



GENERAL INFORMATION

A Low VOC medium-solids (MS), 2K (two-component) polyurethane clearcoat formulated to offer ease of application, very good flow and leveling, excellent durability, very good gloss and good distinctness of image.



1. COMPONENTS

- AC2100 Low VOC MS Clearcoat
- HPC0 Activator Slow
- HPC1 Activator Standard
- HPC2 Activator Fast
- HPC3 Activator Very Fast



2. MIXING RATIO (4:1 by volume)

- Mix four (4) parts AC2100 with one (1) part HPC Activators

For USA/Canada VOC compliant rules:

- For 2.1 VOC compliance use components listed above



3. POT LIFE @ 77°F (25°C)

- When properly covered at 77°F (25°C), AC2100 will maintain a sprayable viscosity for at least from 3-4 hours depending on activator selection



4. CLEAN UP

- Use Valspar Refinish exempt reducers (check local regulations)



5. ADDITIVES

- N/A



6. SURFACE PREPARATION

FOR APPLICATION OVER RECOMMENDED BASECOAT SYSTEM

- Allow basecoats sufficient dry times
- Over OEM finish sand finish dull with P800 or gray scuff pad



7. TOPCOATS

- N/A



8. TECH NOTES

- N/A



9. SUBSTRATES

- 333 Series Basecoat
- 999 Series Basecoat
- 840 2K Polyurethane Basecoat
- 829 HS Basecoat
- LVBR100 Series
- Properly cleaned and sanded OEM finishes



10. APPLICATION

- Spray two (2) to three (3) medium-wet to wet coats, overlap 75%
- Allow each coat to become not stringing before applying the next coat

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	Not Stringing
Dust Free	20-25 Minutes

Sand and Buff

HPC0 Activated	HPC1 Activated	HPC2 Activated	HPC3 Activated
Overnight	Overnight	4 - 6 Hours	2 - 4 Hours

FORCE DRY with HPC0 and HPC1 Activator

Flash before Force Dry	20 Minutes
Force Dry Time	45 Minutes @ 130°F (54°C)
Sand and Buff	After Cool Down

FORCE DRY with HPC2 and HPC3 Activator

Flash before Force Dry	0 Minutes
Force Dry Time	15-20 Minutes @ 165°F (74°C)



12. INFRARED CURE

- See Infrared Curing Information



13. GUN SET UP



CONVENTIONAL GUN	
Gravity Feed	1.3 mm - 1.5 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	



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 (2.1 LBS./GAL Compliance):

RTS REGULATORY DATA	4:1	
	(No Reduction)	
	LBS./GAL.	g/L
Actual VOC	1.15 Max.	138 Max.
Regulatory VOC (less water and exempt solvents)	2.1 Max.	250 Max.
Density	8 - 10	960 - 1200
	WT. %	VOL. %
Total Solids Content	32 - 35	32 - 35
Total Volatile Content	65 - 68	65 - 68
Water	0	0
Exempt Compound Content	45 - 55	45 - 55
Coating Category	Clearcoat	

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:	4:1	
	(No Reduction)	
	LBS./GAL	g/L
VOC	6.5 Max	780 Max
Density	8 -10	960 - 1200
	WT%	VOL%
Total Solids Content	32 - 35	32 - 35
Total Volatile Content	65 - 68	65 - 68
Water	0	0
Coating Category	Clearcoat	

NOTES

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