



## GENERAL INFORMATION

AC4400 is a versatile Polyurethane Clearcoat which exhibits ease of application, high durability, and the ultimate in gloss and depth. AC4400 may be mixed as either a spot/panel or overall clear depending upon activator and reducer selection.



## 1. COMPONENTS

- AC4400 Clearcoat
- HPC0 Slow Activator
- HPC1 Medium Activator
- HPC2 Fast Activator
- HPC3 Warp Speed Activator
- X01/X02 Fast/Medium Uni-Solvent LV
- 171 Fast Uni-Solvent up to 75°F (24°C)
- 172 Medium Uni-Solvent 75°-85°F (24°-29°C)
- 173 Slow Uni-Solvent 85°-95°F (29°-35°C)
- 174 Very Slow Uni-Solvent 95°F (35°C) and over
- 171HP High Performance Reducer Fast
- 172HP High Performance Reducer Medium
- 173HP High Performance Reducer Slow
- 174HP High Performance Reducer Very Slow
- BZ1 Universal Blending Solvent (for more information see technical data sheet)



## 2. MIXING RATIO

**Note:** Activator and Uni-Solvent selections should be based on the size of the area to be painted, air movement, and temperature. For larger areas and/or high temperatures, HPC0 or HPC1 should be used. For panel and multi-panel refinishing, HPC2 should be used. HPC3 should only be used for small areas.

Mix two (2) parts AC4400 Clear with one (1) part HPC0/1/2/3 Activator and reduce with one (1) part solvents or reducers listed above.

### USA VOC compliant rules:

For VOC 3.5 compliant use Uni-Solvent LV X01 or X02.  
For VOC national rule use solvents or reducers listed above.



## 3. ADDITIVES

ACCELERATOR: T566 (max 1%).  
FISHEYE: T152 Fisheye Eliminator (max 1%).  
FLEX ADDITIVE: N/A

**Note:** Do not spray when surface temperature is below 50°F (10°C).



## 4. POT LIFE @ 77°F (25°C)

HPC0 Activated - 4 Hours  
HPC1 Activated - 3 Hours  
HPC2 Activated - 1 Hour  
HPC3 Activated - 1 Hour



## 5. CLEAN UP

Valspar Uni-Solvent 171-174 and X01, X02 (check local regulations).



## 6. SURFACE PREPARATION

FOR APPLICATION OVER RECOMMENDED BASECOAT SYSTEM.

- Mask all adjacent areas to prevent over spray problems.
- Allow basecoats sufficient dry times.
- Over OEM finish using gray scuff pad r P800 grit sandpaper.



## 7. SUBSTRATES

- 333 Series
- 840 Series
- 999 Series
- Properly sanded and cleaned OEM finish



## 8. APPLICATION

Spray two wet coats allowing 10-20 minutes flash time between coats. Flash times will be dependent on temperature, air flow, activator selection, and reducer selection.



## 9. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

|                     | HPC0       | HPC1       | HPC2       | HPC3      |
|---------------------|------------|------------|------------|-----------|
| Flash between coats | 15-20 min. | 10-20 min. | 10-15 min. | 5-10 min. |
| Dust Free           | 25-30 min. | 15-20 min. | 10-15 min. | 5-10 min. |
| Sand and Buff       | Overnight  | Overnight  | 4-6 Hours  | 2-3 Hours |

### FORCE DRY

|                        | HPC0         | HPC1         | HPC2         | HPC3         |
|------------------------|--------------|--------------|--------------|--------------|
| Flash before Force Dry | 0 min.       | 0 min.       | 0 min.       | 0 min.       |
| Force Dry Temp.        | 145°F (63°C) | 145°F (63°C) | 145°F (63°C) | 145°F (73°C) |
| Force Dry Time         | 30 min.      | 30 min.      | 20 min.      | 20 min.      |



## 10. INFRARED CURE

See Infrared Curing Information.



## 11. GUN SET UP

### CONVENTIONAL GUN

Gravity Feed 1.4 mm - 1.6 mm

Siphon Feed 1.6 mm - 1.8 mm



### HVLP

Gravity Feed 1.3 mm - 1.5 mm

### AIR PRESSURES

#### Conventional @ Gun

Gravity Feed 35-40 psi (2.5-2.8 bar)

Siphon Feed 35-45 psi (2.5-3.1 bar)

HVLP Inlet Air 30 psi (2.0 bar)

See spray gun manufacturer info



## 12. PHYSICAL DATA

|                          |                                      |
|--------------------------|--------------------------------------|
| VOC (Packaged)           | 3.5 or 4.4 lbs./gal. (RTS)           |
| Volume Solids            | 38.4% Average                        |
| Theoretical Coverage     | 616 sq. ft. per mil/25 µm per gallon |
| Recommended DFT          | 2-4 mils (50-100 µm).                |
| Zahn #2 Viscosity (RTS)  | 19 - 21 Seconds                      |
| Din #4mm Viscosity (RTS) | 15 - 17 Seconds                      |