valspar
REFINISH

829 Series HS
Low VOC 2K Polyurethane

GENERAL INFORMATION
A Low-VOC 2K (two-component) polyurethane topcoat designed to meet stringent air-quality requirements, allow for ease of application and provide a long-lasting protective finish in fleet and OE refinishing/finishing applications.

1. COMPONENTS

• 829 Series	Mixed Color
• HPC0	Activator Slow
• HPC1	Activator Medium
• HPC2	Activator Fast
• HPC3	Activator Very Fast
• 171	Reducer Fast
• 172	Reducer Medium
• 173	Reducer Slow
• 174	Reducer Very Slow
• 171HP	Reducer High Performance Fast
• 172HP	Reducer High Performance Medium
• 173HP	Reducer High Performance Slow
• 174HP	Reducer High Performance Very Slow
• X01	Reducer Fast Low VOC
• X02	Reducer Medium Low VOC
• LVBF100	Reducer Fast Low VOC
• LVBM100	Reducer Medium Low VOC
• LVBS100	Reducer Slow Low VOC

2. MIXING RATIO (3:1:0-10%)
• Mix three (3) parts 829 2K HS Color with one (1) part HPC Series Activators and reduce with up to 10% with solvents or reducers listed above

USA VOC compliant rules:
• For VOC 3.5 compliant use 170 or 170HP Series Reducers
• For VOC 2.8 compliant use Low VOC Reducers: X01, X02 or LVB100 Series Reducers

3. POT LIFE @ 77°F (25°C)
• 4 hours

4. CLEAN UP
• Use Valspar Refinish Reducers listed above (check local regulations)

5. ADDITIVES
• ACCELERATOR: N/A
• FISHEYE: N/A
• FLEX ADDITIVE: N/A

6. SURFACE PREPARATION
USE RECOMMENDED UNDERCOAT SYSTEM FOLLOWING RECOMMENDED PROCEDURES
• Finish sand with P320-P500 grit wet or dry sandpaper or equivalent
• Mask all adjacent areas to prevent over spray problems

7. TOPCOATS
For National Rule Compliance:
• AC4400 Clear Coat

For Low VOC 2.1 Compliance:
• AC2100 Clear Coat

8. TECH NOTES
• N/A

9. SUBSTRATES
• All Valspar 2K Primer/Sealers
• Properly Prepared OEM Finish

10. APPLICATION
Cross Coat Technique:
• Spray a fast tack coat on panel using a top to bottom stroke
• Follow with medium wet coat using a side to side stroke
NOTE: Do not spray when surface temperature is below 50°F (10°C)

11. FLASH / DRY TIMES
AIR DRY @ 77°F (25°C)

Flash between coats	Up to 15 Minutes.
To Tape	6 Hours
To Deliver	8 Hours

FORCE DRY

Flash before Force Dry	20 Minutes
Force Dry Time	40 Minutes @ 140°F (60°C)
Sand and Buff	After Cool Down (1-2 Hours)

12. INFRARED CURE
• **See Infrared Curing Information**

13. GUN SET UP

CONVENTIONAL GUN	
Gravity Feed	1.5 mm - 1.8 mm
Siphon Feed	1.6 mm - 1.8 mm
HVLP	
Gravity Feed	1.3 mm - 1.5 mm

AIR PRESSURES

Conventional @ Gun	**PANEL**
Gravity Feed	30-35 psi (2.0-2.5 bar)
Siphon Feed	35-45 psi (2.5-3.1 bar)
HVLP Inlet Air	30 psi (2.0 bar)
See spray gun manufacturer info	

14. PHYSICAL DATA
SEE PAGE 2

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14. PHYSICAL DATA (Continued)

FOR USA/Canada (3.5/2.8 LBS./GAL Compliance)

RTS REGULATORY DATA	3:1:0-10% (170 or 170HP Series Reducers)		3:1:0-10% (X01, X02 or LVB100 Series Reducers)	
	LBS./ GAL.	g/L	LBS./ GAL.	g/L
Actual VOC	3.3 Max.	400 Max.	2.6 Max.	306 Max.
Regulatory VOC (less water and exempt solvents)	3.5 Max.	420 Max.	2.8 Max.	340 Max.
Density	8 - 11	960 - 1320	8 - 11	960 - 1320
	WT.%	VOL.%	WT.%	VOL. %
Total Solids Content	50 - 70	40 - 60	30 - 60	30 - 70
Total Volatile Content	30 - 50	40 - 60	40 - 70	30 - 70
Water	0	0	0	0
Exempt Compound Content	5 - 15	5 - 15	10 - 25	10 - 25
Coating Category	Single-Stage			

NOTE: US/Canadian Regulations allow for the use of exempt compounds for VOC calculations.

FOR REST-OF-WORLD (outside US and Canada):

RTS REGULATORY DATA	3:1:0-10% (170 or 170HP Series Reducers)	
	LBS./GAL.	g/L
VOC	4.2 Max.	500 Max.
Density	8 - 11	960 - 1320
	WT.%	VOL.%
Total Solids Content	50 - 70	40 - 60
Total Volatile Content	30 - 50	40 - 60
Water	0	0
Coating Category	Single-Stage	

NOTES