



## GENERAL INFORMATION

860 2K is a two-component polyurethane topcoat formulated to provide the ultimate in performance, gloss and color retention, durability, and superior productivity characteristics.



## 1. COMPONENTS

- 860 Series Mixed Color
- HPC0 Slow Activator
- HPC1 Standard Activator
- HPC2 Fast Activator
- HPC3 Very Fast Activator
- 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 above
- 171HP High Performance Reducer Fast
- 172HP High Performance Reducer Medium
- 173HP High Performance Reducer Slow
- 174HP High Performance Reducer Very Slow



## 2. MIXING RATIO - 4:1:1

Mix four (4) parts 860 Series color to one (1) part Activator HPC0, HPC1, HPC2, or HPC3 and reduce with one (1) part solvents or reducers listed above (4:1:1 by volume).



## 3. POT LIFE @ 77°F (25°C)

	HPC0	HPC1	HPC2	HPC3
Pot Life (Activated)	4 Hours	3 Hours	1 Hour	1 Hour



## 4. CLEAN UP

Uni-Solvent 171-174 or Uni-Solvent LV X01, X02 (check local regulations).



## 5. SURFACE PREPARATION

USE RECOMMENDED UNDERCOAT SYSTEM FOLLOWING RECOMMENDED PROCEDURES.

- Finish sand with P320-P500 grit dry sandpaper or equivalent.
- Mask all adjacent areas to prevent over spray problems.
- Clean surface with Aqua Clean 170 prior to spraying.



## 6. SUBSTRATES

- Properly prepared previously painted surfaces
- Valspar 2K primers and sealers
- **NOTE:** do not apply over Self Etching Primers



## 7. APPLICATION

- Spray two to three medium wet coats or until hiding is achieved.
- Allow 10-20 minutes between coats.



## 8. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Flash Time	10-20 Minutes
To Tape	4 Hours



## 9. INFRARED CURE

See Infrared Curing Information section.



## 10. GUN SET UP

### CONVENTIONAL GUN

Gravity Feed 1.4 mm - 1.5 mm  
Suction Feed 1.4 mm - 1.5 mm



### HVLP

Gravity Feed 1.3 mm - 1.5 mm

### AIR PRESSURES

#### Conventional @ Gun

Gravity Feed 30-35 psi (2.0-2.5 bar)  
Siphon Feed 35-40 psi (2.5-3.0 bar)

#### HVLP Inlet Air

30 psi (2.0 bar)  
See spray gun manufacturer info



## 11. PHYSICAL DATA

### Reduced with Uni-Solvent 171-174

	860 Series
VOC (As Packaged)	4.5 lbs./gal.
VOC (Ready to Spray)	4.74 lbs./gal.
Total Solids by Weight (RTS)	40.7%
Total Solids by Volume (RTS)	34%
Sq. Ft. Coverage/US Gal. (RTS)	546
Flash Point (RFS)	45°F / 7°C
Total HAPS (lb HAPS/gal solid)	3.79

### Reduced with Uni-Solvent LV X01 or X02

	860 Series
VOC (Ready to Spray)	4.23 lbs./gal.
Flash Point (RFS)	-4°F / -20°C
Total HAPS (lb HAPS/gal solid)	1.86
Zahn #2 Viscosity (RTS)	20 - 22 Seconds
Din #4mm Viscosity (RTS)	16 - 18 Seconds
Recommended DFT	1 - 3 mils (25 - 75 µm)