



MASTERTINT® 304s,305s,306s VINYL COLOR SYSTEM



GENERAL

DESCRIPTION

A 7.0 lb. /gal (840 g/l) VOC compliant, RTS, flexible coating designed for interior and exterior vinyl, plastic and trim applications, and may also be used as a striping paint. It is fast drying and offers low, medium and high gloss levels.

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



MIXING

COMPONENTS

MasterTint® Mixing Colors- "J" Quality
Axalta VS® 5000 Mixing Colors- "NIK" Quality
304S™ Low Gloss Vinyl Additive (1-10 units gloss reading using a 60 degree meter)
305S™ Medium Gloss Additive (10-20 units gloss reading using a 60 degree meter)
306S™ High Gloss Additive (20-30 units gloss reading using a 60 degree meter)

MIX RATIO

MasterTint® 304s/305s/306s Vinyl Color is ready-to-spray. No reduction is necessary.

VISCOSITY

18-22 seconds in a Zahn #2 cup.

ADDITIVES

Accelerator:	Not Recommended
Fish Eye Eliminator:	Not Recommended
Flex Additive:	Not Recommended
Reducer:	5-10% as necessary with lacquer thinner

Tips for Success

- Thinner may also be necessary in a blending procedure.
- Additional thinning may adversely affect hiding ability.

TINTING

MasterTint® & Axalta VS Series Toners Vinyl color may be tinted up to 5% with MasterTint® & Axalta VS Series tints.



APPLICATION

SUBSTRATES

Properly prepared plastics
Flexible vinyl interior parts and vinyl roofs
Axalta 320 Black or 330 Gray Flexible Adhesion Surfacers

SURFACE PREPARATION

- For flexible vinyl interior parts and vinyl roofs, clean with hot soapy water and rinse. Follow with a final cleaning using Axalta 220™ Low VOC Cleaner.
- For other types of plastic, follow specific procedures outlined in Plastics Refinishing Guide.



Tips for Success

- Extreme caution should be used when cleaning flexible vinyl. Harsh solvent products can soften the vinyl, preventing the MasterTint® Vinyl Color System from properly drying and/or adhering.
- Do not use MasterTint® Vinyl Color System on carpet, leather, other natural fiber substrates or convertible tops. Severe damage could result.

GUN SETUPS

HVLP:	1.4 mm-1.5 mm
Compliant:	1.4 mm-1.6 mm

AIR PRESSURE

HVLP	6-8 psi at the gun cap
Compliant:	25-30 psi at the gun

Refer to the manufacturer's directions for gun specific recommendations.

APPLICATION

Apply 2-4 coats until hiding and color match are achieved. Flash 5 minutes between coats.

CLEANUP

Clean spray equipment as soon as possible with lacquer thinner.



DRY TIMES

Dry Time:	30 minutes
Force Dry:	Not Recommended



PHYSICAL PROPERTIES

All Values Ready To Spray

	304S™	305S™	306S™
Max. VOC (LE):	709 g/L (5.9 lbs./gal)	723 g/L (6.0 lbs./gal)	728 g/L (6.1 lbs./gal)
Max. VOC (AP):	481 g/L (4.0 lbs./gal)	487 g/L (4.1 lbs./gal)	490 g/L (4.1 lbs./gal)
Avg. Gal. Wt.:	866 g/L (7.23 lbs./gal)	854 g/L (7.13 lbs./gal)	850 g/L (7.09 lbs./gal)
Avg. Wt.% Volatiles:	85.1%	87.3%	88.3%
Avg. Wt.% Exempt Solvent:	29.5%	30.2%	30.6%
Avg. Wt.% Water:	0.0%	0.0%	0.0%
Avg. Vol.% Exempt Solvent:	32.1%	32.5%	32.7%
Avg. Vol.% Water:	0.0%	0.0%	0.0%
Theoretical Coverage:	238 ft ² (22.1 m ²) (silver) per RTS gal. at 1 mil. 267 ft ² (24.8 m ²) (white) per RTS gal. at 1 mil.		
Recommended Dry Film Thickness:	1.5-2.0 mils in 2-4 coats		
Flash Point:	See MSDS/SDS		

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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