Velocity®

VS3X0 2K Urethane Primer Sealer

VS300 White | VS310 Gray | VS320 Dark Gray

Product Data Sheet

PPG VELOCITY® VS3X0 2K Urethane Primer Sealers were developed to improve adhesion and topcoat coverage before applying the basecoat color. Various shades of G1 – G7 gray can be achieved by combining VS300, VS310 and VS320 in different proportions, which may optimize topcoat consumption and the total repair process time. See *Shades of Gray* section for details.

Compatible Products

Apply over:

- Cleaned and abraded OEM paintwork
- Cleaned and primed aluminum, steel and galvanized steel
- Properly cleaned e-coat
- Cleaned and abraded gel-coated fiberglass
- PPG ONECHOICE® Plastic Adhesion Promoter
- VP900 Etch Primer
- VP2X0 2K Urethane Primer Surfacer
- DPLF Epoxy Primer (DP48LF, DP50LF, DP90LF)

Topcoat with:

- VB Basecoat

Substrate Preparation

- **All surfaces to be painted** should be cleaned with car wash soap and water, then apply the appropriate *OneChoice* cleaner. Ensure the substrate is thoroughly cleaned and dried both before and after preparation work.
- **Original paintwork** should be abraded using U.S. 240 / European P280-grade discs (dry) or U.S. 320 / European P360-grade paper (wet). Exposed bare metal should be spot-primed with a suitable bare metal primer such as *Velocity* VP900 Etch Primer or DPLF Epoxy Primer.
- **Electrodeposition primer** must be thoroughly cleaned and abraded as outlined above. When using this primer sealer, abrasion of the electrodeposition primer is optional and not necessary.
- **Aluminum, bare steel and galvanized steel** must be clean, rust free and abraded thoroughly using U.S. 80-180 / European P180-grade paper and primed with *Velocity* VP900 Etch Primer or DPLF Epoxy Primer after abrading.
- **Gel-coated fiberglass and SMC** should be dry abraded using U.S. 240 / European P280-grade paper.
- **Bare plastic** should be abraded with a gray scuff pad (use a finer grade for softer plastics) and primed with *OneChoice* Plastic Adhesion Promoter.

Application Guide

Mix Ratio

VS300/VS310/VS320 Urethane Primer Sealer	4 parts
VH330 Undercoat Hardener	1 part
VR25X Thinner	1 part

Hardeners

VH330 Undercoat Hardener

Thinners

VR251 Fast Thinner	Small repairs 60-80° F (15-26° C)
VR252 Medium Thinner	65-90° F (18-32° C)
VR253 Slow Thinner	77-95° F (25-35° C)
VR254 Very Slow Thinner	Above 90° (35° C)

Application Guide (cont.)

Pot Life

45 minutes at 70° F (21° C)

Spray Gun Setup and Pressure

Fluid tip	1.3 – 1.5 mm
HVLP at the air cap	8 – 10 psi
Compliant at the spray gun	26 – 29 psi

For best overall results, refer to the spray gun manufacturer's recommendations for optimum inlet air pressures.

Application

- 1 medium wet coat if applying over VP2X0 2K Urethane Primer Surfacer
- 2 medium coats if applying over VP900 Etch Primer
- 4 mils per wet coat
- 1 mil suggested dry film build

Drying Times

Dust-free, air dry	10 minutes at 70° F (21° C)
Dry to topcoat, air dry	20 minutes for one coat or 40 minutes for two coats at 70° F (21° C)

Flash Off

Between coats, 5-10 minutes or until fully flashed off at 70° F (21° C)

After 72 hours VS primer sealer must be sanded and reapplied before applying VB basecoat

Topcoating

- For best performance, use VN300 activator in VB basecoat

Shades of Gray

VS300 White, VS310 Gray and VS320 Dark Gray may be blended together to match various G1 – G7 shades of gray. The blends quoted below are percentages by weight.

% by Weight	G1	G3	G5	G6	G7
VS300 White	100	67	–	–	–
VS310 Gray	–	33	100	66	–
VS320 Dark Gray	–	–	–	34	100

Performance Guidelines

- The use of HVLP spray equipment can give an increase in transfer efficiency of around 25% depending upon the make and model of the equipment used.
- Do not attempt spot repair on original or refinish thermoplastic applications, lacquer or 1K finishes.
- Primer surfacer and its ancillaries are sensitive to moisture, so all equipment must be perfectly dry.
- Partially used cans of hardener must be carefully closed. Store all contents in a cool dry place away from heat.

Technical Data

RTS Information	VS3X0 : VH330 : VR25X 4 : 1 : 2
Coating category	Primer Sealer
VOC actual (g/L)	517 – 521 g/L
VOC actual (lbs./U.S. gal.)	4.31 – 4.35 lbs./gal.
VOC regulatory (g/L) (less water less exempt)	517 – 521 g/L
VOC regulatory (lbs./U.S. gal.) (less water less exempt)	4.31 – 4.35 lbs./gal.
Density (g/L)	1203.2 – 1209.2 g/L
Density (lbs./U.S. gal.)	10.04 – 10.09 lbs./gal.
Volatiles weight %	42.9 – 43.1%
Water weight %	0.00%
Exempt weight %	0.00%
Water volume %	0.00%
Exempt volume %	0.00%
Solids volume %	38.80%
Solids weight %	57.00%
Coverage at 1 mil at 100% transfer efficiency (sq. ft.)	558.2 – 623.9 sq. ft.

Velocity® VS3X0 2K Urethane Primer Sealer

VS300 White | VS310 Gray | VS320 Dark Gray

Product Data Sheet

Health and Safety

See Safety Data Sheet and Labels for additional safety information and handling instructions.

- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and SDS of all the components, since the mixture will have the hazards of all its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company policy, product SDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Store waterborne and solventborne waste separately. A competent agent with appropriate certification must handle all hazardous wastes. Wastes must be disposed in accordance with all federal, state, provincial and local laws and regulations.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- Always observe all applicable precautions and follow good safety and hygiene practices.

Emergency Medical or Spill Control Information: (412) 434-4515

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, result, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

PPG Automotive Refinish • 19699 Progress Drive, Strongsville, OH 44149 • 1.800.647.6050 • ppg.com/refinish

We protect and beautify the world®