

ADVANTAGE REFINISH PRODUCTS
TECHNICAL DATA INFORMATION
DATED: JUNE 2014

DESCRIPTION

ADVANTAGE #304 (BUFF) and #312 (GRAY) 2K Urethane Primer Surfacer 4.8 VOC is a top quality product that provides quick and easy sanding, excellent filling properties, fast dry times with exceptional holdout and fast film build, essential to today's advanced finishes.

PRODUCTS

#304-01	2K Urethane Primer Surfacer (BUFF) 4.8 VOC	Gallon
#304-04	2K Urethane Primer Surfacer (BUFF) 4.8 VOC	Quart
#312-01	2K Urethane Primer Surfacer (GRAY) 4.8 VOC	Gallon
#312-04	2K Urethane Primer Surfacer (GRAY) 4.8 VOC	Quart
#305-04	2K Urethane Primer Primer Catalyst 4.8 VOC	Quart
#305-16	2K Urethane Primer Primer Catalyst 4.8 VOC	Half Pint

SURFACE PREPARATION

1. Wash area thoroughly with soap and water to remove contaminants that solvent based cleaners cannot remove effectively.
2. Clean repair area with #191 Waterborne Surfacer Cleaner.
3. Completely sand surface with 180-220 grit paper and re-clean with #191 Waterborne Surface Cleaner.
4. For maximum adhesion and corrosion resistance, treat bare metal with a quality metal conditioning system or primer with Self Etching Primer or #325 DTM – Direct to Metal Primer.

MIXING RATIO

Mix 4 parts #304/#312 Primer to
1 part #305 Primer Catalyst.

APPLICATION DIRECTIONS

Apply 2-3 coats with a 10-15 minute flash between each coat. Use 40-50 psi at the gun or 5-10 psi at the air cap when using an HVLP. Allow #304/ #312 to dry 4-6 hours at 77° F before sanding. We recommend a final blocking with 600 grit or finer paper before topcoating. For maximum performance, seal before topcoating.

Note: Film thickness, flash times, and temperatures may effect sanding times.

DRY TIMES AT 77° F

FLASH	10-15 MINUTES
TO SAND	2-4 HOURS
TO TOPCOAT	2-4 HOURS

FORCE DRYING

PURGE TIME @ 77° F 15 MINUTES

BAKE TIME @ 140° F 20 MINUTES

RECOATING

#304/#312 Primer may be recoated after 30 minutes dry at 77° F or upon cool down after force drying at 140° F for 20 minutes. After 8 hours dry time primer must be sanded before topcoating.

POT LIFE

Pot life will be 1 1/2 - 2 hours at 77°F.

ACCELERATOR

Use up to 1/2 fluid ounce of Accelerator per sprayable quart. The addition of Accelerator will reduce cure times and pot life by 50%. The use of Accelerator will not increase VOC in area where acetone is exempt.

FISH EYE

Do not use fish eye eliminator in this product.

PAINTING FLEXIBLE PARTS

A flexible additive may be needed when painting certain flexible parts.

EQUIPMENT CLEAN-UP

Clean equipment immediately after use with gun wash or a high quality lacquer thinner.

TECHNICAL DATA

Color: BUFF (#304) GRAY (#312)
Mixing Ratio: 4 parts Primer : 1 part Catalyst
Catalyst: (#305)
Induction Period: None
Film Build: 1.0 - 1.5 dry per full wet coat
Coverage: 555 sq. ft.
Dry Times: 2-4 Hours
Pot Life: 1 1/2 - 2 Hours
VOC (RTS): 4.8lbs/gal or less
Disposal/Safety: see MSDS for this product
Lead/Chromate: None
Humidity Resistance: Excellent
Salt Spray Resistance: Excellent
Volume Solids (RTS): 34.6%

NOTE: ADVANTAGE products are not recommended for use in temperatures below 60° F. Use below these temperatures will effect dry times and performance.

FOR INDUSTRY USE ONLY

Read MSDS Before Use

The contents of the package must be blended with other components before the product can be used. Any mixture of components will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions. The material is designed for application only by professionally trained personnel using proper equipment under controlled conditions, and is not intended for sale to the general public.

SEE MSDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.

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