

**ADVANTAGE REFINISH PRODUCTS**  
**TECHNICAL DATA INFORMATION**  
**DATED: MAY 2017**

**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 Catalyst 4.8 VOC        | Quart     |
| #305-16 | 2K Urethane 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**

**For Optimal Application Adhere to these Guidelines:**

**Apply no more than 2-3 medium wet coats @ 1.0 - 1.5 mils. dry per full wet coat.** Leave 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                                   |
| <b>Film Build:</b> | <b>1.0 - 1.5 dry per full wet coat</b> |
| 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 SDS 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 SDS 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 SDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.**

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