



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

If used as instructed, this product is designed to comply with VOC standards in low-VOC jurisdictions. Confirm compliance with state and local air quality rules before use. The data on this sheet represent typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Valspar assumes no obligation or liability for use of this information. **UNLESS VALSPAR AGREES OTHERWISE IN WRITING, VALSPAR MAKES NO WARRANTIES, EXPRESS OR IMPLIED, AND DISCLAIMS ALL IMPLIED WARRANTIES INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE OR FREEDOM FROM PATENT INFRINGEMENT. VALSPAR WILL NOT BE LIABLE FOR ANY SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES.** Your only remedy for any defect in this product is the replacement of the defective product, or a refund of its purchase price, at our option.



14. PHYSICAL DATA (Continued)
FOR USA/Canada (3.5/2.8 LBS./GAL Compliance)

NOTES

RTS REGULATORY DATA	3:1:0-10%		3:1:0-10%	
	(170 or 170HP Series Reducers)		(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	

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