

SPECTRACRON®

315 Series

High Build Primer-Surfacer

Product Data Sheet

Spectracron® 315 Series High Build Primer-Surfacers are two-component, 2.1 VOC compliant, high solids, corrosion inhibitive primers. They are specially designed to be used as either a primer/ sealer or as a high build surfacer to fill scratches and imperfections in the substrate which can then be sanded to produce a smooth finish.

Substrates

- Blasted steel¹
- Cold rolled steel
- Aluminum
- Plastics²

Suggested Topcoats

- Spectracron branded epoxy and urethane topcoats

End Use Markets

- Medical device
- Trailer
- Metal fabrication
- Industrial machinery
- Heavy duty equipment
- Agricultural equipment

Product Codes

- QAP315-GRY
- QAP315-WHT

Product Highlights

- Shared catalyst with urethane topcoats
- Easy to sand
- Excellent filling properties
- Very good corrosion resistance
- Strong adhesion to a wide variety of substrates
- Good chemical resistance
- VOC 2.1 lbs. /gal. (252 g/L)
- HAPS 0.47 lbs./gal. (56 g/L)

Physical Properties

| Property | Blended Value |
|---------------------------|---|
| Solids % by weight | 63.0 ± 2.0 |
| Solids % by volume | 50.0 ± 2.0 |
| Weight / Gallon | 11.5 – 12.1 lbs. /gal. (1380 – 1452 g/L) |
| Coverage @ 1 mil, 100% TE | 738 – 802 ft. ² /gal. (69 – 75 m ² /3.785L) |
| 60° Gloss | <10 |
| VOC (less exempts) | 2.1 lbs./gal. (252 g/L) |
| VOC (actual) | 1.4 lbs./gal. (168 g/L) |
| Shelf life | 2 years (each component) |

Performance Properties

| Test | Result* |
|------------------------|-----------|
| Pencil hardness | B – HB |
| Conical mandrel (1/8") | Pass |
| Adhesion | 5B |
| Salt Spray | 250 hours |
| Humidity | 300 hours |

*results obtained over iron phosphate CRS panels



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Substrate Protection

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.

Cure Schedule

Paint film is not fully cured for 7 days. Drying time listed may vary, depending upon film build, color selection, temperature, humidity and degree of air movement.

Physical Properties

Air Dry Times³

| | |
|------------|---------------|
| To Touch | 15 – 20 min. |
| To Handle | 30 – 45 min. |
| To Topcoat | After 1 hour |
| To Sand | 90 – 120 min. |

Force Dry Times

| | |
|---------------------|--------------------|
| Flash Time | 20 min. (ambient) |
| Temperature | Up to 160°F (71°C) |
| Time at Temperature | 20 – 40 min. |

Mix Directions

| | |
|--------------------------|------------------------|
| Blend Ratio ⁴ | 6:1 with Q3606A |
| Pot Life | 1 – 1.5 hours |
| Reduction ⁵ | Q30, Q70 or TFS Blends |
| Line/Flush Clean Up | Q30, Q60, Q120 |

Application

| | |
|----------------------------|------------------------------------|
| Equipment | Conventional, HVLP |
| Recommended Wet Film Build | 3.0 – 5.0 mils 76 – 127 microns |
| Recommended Dry Film Build | 1.5 – 2.5 mils 38 – 64 microns |

Additional Information

| |
|---|
| In-Service Temperature: 250°F (121°C) |
| Do not apply at temperatures below 50°F (10°C) |
| Protect from freezing |
| Can be sanded by hand or with dual action sander to obtain a smooth finish using 320 grit sandpaper |
| Not recommended for use on zinc rich surfaces |

Footnotes

1. In order to fill a blasted steel profile, 2-3 applications may be necessary.
2. Due to the variability in plastic substrates, it's highly recommended to test adhesion on a small sample before application.
3. Excess film thickness will retard dry times and affect the recoat window.
4. No-mixing or improper mixing can result in performance issues and curing issues.
5. Use of a reducing solvent other than Q30 or TFS321-50 will increase VOC above 2.1 lbs./gal.

The technical data presented is information believed by PPG to be currently accurate; however, no guarantee of accuracy, comprehensiveness or performance is given or implied. Continuous improvements in coating technology may cause future technical data to vary from what is in this document. Product is intended for application by trained personnel in a factory or shop application. Do not attempt to use product without the current Safety Data Sheet. The performance of a product can fluctuate due to surface preparation technique, method of application, operating conditions, the material it is applied to or with, and use. It is strongly recommended that products be tested with respect to these factors prior to full scale use.

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