



GENERAL INFORMATION

A high-solid (HS), single-stage acrylic urethane enamel that provides high performance for shops specializing in overall repaints and fleet applications. Apply with HPC activators to achieve enhanced urethane properties, increased durability and superior application control.



1. COMPONENTS

- 327 Series Color
- HPC1 Activator Medium
- 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



2. MIXING RATIO (8:1:10%)

For USA 5.0 lbs/gal (600 g/L) VOC compliant rules (National Rule Only):

- Reduce 10% with 170 or 170HP Series Reducers listed above
- For best performance, activate eight (8) parts 327 Color with one (1) part HPC1 Activator Medium prior to reduction

NOTE: Choose reducer based on temperature and size of part to be finished



3. POT LIFE @ 77°F (25°C)

- Indefinite without activator
- Four (4) Hours with activator



4. CLEAN UP

- Use Valspar Refinish Reducers listed above (check local regulations)



5. ADDITIVES

- FISHEYE: T152 max. 1%
- FLEX ADDITIVE: N/A

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



6. SURFACE PREPARATION

USE RECOMMENDED UNDERCOAT SYSTEM FOLLOWING RECOMMENDED PROCEDURES

- Finish sand with P320-P500 grit dry sandpaper or wet equivalent
- Mask all adjacent areas to prevent over spray problems



7. TOPCOATS

- N/A



8. TECH NOTES

- N/A



9. SUBSTRATES

- All Valspar 2K Primer/ Sealers
- Properly Prepared OEM Finish



10. APPLICATION

- Spray two (2) to three (3) medium wet coats allowing 20 minutes flash between coats



11. FLASH / DRY TIMES

AIR DRY @ 77°F (25°F)

Flash between coats	20 Minutes
Tape Time without Activator	Overnight
Tape Time with Activator	Overnight
To Deliver	Next Day

FORCE DRY

Flash before Force Dry	20 Minutes
Force Dry Time	30 Minutes @ 130°F (54°C)
To Tape after Cool Down	1 - 2 Hours
To Topcoat after Cool Down	1 - 2 Hours



12. INFRARED CURE

- N/A



13. GUN SET UP



CONVENTIONAL GUN	
Gravity Feed	1.4 mm - 1.8 mm
Suction 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)
Suction 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 the US National Volatile Organic Compound (VOC) Emission Standard for Automobile Refinish Coatings. 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 (5.0 LBS./GAL Compliance National Rule)

NOTES

RTS REGULATORY DATA:	10% Reduction		8:1:10%	
	(170 or 170HP Series Reducers)		(170 or 170HP Series Reducers)	
	LBS./GAL	g/L	LBS./GAL	g/L
Actual VOC	5.0 Max.	600 Max.	5.0 Max	600 Max
Regulatory VOC (less water and exempt solvents)	5.0 Max.	600 Max.	5.0 Max	600 Max
Density	8 - 10	960 - 1200	8 - 10	960 - 1200
	WT.%	VOL. %	WT.%	VOL. %
Total Solids Content	35 - 55	30 - 40	35 - 55	30 - 40
Total Volatile Content	45 - 65	60 - 70	45 - 65	60 - 70
Water	0	0	0	0
Exempt Compound Content	0 - 5	0 - 5	0 - 5	0 - 5
Coating Category	Single-Stage			

NOTE: Values reflect use with and without optional additives. US Regulations allow for the use of exempt compounds for VOC calculations.

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

RTS REGULATORY DATA:	10% Reduction		8:1:10%	
	(170 or 170HP Series Reducers)		(170 or 170HP Series Reducers)	
	LBS./GAL	g/L	LBS./GAL	g/L
VOC	6.5 Max.	780 Max.	6.5 Max	780 Max
Density	8 - 10	960 - 1200	8 - 10	960 - 1200
	WT.%	VOL. %	WT.%	VOL. %
Total Solids Content	35 - 55	30 - 40	35 - 55	30 - 40
Total Volatile Content	45 - 65	60 - 70	45 - 65	60 - 70
Water	0	0	0	0
Coating Category	Single-Stage			

NOTE: Values reflect use with and without optional additives.

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