



## GENERAL INFORMATION

327 Series is a low VOC High Solid Single Stage Acrylic Urethane Enamel. Apply with HPC hardeners to achieve enhanced urethane properties, increased durability, and superior application control.



## 1. COMPONENTS

- 327 Series Color
- HPC0 Slow Activator
- HPC1 Standard Activator
- HPC2 Fast Activator
- HPC3 Warp Speed 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



## 2. MIXING RATIO

Reduce 10-15% with 171 - 174 Reducers. Choose Uni-Solvent based on temperature and size of part to be finished.

For best performance, activate 8 parts 327 Color with 1 part Universal Series Polyurethane Activator (HPC0 - HPC3) prior to reduction.



## 3. POT LIFE @ 77°F (25°C)

Indefinite without hardener.  
4 Hours with hardener.



## 4. CLEAN UP

Valspar Refinish 100 Thinner (check local regulations).



## 5. ADDITIVES

FISHEYE: T152 Fisheye Eliminator 1 ounce per gallon.  
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 360-400 grit wet or dry sandpaper or equivalent.
- Mask all adjacent areas to prevent over spray problems.



## 7. SUBSTRATES

- 87N or CPSEN
- DTM2004 or CPSDTM
- Properly Prepared OEM Finish
- VP, CPSVP or CPSVPLV Series Epoxy Primers
- Valspar Polyurethane Primer/Sealers



## 8. APPLICATION

Spray two to three medium wet coats allowing 20 minutes flash between coats.



## 9. FLASH / DRY TIMES

### AIR DRY @ 77°F (25°C)

Flash between coats	20 Minutes.
Tape Time without Hardener	Overnight
Tape Time with Hardener	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



## 10. GUN SET UP

### CONVENTIONAL GUN

Gravity Feed 1.6 mm - 1.8 mm  
Siphon Feed 1.6 mm - 1.8 mm



### HVLP

Gravity Feed 1.3 mm - 1.5 mm

### AIR PRESSURES

#### Conventional @ Gun

Gravity Feed 30-35 psi  
Siphon Feed 30-45 psi

#### HVLP @ Cap

#### PANEL

30-35 psi  
30-45 psi  
6-8 psi

#### OVERALL

35-40 psi  
40-50 psi  
8-10 psi



## 11. PHYSICAL DATA

VOC (Unreduced)	4.3 lbs./gal.
VOC Red @ 25% Solid	4.7-4.9 lbs./gal.
VOC Red @ 30% Metallic	5.0 lbs./gal.
Volume Solids	44% Average
Theoretical Coverage	690 - 725 sq. ft. per mil per gallon
Recommended DFT	1 - 3 mils.
Zahn #2 Viscosity (RTS)	20 - 21 Seconds