

ADVANTAGE REFINISH PRODUCTS
TECHNICAL DATA INFORMATION
DATED: JULY 2016

PRODUCT DESCRIPTION:

ADVANTAGE #320 2K Urethane Primer Surfacer 2.1 VOC is formulated for a wide range of applications such as properly prepared bare metal, aluminum, SMC, fiberglass and previously painted surfaces. Provides quick fill, excellent color holdout, ease of sanding and a fast film essential to today's advanced finishes. #320 will provide the high performance you expect from a high build 2K Urethane Primer.

PRODUCTS:

#320-01	2K Urethane Primer Surfacer (GRAY) 2.1 VOC	Gallon
#320-04	2K Urethane Primer Surfacer (GRAY) 2.1 VOC	Quart
#321-04	2K Urethane Primer Catalyst 2.1 VOC	Quart
#321-16	2K Urethane Primer Catalyst 2.1 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 Surface 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 DIRECTIONS:

Mix 4 parts #320 Primer Surfacer to
1 part #321 Primer Catalyst

Note: The addition of any urethane reducers will increase the VOC over 2.1 lbs/gal.

APPLICATION DIRECTIONS:

Apply 2-3 medium wet coats with a 15 minute flash between each coat. Use 40-50 psi at the gun or 8-10 psi at the air cap when using an HVLP. Allow #320 to dry 4-6 hours at 77° F before sanding. **Note:** Film thickness, flash times, and temperatures may effect sanding times.

DRY TIMES AT 77°F:

FLASH	15 min
TO SAND	4-6 HOURS
TO TOPCOAT	4-6 HOURS

FORCE DRYING

PURGE TIME @ 77° F	15 min
BAKE TIME @ 140° F	30 mins

POT LIFE:

Pot life is 1-2 hours at 77°F.

RECOATING:

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

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%.

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.

CLEAN UP:

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

TECHNICAL DATA:

Color:	GRAY
Mixing Ratio:	4 parts Primer Surfacer : 1 part Catalyst
Flex Additive:	4:1:10%
Volume Solids (RTS):	46.8%
Film Build:	1.3 - 1.5 mils per full wet coat
Coverage:	750 sq. ft. RTS gallon @ 1 mil
Dry Times:	4 - 6 Hours
Pot Life:	1 - 2 Hours
V.O.C.	2.1 lbs/gal (using EPA test method 24)
Disposal/Safety:	See SDS for this product
Lead/Chromate:	None
Humidity Resistance:	Excellent
Salt Spray Resistance:	Excellent

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 MSDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.

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