

**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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