good compatibility with polyamide and Hydrocarbon
- Long pot life
- Does not contain vinyl
- Limited to no "orange peel"



### Compatible Surfaces

- Basically anything
- All primers
- Bare metals
- Plastics
- Old finishes

### Required products

- HP 660C Hardener

### Optional

- HR reducers
  - HR1360
  - HR1370
  - HR1380

**Note:** Only use Tamco® reducers.

(See our "What Temperature should I choose PDF" for a guideline on which suits your current job)



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### Applicable Substrates:

- Aluminum
- Titanium
- Stainless steel
- Copper
- Steel
- Magnesium
- Bronze
- Nickel
- Nickel Chrome plating
- Ferrous and nonferrous alloy etc.
- Plastics and rubber
- Glass
- Fiberglass
- ABS
- Over filler sanded with 80 grit or finer
- Rust - Must be 2.5 mil film or higher

*(See our tech sheet on priming over rust)*

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### Surface Preparation:

Metals: Thoroughly cleaned with HR397 wax and grease remover and wipe dry with clean cloth.

Plastics: Clean with HR397 using a Scotch-Brite pad, wipe dry with clean cloth.

Recoat: 1 hour

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### Mix Ratio:



#### Component

#### Volume

HP661/HP662/HP663	Primer	1
HH660C	Activator	1
HR1360/1370/1380	Reducer	up to 5-10% (if needed)

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### Air Pressure & Gun Setups:



#### Gun Setups:

See manufacturers suggestions Common User Suggestions: 1.3-1.5

- 1.3-1.5 mm fluid tip
- 35-40 PSI at the gun
- 8-10 PSI at the gun cap
- 8-10 PSI at the gun cap

*(See your HVLP gun manufacture for specific setups for sealers)*



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### Application:



- **Do not** use any metal prep conditioners, converters or any rust removers under this product. They can cause failure.
  - Clean surface thoroughly using HR397 or HR397W Cleaner.
  - Sand area with 320 grit and re-clean with HR398.
  - Apply 1-2 medium-wet coats of DTA, waiting 20-30 minutes flash time between coats at 78°F.
  - Do not topcoat for at least 12 hours at 78°F.
  - Do not try to sand before 24 hours at 78°F
  - Induction period - not needed.
  - Pot Life: 12-18 hours at 70°F.
  - Do not use if shop temperature is less than 60°F (10°C).
  - Heat up your space & substrates.
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### Drying Times:



Air Dry at 78° 12-24hours.

Do not bake.

Recoat: Can be recoated at any time within 14 days without sanding.

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### Polishing:



N/A

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### Tamco® Tips:



1. In application, apply as a primer sealer. DTA is not a building primer. (Use HP770 series for build).
  2. DTA is very slow curing, allow a day or longer to dry before top coating.
  3. Heavy coats, over applying, or not waiting the proper flash times can cause severe "wrinkling".
  4. If you choose to sand, sand with 320-400 grit sandpaper.
  5. For maximum corrosion resistance, two medium coats should be applied.
  6. Applying over rust, you must have 2.5 mil film or higher.
  7. Heat up your space & substrates for best adhesion capabilities.
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### Equipment Cleaning:

Lacquer Thinner or HR1360 is an excellent cleaner.

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### Cold Shop Conditions:

Do not Spray below 65°F.

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### TECHNICAL DATA & PHYSICAL PROPERTIES

**Test Method:** ASTM D 3359B

**Dry Film Thickness (mil) recommended Mil:** 1.2-2.0

**Colors:** Grey, White, Black

**Mix Ratio:** 1:1

**Viscosity:** (RTS) 18-22 sec. EZ Zahn #2

**Theoretical Dry Film:** 480 ft<sup>2</sup> @ 1 Mil Weight Solids (RTS) 37%

**Color & Gloss holdout:** NA

**Volume Solids:** (RTS) 32%

**Humidity Resistance:** Excellent

**Weight Per Gallon:** White: 10.38lb Black: 9.59lb. Grey: 10.38lb.

**Solvent Resistance:** Excellent

**Florida Exposure:** NA

**Package VOC:** 3.10 # / gal

**RTS VOC:** 4.5# / gal

**Chip Resistance:** Good

**See Safety Data Sheet/Material Safety Data Sheet and Labels for additional safety information and handling instructions.**

**Important:** The contents of this package must be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to direction, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to Tamco Paint Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does Tamco Paint warrant freedom from patent infringement in the use of any formula or process set forth herein.

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