

Direct to Metal Primer 310

Surface Preparation

Wash prime area with mild detergent and water. Clean area with 901 Final Wash. Sand as needed to remove rust or corrosion. Re-clean with 901 Final Wash. With Pre-Painted Surfaces wash areas thoroughly with soap and water. Clean thoroughly with 901 Final Wash. Sand and featheredge area as needed.

Mixing Ratio

Mix the components in the order and ratio indicated

4 : 1

Mix Ratio	High Build	Medium Build	Sealer
Primer (310)	4 Parts	4 Parts	4 Parts
Activator (D311)	1 Part	1 Part	1 Part
Reducer			
161	5-10%	15-20%	N/A
162	5-10%	15-20%	1 Part
163	5-10%	15-20%	1 Part
Mixed VOC	4.4 lb/gal	4.4 lb/gal	4.7 lb/gal

Pot Life

90 Minutes

Recommended Topcoats

Acrylic and polyurethane topcoat. Acrylic basecoat/clearcoat finishes. Acrylic or synthetic enamel finishes.

Gun Set-Up

Use 30 to 45 PSI air pressure at the gun.

Application & Dry Times

Use 30 to 45 PSI air pressure at the gun. Apply even wet coats allowing 15 minutes flash between coats. Finish sand with 320 grit or finer wet or dry paper following paint manufacturers recommendations. Initial sanding can be done with 180-220 grit paper. For large bare metal areas apply a self-etching primer, 320 can be applied directly to clean and dry bare metal cut through areas. Allow 50 minutes or more, depending on the amount of primer applied. Heavy primer coats will lengthen dry time. High build can be accelerated with UA8 Universal Accelerator for quick sanding in cold weather conditions. Using UA8 will reduce pot life.

Clean Up

Clean equipment immediately after use with Excel Urethane Grade reducer or Excel 99/100 Virgin Lacquer Thinner. Do not leave activated material in the spray gun longer than 3 hours.

Safety & Handling

Read all directions and warnings before using this product.

