



## DIRECT TO METAL & DIRECT TO RUST PRIMER

### HP5310/HP5311 /HP5312

HP-5300 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. HP-5300 Primer provides no shrinkage and the maximum in color holdout properties available.



Gray - HP 5310

Black - HP5311

White - HP5312

#### Features & Benefits

- Direct to Metal, Rust & Aluminum
- High Build
- Easy sand
- No shrinkage
- Anti-corrosion

#### Compatible Surfaces

- Sanded metal or aluminum
- Galvanized, Plastic, Fiberglass & old sound finishes
- All surfaces EXCEPT stainless steel!

#### Required Products

##### Hardener:

- HH3100 - Primer Hardener
- HR Reducers - Urethane Reducer

##### Optional:

- HH7603 - Fast Temperature
- HH7605 - Medium Temperature
- HH7607 - Slow Temperature
- Pot Life Extender 95°F
- HP1001 Accelerator

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

TAMCO

## HP5310/HP5311 /HP5312

**Surface Preparation:** Thoroughly degreased, non-sanded, or lightly sanded E-coat, before sanding with HR-397 or HR 397W. Use HR-397 or HR397W to clean original or old paintwork (except reversible substrates, Example: lacquer). Properly prepared fiberglass with no exposed fibers. Use ONLY HR-398 after priming.

**Mix Ratio:**



**Standard Mix**

HP53XX : HH3100 : HR Series Reducer  
 4 : 1 : 10-15%



**Mixing with Clear Hardener**

HP53XX : HH76XX Series : HR Reducer  
 5 : 1 : 1

**Standard Mix - Sealer (Sandable/Non Sandable)**

HP53XX : HH3100 : HR Series Reducer  
 4 : 1 : 2

**Mixing with Clear Hardener - Sealer**

HP53XX : HH76XX Series : HR Series Reducer  
 5 : 1 : 2

**Note:** NEVER USE HR1360 (fast temp) in our urethane primers, urethane topcoats or clears!!!



**Pot Life :** Depending on hardener and reduction, approximately 60-120 minutes at 78°F best sprayed above 70°F

**Additives:**



10-15% HR 1370, 1380 or 1390 may be added to help with flow or reduce viscosity.

HR 1360 (Fast) **IS NOT** recommended in any of our primers, clears or topcoats

USE ONLY Tamco HR Reducer series! Our reducers are moisture free less than 150 ppm of water! - other reducers may cause die-back due to water content.

**Air Pressure and Gun Setup:**



See manufacturers suggestions----Common User Suggestions

**HVLP**

**PRIMER:**

HVLP or Conventional  
 Siphon:Feed: 2.0mm-2.5mm  
 Gravity Feed: 1.8 mm – 2.5 mm

**SEALER:**

HVLP or Conventional  
 Siphon:Feed: 1.3mm - 1.4mm  
 Gravity Feed: 1.3mm - 1.4mm

( HVLP 8-10 psi at the gun or follow the guidelines for your particular Gun for very high build primers or non-sanding sealers)

**Conventional**

**PRIMER:**

Siphon Feed: 35-45 psi at the gun  
 Gravity Feed: 30-40 psi at the gun

**SEALER:**

Siphon Feed: 30-45 psi at the gun  
 Gravity Feed: 30-45 psi at the gun

**Application:**



Tamco Paint recommendations for applying their body filler system over primer, not under.

(Filler does not have rust inhibitors like our DTM/DTR Primer)




Thoroughly degrease, non-sanded, or lightly sanded E-coat. before sanding with HR-397 or HR 397W. (Use ONLY HR-398 after priming.) Use HR-397 or HR397W to clean original or old paintwork (except reversible substrates, Example: lacquer). Properly prepared fiberglass with no exposed fibers. Sand with 80-180 grit depending on JOB. Apply 2-3 wet coats of HP-53XX with 15-25 minutes flash between coats at 78°F-85°F. Flash Between Coats: 10-15 minutesWet Sanding: 1 hour LOW BAKE Flash-off time: Drying time at 140°F/ metal temp.:10-15 minutes with 10 min cool-down.

Total Recommended Dry Film: 3.0- 6.0 mils

DO NOT SPRAY UNDER 65°F or if the metal temperatures are colder than air temperatures! Heat up your space!

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Drying Times:		<b>Between Coats:</b>	10-15 mins Wet Sanding: 1 hour
		<b>Dust Free: Tape:</b>	20 minutes Tape free – 8 hours LOW BAKE flash off time:
		<b>Air Dry:</b>	15-25 mins at 78-85°F between coats. Lower temperatures need longer flash times, higher temps are lower flash times. DO NOT apply more primer after 1 hour from completion.
		<b>Force Dry:</b>	10-15 mins with 10 min cool down at 140°F metal temperature



### 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 “pigtailed” can be introduced and become difficult to remove in the polishing process

### Recoat

If you choose to apply additional coats of primer after sanding you can. After a minimum of 4 hours @ 78°F. There is no maximum.



### Tamco Tips:

#### Tips:

1. In order to make sanding easier, apply guide coat before sanding.
2. When air drying, a minimum temperature of 60°F must be maintained
3. Sanded surface should be re-sanded if not top-coated within 8 hours
4. When HH76XX Hardeners, extra reducer may be required.
5. When using hardeners, be sure the mixture is stirred thoroughly.



### Wet Sanding:

#### 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

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### Equipment Cleaning:

Spray guns, gun cups, storage pots, etc., should be cleaned thoroughly after each use with any appropriate general purpose solvent or HR1360 (Fast Temperature) is an excellent cleaner.

### COLD SHOP CONDITIONS

For maximum paint performance, vehicle should be kept above 75°F for 8 hours. Temperatures below 60°F will severely retard dry times and through cure of urethane clear-coats.

### Technical information

#### Physical Properties:

Coating Category: As primer

HP-53XX Primers V.O.C.: 420 g/l (3.50#/gal)

Max: VOC 3.5 lbs/gal

Avg. gallon weight: 11.3 lbs/gal

Avg weight: 66%

Theoretical Coverage: 668.4 sq. ft. @ 1 mil

Theoretical Coverage @ recommended Film Build: 84-223 sq. ft.

Theoretical Coverage: As sealer 750.6 sq. ft. @ 1 mil

Theoretical Coverage @ recommended Film Build : 250-300 sq. ft.

### TECHNICAL DATA & PHYSICAL PROPERTIES

Color:	White, Grey or Black
Sprayable Viscosity (RTS):	24-28 sec.
Pot Life:	1 - 1.5 hours Mix at 78°F Ratio 4:1
Theoretical Dry Film :	466ft <sup>2</sup> @ 1 Mil
Weight Solids:	66%
Humidity Resistance:	Good
Weight Per Gallon:	11.30 lbs. (avg)
Solvent Resistance:	Good, But not solvent resistant when fresh.
Repair Ability :	Excellent Flash point 88°F.

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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