



TAMCO PAINT

AUTOMOTIVE

DIRECT TO METAL PRIMER HP5310/HP5311/HP5312

HP53XX series Premium 2K DTM - high quality, high solids 2K acrylic surfacers with exceptionally high build and direct-to-metal properties. We also incorporate a Direct to Rust additive as well. Apply over surface rust if need be. It is always best to remove rust if possible.

HP5300 has very good vertical stability, efficient application due to excellent build and leveling, and sands easily.

Very soft sanding, wet or dry after short dry times. **HP5300** Primer provides no shrinkage and the maximum in color holdout properties available.

Colors:

Gray - HP 5310 Black - HP5311 White - HP5312



Features & Benefits

- Exceptionally High Build
- Superior Sanding Ability
- Smooth Finish
- Direct to Metal
- Direct to Rust
- Outstanding Leveling
- Excellent Adhesion
- No Shrinkage
- Anti-corrosion

Compatible Surfaces

- Metal
- Aluminum
- Galvanized Steel
- Bare Steel
- Fiberglass
- Plastics
- Wood

Required products

- HH3100 Primer Hardener
- HR Reducers - Urethane Reducer
 - HR1370
 - HR1380
 - HR1390

Optional

- Pot Life Extender 95°F
- HP1001 Accelerator

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

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Surface Preparation: Thoroughly degreased, non-sanded, or lightly sanded substrates. Before sanding clean with HR397 or HR397W Wax & Grease Remover. Use HR397 or HR397W to clean original or old paintwork (except reversible substrates, Examples: lacquer). Properly prepared fiberglass (with no exposed fibers).

Mix Ratio:



Component

Volume

Standard Mix

HP53XX	Primer	4
HH3100	Activator	1
HR1370/1380/1390	Reducer	10-15%



Standard Mix - Sealer (Sandble/Non-Sandable)

HP53XX	Primer	4
HH3100	Activator	1
HR1370/1380/1390	Reducer	2



Mixing with Clear Hardener

HP53XX	Primer	5
HH76XX	Activator	1
HR1370/1380/1390	Reducer	1



Mixing with Clear Hardener - Sealer

HP53XX	Primer	5
HH76XX	Activator	1
HR1370/1380/1390	Reducer	2

Note: Do not use HR1360 (fast temp) in our urethane primers.

Pot Life: Depending on hardener and reduction, approximately 1-2 hours at 78°F, but best sprayed above 70°F.

Additives:



10-15% HR1370/HR1380/HR1390 Reducer may be added to help with flow or reduce viscosity.

HR1360 (Fast) is not recommended in any of our primers, clears or topcoats.

Use only Tamco® HR Reducers series. Our reducers are moisture free less than 150 ppm of water. Other reducers may cause die-back due to water content.

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Air Pressure & Gun Setups:



Gun Setups:

As a Primer:

HVLP

Siphon Feed: 2.2 mm – 2.5 mm

Gravity Feed: 2.2 mm – 2.5 mm

Conventional

Siphon Feed: 2.2 mm – 2.5 mm

Gravity Feed: 2.2 mm – 2.5 mm

As a Sealer:

HVLP

Siphon Feed: 1.8 mm – 2.0 mm

Gravity Feed: 1.8 mm – 2.0 mm

Conventional

Siphon Feed: 1.8 mm – 2.0 mm

Gravity Feed: 1.8 mm – 2.0 mm

30-45 PSI at the gun

8-10 PSI at the cap

Air Pressures Conventional: Always refer to your gun manual for their advice in using our products.

Application:



- Apply 2-3 wet coats of DTM Primer
- Flash Between Coats: 15-20 minutes at 78°F
- Total Recommended Dry Film: 3.0-6.0 mils.
- Tamco® Paint recommends applying our body filler system over DTM primer, not under. (Filler does not have rust inhibitors like our DTM Primer)
- Do not spray under 65°F or if the metal temperatures are cooler than air temperatures. Heat up your space.

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Drying Times:



Airdry:	1-2 hours at 78°F - 85°F Lower temperatures will increase dry time.
Dust Free Tape:	20-25 minutes Tape free - 8 hours Low Bake flash off time
Recoat:	8 hours at 78°F.
Force Dry:	15-20 minutes with 10 min cool down at 140°F metal temperature.
Flash:	Flash before Bake 0-5 minutes temperature.
Bake:	Bake at 140°F.
Recoat:	After 24 hours at 78°F or cool down after baking at 140°F for 30-40 minutes.

Sanding:



After the primer has cured for at least 4 hours dry or wet sanding is acceptable. Adding a small amount of dish soap to the water and soaking the paper will provide best results. If sanding with a DA sander we recommend denibbing first and taking it slow as "pigtails" can be introduced and become difficult to remove in the polishing process.

Recoat: You can apply additional coats of primer after sanding if needed after a minimum of 4 hours at 78°F.

Dry Sanding:

Dry Sanding with random orbital sander and dust extraction
Initial sanding : P320

Final Sanding: P500 - P800

Wet Sanding:

Initial sanding : P320

Final sanding : P600- P800

Tamco® Tips:



1. When air drying, a minimum temperature of 60°F must be maintained.
2. Sanded surface should be re-sanded if not top-coated within 8 hours.
3. When HH76XX Hardeners, extra reducer may be required.
4. When using hardeners, be sure the mixture is stirred thoroughly.
5. Use HR398 after priming.
6. Our reducers are moisture free. less than 150 ppm of water.
7. Other reducers may cause die-back due to water content.
8. Heat up your space & substrates.



DIRECT TO METAL AND DIRECT TO RUST PRIMER

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Equipment Cleaning: Lacquer Thinner or HR1360 is an excellent cleaner.

TECHNICAL DATA & PHYSICAL PROPERTIES

Colors: Grey, Black, White, Clear
Mix Ratio: 4:1
Sprayable Viscosity: (RTS) 21-26 sec. EZ Zahn #2
Dry Film Mil Thickness: 2.0
Theoretical Dry Film: 480 ft² @ 1 Mil Weight Solids (RTS) 53%
Color & Gloss hold out: N/A
Humidity Resistance: Good
Avg Weight Per Gallon: 11.3 lbs.
Solvent Resistance: Good
Repair ability: Excellent
Flash point: 52°F
Volume Solids (RTS): 45%
Florida Exposure: N/A
Package voc: 4.60 # / gal
Chip resistance: Excellent
RTS VOC: 5.0 # / gal

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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