



GENERAL INFORMATION

HS35 Multi-Use 2K urethane surfacer/sealer is a High Solids surfacer formulated to provide the ultimate in performance, productivity, versatility, adhesion, durability, and superior sanding and sealing characteristics.



1. COMPONENTS

- HS35 2K Multi-Use Surfacer/Sealer
- 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
- X01 Fast Uni-Solvent LV
- X02 Medium Uni-Solvent LV
- HPC0 Slow Activator
- HPC1 Standard Activator
- HPC2 Fast Activator
- HPC3 Very Fast Activator
- T566 Accelerator



2. MIXING RATIO

RFU as Surfacer - 4:1:1

- Mix four (4) parts HS35 to one (1) part HPC0, HPC1, HPC2, or HPC3 Activator and reduce with one (1) part solvents or reducers listed above. (4:1:1 by volume)

RFU as Sealer - 4:1:2

- Mix four (4) parts HS35 to one (1) part HPC0, HPC1, HPC2, or HPC3 Activator and reduce with one (2) parts solvents or reducers listed above. (4:1:2 by volume)

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. POT LIFE @ 77°F (25°C)

	HPC0	HPC1	HPC2	HPC3
As Surfacer	40 min.	40 min.	30 min.	20 min.
As Sealer	45 min.	45 min.	35 min.	25 min.



4. CLEAN UP

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



5. SURFACE PREPARATION

- Surfaces should be prepared using the proper undercoat system following recommended procedures.
- Sanding grits coarser than 220P grit should be finish sanded with finer grit prior to application.
- Clean surface with Aqua Clean 170.



6. SUBSTRATES

- Properly prepared previously painted surfaces
- Properly prepared OEM finishes
- Valspar 2K Primers/ Sealers
- SE88 1k Self Etch Primer



7. APPLICATION

- Spray one to three medium wet coats or until desired build is achieved.
Do not exceed 6 mils (150 µm).
- Allow each coat 5-10 minutes flash or until flash is dull.
- Surface temperature should be 10 - 38°C with less than 80% ambient humidity preferred.



8. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

	As Surfacer	As Sealer
Flash between coats	5-10 min.	4-8 min.
To Sand	60 min.	Nib Sand 20 min.
To Topcoat	60 min.	20 min.



9. INFRARED CURE

See Infrared Curing Information.



10. GUN SET UP

CONVENTIONAL GUN

Gravity Feed

Siphon Feed

HVLP

Gravity Feed

As Primer

1.4 mm - 1.8 mm

1.4 mm - 1.8 mm

As Sealer

1.3 mm - 1.5 mm

1.3 mm - 1.5 mm

AIR PRESSURES

Conventional @ Gun

Gravity Feed

30-45 psi (2.0 - 3.1 bar)

Siphon Feed

30-45 psi (2.0 - 3.1 bar)

HVLP Inlet Air

20-30 psi (1.5 - 2.0 bar)



11. PHYSICAL DATA

Reduced with Uni-Solvent 171-174

	As Surfacer	As Sealer
VOC (PKG) per U.S. Gal.	2.95	2.95
VOC (RTS) per U.S. Gal.	3.7	4.2
Viscosity (RTS) DIN 4 @ 77°F/25°C	20-22 sec.	15-18 sec.
Total Solids by Weight (RTS)	65.3%	58.8%
Total Solids by Volume (RTS)	46%	39.4%
Sq. Ft. Coverage/US Gal. (RTS)	738	632
Flash Point (RFS)	45°F	45°F
Total HAPS (lb HAPS/gal solid)	1.07	1.51

Reduced with Uni-Solvent LV X01 or X02

	As Surfacer	As Sealer
VOC (RTS) per U.S. Gal.	3	3
Flash Point (RFS)	-4°F	-4°F
Total HAPS (lb HAPS/gal solid)	0.629	0.629