Zinc Etching Primer is designed for use on bare steel and aluminum where ultimate adhesion and corrosion resistance is desired. This product is free of chromate, lead and isocyanates. It provides excellent filling qualities and quick dry times.

- National Rule Compliant
- Ideal for Direct to Metal (DTM) application
- Exceptional corrosion resistance
- Exceptional adhesion

**COATING TYPE:**
Non-sanding zinc-based etching primer

**PRODUCT CODE:**
SPO-323 Light Green

**ACTIVATOR:**
Not Required

**REDUCERS:**
R-6820 Self Etching Reducer

**PHYSICALS:**
- **Appearance:** Varies with color
- **Weight per Gallon:** 10.59
- **Package Measure:** 1 U.S. gallon / 128 fl. oz. (3.785 liters)
- **Packaged VOC:** 4.05 lbs/gallon (485 g/L)
SURFACE PREP:

For bare metal:
Remove all traces of wax, grease, silicone, oil and other contaminants with detergent wash, followed with a solvent wash (such as Kirker’s 650 Wax & Grease Remover).
Abrade substrate with 180 grit, then re-clean with final wash cleaner (such as Kirker’s 600 Surface Wash).

Be sure to mask all adjacent panels to prevent dry overspray.

MIXING:
Mix ratio: 4:1 by volume. Thoroughly mix four (4) parts SPO-323 Zinc Etching Primer with one (1) part R-6820 Self-Etching Reducer.

Additional reduction may be required to improve sprayability, flow and leveling.

<table>
<thead>
<tr>
<th>ZINC ETCH PRIMER</th>
<th>4oz</th>
<th>12 oz.</th>
<th>20 oz.</th>
<th>28 oz.</th>
</tr>
</thead>
<tbody>
<tr>
<td>SELF-ETCH REDUCER</td>
<td>1 oz.</td>
<td>3 oz.</td>
<td>5 oz.</td>
<td>7 oz.</td>
</tr>
<tr>
<td>TOTAL MIXTURE</td>
<td>5 oz.</td>
<td>15 oz.</td>
<td>25 oz.</td>
<td>35 oz.</td>
</tr>
</tbody>
</table>

Hardener option:
Though not required, an acrylic enamel hardener (such as Kirker’s K-1606 or K-1607) may be added to SPO-323 to speed dry and increase durability. It should be noted that the use of this type of product will result in a slightly higher gloss in the primer’s finished film, and limit it’s recoatability. When using Zinc Etching Primer with an acrylic enamel hardener, primer must be topcoated before four hours. If more than four hours have passed since the application of primer, wait at least 24 hours (at approximately 70° F), then scuff sand to ensure sufficient adhesion. If choosing this option, add up to one pint (16 fl. oz.) of hardener per gallon of primer.

GUN SETTINGS:

<table>
<thead>
<tr>
<th>GUN TYPE</th>
<th>TIP SIZE</th>
<th>AIR PRESSURE</th>
</tr>
</thead>
<tbody>
<tr>
<td>Conventional Siphon Feed:</td>
<td>1.6 mm – 1.8mm</td>
<td>45-55 psi at the gun</td>
</tr>
<tr>
<td>Conventional Gravity Feed:</td>
<td>1.6 mm – 1.8 mm</td>
<td>45-55 psi at the gun</td>
</tr>
<tr>
<td>HVLP</td>
<td>1.4 mm – 1.6 mm</td>
<td>8-10 psi at the tip</td>
</tr>
</tbody>
</table>

Always refer to gun manufacturer’s recommendations for additional details on suggested tip size, air pressure and other adjustments.

APPLICATION:
Apply one (1) medium wet coat.
DRY TIMES / RECOAT:
Allow a minimum of 15 minutes for SPO-323 Zinc Etch Primer to dry before topcoating.

SUPER RUST STOP should dry dust free within 20-30 minutes.

If applying topcoat more than one week after primer application, lightly abrade surface to promote intercoat adhesion. If paper gums, try wet sanding.

Air-dry times may vary slightly depending on shop temperatures, airflow and total film thickness. All dry times listed are approximate, at 70° - 75°F

CLEANUP:
Close all containers tightly after each use. Clean gun and spray equipment with gun wash or other appropriate solvent products immediately after application to prevent damage.

HEALTH / SAFETY PRECAUTIONS:
THIS PRODUCT IS INTENDED FOR USE BY PROFESSIONALS ONLY.

USE THIS PRODUCT ONLY WITH ADEQUATE VENTILATION: Wear appropriate, properly fitted NIOSH/MSHA approved respirator as directed by the manufacturer. Protect hands with impervious rubber gloves. Always wear eye and face protection. Individuals with lung or breathing problems should neither use nor be exposed to this product, its vapors or spray mist. READ ALL WARNINGS ON ALL LABELS BEFORE USING.

This product is designed to be mixed with other components. Mixture will have hazards of both components. Before opening the packages, read all warning labels. Follow all precautions. See Material Safety Data Sheet for additional safety information.

WARRANTY:
All recommendations for the use of Kirker products are based on tests and experience believed to be reliable. Since the methods of use, conditions of application, and the application itself are beyond our control, product warranty is restricted to replacement of material only. No other warranty, written or oral, is expressed or implied.

FOR ADDITIONAL INFORMATION:

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