



## 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<br>(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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