



## SPECTRACRON® 315 HIGH BUILD PRIMER SURFACER

### DESCRIPTION:

**SPECTRACRON® 315 High Build Primer Surfacers** is a two-component, 2.1 VOC compliant, high solids, chrome-free, corrosion inhibitive primer. It is specially designed to fill scratches and minor surface imperfections in the substrate which can then be sanded to produce a smooth finish.

### HIGHLIGHTS:

- ❖ Excellent filling properties
- ❖ Easy to sand
- ❖ Low HAPs
- ❖ Contains no heavy metals
- ❖ Capable of 2.8 or 2.1 lbs. /gal. VOC

### TECHNICAL PROPERTIES:

PROPERTY	METHOD	RESULT*
Colors		White (QAP315-WHT)
Gloss Range @ 60° Angle	ASTM D523	Low
Pencil Hardness	ASTM D3363	B - HB
Conical Mandrel (1/8")	ASTM D522	Pass
Adhesion	ASTM 3359	5B, Excellent
Humidity Resistance – 300 Hours	ASTM D2247	No Effect
Water Soak Test – 1000 Hours	ASTM D870	No Effect
Salt Spray Resistance – 250 Hours	ASTM B117	0.5 – 1 mm Scribe Creepage, No blisters
Solvent Resistance (Double Rubs)		100 IPA, 30 MEK (slight transfer with both)
Substrates		CRS, Blasted Steel, Aluminum, Plastics**
Recommended Topcoat(s)		SPECTRACRON 310 & 320

\*These results were obtained over iron phosphated CRS panels.

\*\* Plastic substrates should be properly cleaned & tested for adhesion prior to application.

### PHYSICAL PROPERTIES:

PROPERTY	QAP315-WHT	BLENDED VALUES 6:1:1 w/TFS321-50	BLENDED VALUES 6:1:1 w/TFS309-60
Weight per gallon	12.9 ± 0.2 lbs. / gal.	11.9 ± 0.2 lbs. / gal.	11.7 ± 0.2 lbs. / gal.
Weight Solids (%)	68.0 ± 2.0%	63.0 ± 2.0%	64.0 ± 2.0%
Volume Solids (%)	54.0 ± 2.0%	48.0 ± 2.0%	48.0 ± 2.0%
VOC	1.86 lbs. / gal.	2.0 lbs. / gal.	2.76 lbs. / gal.
% Organic HAPS per gallon (VHAPS)	2.68%	2.18%	4.03%
Coverage (@ 1 mil, no loss)	n/a	738 – 802 sq. ft. / gal.	738 – 802 sq. ft. / gal.
Flash Points:			
SPECTRACRON 315	80°F (27°C)		
SPECTRACRON 3606	124°F (51°C)		
TFS321-50	4°F (-16°C)		
TFS309-60	80°F (27°C)		
Shelf Life - unopened container	2 yrs.	n/a	n/a

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## SURFACE PREPARATION:

The surface must be clean and free of all surface contamination. A chemical pretreatment such as PPG Chemfos® KA Cleaner/Coater or a similar conversion coating will improve the performance properties of the coating system. See your PPG Representative for recommendations.

## APPLICATION DATA:

Mixing Instructions: 6 parts SPECTRACRON 315 (Component A)  
(by volume) 1 part SPECTRACRON 3606 (Q3606; Component B)  
Mix thoroughly

Reducer: 1 part (or 14%) TFS321-50 (SPECTRATHIN® Exempt Reducer) for  $\leq 2.1$  VOC  
or, TFS309-60 (SPECTRATHIN Std. Urethane Reducer) for  $\leq 2.8$  VOC

Viscosity (@77°F): 10 – 18 seconds blended (Zahn #3 EZ Cup)

Wet Film Thickness: 3.0 – 5.0 mils

Dry Film Thickness: 1.5 – 2.5 mils (1.5 mils DFT after sanding is recommended for optimum performance)

Clean up: TFS321-50, Q60 (MEK), Q30 (Acetone) or Q120 (Polypurge)

Pot Life (@77°F): 1 hour (@ 6:1:1) – Pot Life can be extended up to 1.5 hrs. if reduced 6:1:2 (28%) with recommended reducers and/or constant agitation. Pot Life is also dependent upon temperature & humidity.

SPRAY APPLICATION	SPRAY EQUIPMENT	FLUID PRESSURE (psi)	ATOMIZATION PRESSURE (psi)	FLUID NOZZLE	AIR NOZZLE
Conventional	DeVilbiss MBC-510	8 - 10	45 - 55	FF (1.4 mm)	797
Conventional	Binks 2001 or 95	8 - 10	45 - 55	65SS (1.5 mm)	63 PR
HVLP*	DeVilbiss JGHV-531	8 - 10	50 inlet	FF (1.4 mm)	46 MP
HVLP*	Binks - Mach 1 HVLP	8 - 10	50 inlet	95 (1.5 mm)	95 AP

\*HVLP atomization pressure should read <10 psi @ the cap

## CURE SCHEDULES:

<b>Air-dry (@ 77°F &amp; 50% Relative Humidity)</b>	<b>Bake / Force Cure</b>
To Touch: 15 – 20 min.	Flash Time: 20 min. (ambient)
To Handle: 30 – 45 min.	Substrate Temp: 120 – 140°F
To Sand: 90 – 120 min.	Bake Time: 30 – 40 min.

## ADDITIONAL INFORMATION:

- ❖ QAP315-WHT can be sanded by hand or with a dual action sander to obtain a smooth finish using 320-grit sandpaper
- ❖ 2 – 3 applications may be necessary to fill a blasted steel profile
- ❖ Do not apply at temperatures below 50°F
- ❖ Excess film thickness will retard dry times
- ❖ Avoid moisture contamination in Q3606; this can gel the material and affect performance properties

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