

Cromax™ PS3304 Primer Surfacer



GENERAL

DESCRIPTION

PS-3304 is a National Rule VOC compliant, three-component urethane primer-filler designed for spot, panel and overall repairs. It provides excellent fill capacity (high build) and is easy to apply and sand.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

PS3304 Primer Filler
XK303 Activator, Fast (up to 65°F, 18°C)
XK304 Activator, Standard (75°F, 24°C)
XK306 Activator, Slow (85°F, 29°C)
XK307 Activator, Very Slow (95°F, 35°C)
AZ3375 Reducer

MIX RATIO

Combine the components by volume (4:1:1) or by weight, see table below.
Mix thoroughly.

Component	Volume
PS3304	4
XK30X	1
AZ3375	1

Mix by Cumulative Weight in grams

Mix size in fluid ounces

Component	6 oz	14 oz	28 oz
PS3304	170g	399g	794g
XK30X	201g	469g	940g
AZ3375	226g	525g	1056g

Tips for Success

- Shake the primer on a mechanical shaker for 5 minutes before first usage. To maintain thorough agitation, place primer on a mixing machine.
- Mix accurately using a mixing stick and a cup with straight sides for accurate measurements to ensure you achieve the stated product application and performance. Mix well with all 3 components, for best results.

VISCOCITY

10-13 seconds, Zahn #3 cup.

POT LIFE

- 30 minutes at 70°F (21°C) when using XK303™ and AZ3375™.
- 1 hour at 70°F (21°C) when XK304™ in conjunction with the AZ3375™

TINTING

Not recommended

ADDITIVES

Accelerator:	Not required
Fish Eye Eliminator:	Not required
Reducer:	Not required
Retarder:	Not required
Flex Additive:	Add 2oz. Plas-Stick® 2350S™ Flexible Additive per RTS quart



APPLICATION

SUBSTRATES

Properly treated steel, aluminum and galvanized
Metal Pretreatment Wipes 495™
Properly sanded & prepared OEM finishes and OEM replacement parts
Direct to 420™ Etch Primer
Polyolefin Adhesion Promoter 310A™
Plastic Polyolefin Adhesion Promoter 300™

SEALER

NS33x0™ series sealers
LE30X0S™ series sealers
LE3540S™ series sealers

TOPCOATS

Cromax® XP™ Basecoat
Cromax® EZ™ Basecoat
Cromax® Pro™ Basecoat

Tips for Success

- Apply primer using outside-in technique. Each coat should be “Hand Slick” before applying next coat.
- For best holdout, IR, force dry, or allow primer to dry overnight.

SURFACE PREPARATION

- Clean painted surface thoroughly with mild detergent and water.
- For substrates other than unprimed plastic or fiberglass, wipe surface with Low VOC Cleaner.
- For unprimed plastic and fiberglass, refer to the plastic repair procedure.
- As a primer, sand and featheredge with P180 / P240 / P320, stepping your way up using the stated grit paper.
- Remove sanding sludge with 200™ (Surface Cleaner).

Tips for Success

- When using coarse grit paper, step your way up through P80/P180/P240 grit prior to priming to remove coarse scratches and avoid sand scratch swelling in OEM finishes. Finish sensitive substrates in P320 grit.
- Sand beyond the area to be primed with P320 grit or finer to ensure good adhesion at the thin edge of the primer.

GUN SETUP

HVLP	1.6-1.9 mm fluid tip
ATE, approved transfer efficiency	1.6-1.9 mm fluid tip

SPRAY PRESSURE

HVLP	6-8 psi at the gun cap
ATE, approved transfer efficiency	Follow manufacturer's recommendation

*The listed setups cover the range for standard application equipment.

APPLICATION

Apply 2 to 3 wet coats, allowing the first coat to completely flash using the "outside in" technique. Flash 8-10 minutes between coats,

EQUIPMENT CLEANING

Clean spray equipment as soon as possible using either Axalta 105 or 107 Low VOC/Low HAPS equipment cleaner.



DRY TIMES

AIR DRY

Flash between Coats:	8-10 minutes (75°F / 24°C)
Wet Sanding:	2-3 hours
Dry Sanding:	2-3 hours

FORCE DRY

Flash before Force Dry:	10 minutes
Cycle Time:	30 minutes at 140°F (60°C)
Cool Down:	30 minutes

INFRARED DRY

Refer to the Infrared Guide for setup recommendations.

Tips for Success

- For optimum holdout, air dry overnight or force dry.
- Stated flash times will depend on film build, temperature and humidity.

RECOATIBILITY

When recoating PS3304 Urethane Primer Filler with itself, sanding is required if the primer has been force dried or has been allowed to air dry more than 2 hours.

SANDING

Finish sand with P500 or P600. Refer to the basecoat recommendation.

Tips for Success

For best holdout, 2-3 mils of dry film build should remain on feathered edges after sanding.



PHYSICAL PROPERTIES

All Values Ready To Spray

Theoretical Coverage 645 sq ft. per RTS gallon at 1 mil
Recommended Dry Film Thickness: 6 mils in 3 coats.
Flash Point: See SDS

	Standard Reduction	Flex Reduction (w/ 2350S)
Max. VOC (LE)	4.1 lb/gal (490 g/L)	4.0 lb/gal (483 g/L)
Max. VOC (AP)	3.7 lb/gal (450 g/L)	3.7 lb/gal (446 g/L)
Avg. Gal. Wt.:	10.6 lb/gal (1275 g/L)	10.5 lb/gal (1255 g/L)
Avg. Wt.% Volatiles:	40.9%	41.0%
Avg. Wt.% Exempt Solvent:	5.8%	5.8%
Avg. Wt.% Water:	0%	0%
Avg. Vol.% Exempt Solvent:	8.2%	8.2%
Avg. Vol.% Water:	0%	0%

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS/SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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