

**ADVANTAGE REFINISH PRODUCTS**  
**TECHNICAL DATA INFORMATION**  
**DATED: SEPTEMBER 2023**

**PRODUCT NUMBER DESCRIPTION**

#325 – HIGH BUILD 2K **DIRECT TO METAL** PRIMER/FILLER/SEALER (GRAY)  
2.1 VOC

**PRODUCT DESCRIPTION:**

ADVANTAGE #325 is formulated with a hybrid of epoxy and acrylic polymers, which provide excellent adhesion, corrosion resistance, productive dry times, and ease of sanding.

**Three products in ONE! High Build Primer, Primer Filler & Primer Sealer.**

**PRODUCTS:**

- |   |           |
|---|-----------|
| • #325-01 High Build 2K DTM Primer/Filler/Sealer (GRAY) 2.1 VOC | Gallon    |
| • #325-04 High Build 2K DTM Primer/Filler/Sealer (GRAY) 2.1 VOC | Quart     |
| • #326-04 High Build 2K DTM Primer Activator 2.1 VOC            | Quart     |
| • #326-16 High Build 2K DTM Primer Activator 2.1 VOC            | Half Pint |

**SURFACE PREPARATION:**

Clean all areas to be primed with compliant Wax & Grease Remover to remove all dirt, wax, grease, and other contaminants. Featheredge and sand the original finish. Surface must be clean and dry.

**Note:** Rust and oxidation must be removed prior to applying primer by sanding, grinding, or sand blasting.

**MIXING DIRECTIONS:**

**HIGH BUILD PRIMER FILLER**

- 4 PARTS #325 DTM Primer
- 1 PART #326 Activator

**REGULAR BUILD PRIMER FILLER**

- 4 PARTS #325 DTM Primer
- 1 PART #326 Activator
- 1 PART Urethane Reducer - Nat'l Rule  
ZERO VOC Reducer for compliancy

**PRIMER SEALER**

- 4 PARTS #325 DTM Primer
- 1 PART #326 Activator
- 2 PARTS Urethane Reducer - Nat'l Rule  
ZERO VOC Reducer for compliancy

**APPLICATION:**

Spray one to three medium wet coats allowing 10-20 minutes flash between coats.

**POT LIFE:**

2-3 hours @ 77° F

**ADDITIVES:**

ACCELERATOR: N/A

FISHEYE: N/A

FLEX ADDITIVE: Not required

**Note:** Do not spray when surface temperature is below 50°F

**CLEAN UP:**

Clean spray equipment immediately after use with Virgin Wash Thinner.

**SUBSTRATES:**

- Properly cleaned and sanded aluminum, steel, galvanized steel or sand blasted steel
- Properly cleaned and sanded fiberglass, SMC, E-Coat and OEM finish.

**GUN SETUPS:****CONVENTIONAL**

Gravity Feed 1.6 mm - 2.0 mm

Siphon Feed 1.8 mm - 2.0 mm

**HVLP** 1.6 mm - 2.0 mm

**AIR PRESSURES****CONVENTIONAL @ Gun PANEL/OVERALL**

Gravity Feed 30-35 psi/40-45 psi

Siphon Feed 30-40 psi/45-55 psi

**HVLP @ Cap** 6-8 psi/8-10 psi

**FLASH/DRY TIMES:**

AIR DRY @ 77°F

Flash between coats 10-20 Minutes

To Sand 60-90 Minutes (Surface prepped in 80 to 120 grit)

\* Once the primer has been sanded, there is no need for another coat of primer prior to topcoating.

To Topcoat 30 Minutes\*

**PLEASE NOTE:** Reduction may accelerate flash times.

\*To Topcoat without sanding - 24 hrs max

\*\* The 24 hour window refers to the amount of time between spraying the primer and topcoating. During this time, it is not mandatory to sand the primer before topcoating. Once the primer sits for longer than 24 hours, it must be sanded for adhesion prior to topcoating.

**TECHNICAL DATA:**

#325 VOC Reg: 204 g/l

#325 VOC Actual: 141 g/l

#326 VOC Reg: 458 g/l

#326 VOC Actual: 271 g/l

VOC Packaged (4:1 Mix) RTS 240 g/l

VOC Spray Applied: 2.1 lbs/gal

VOC Content: 141.0 g/l / 1.18 lb/gl

#325 Primer (Density) 1.66 gm/cc (13.83#/gal)

#326 Activator (Density) 1.02 gm/cc (1.02#/gal)

Pot Life: 2-3 Hours @ 77°F

Disposal/Safety: See SDS for this product

SHELF LIFE: Primers & Activators (3 years sealed & unopened). Do NOT expose to extreme weather – hot/humid/ cold climates or performance could be compromised.

Batch Codes: First digit year produced (Example 6 = 2016), next two digits Month of the year (Example 04 = April)

**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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