



## GENERAL INFORMATION

345 Series is a specialty product designed for interior or exterior vinyl surfaces. It offers excellent flexibility and adhesion, and can be used alone or with a hardener.



## 1. COMPONENTS

- 345 Series Base
- 171 Fast Uni-Solvent up to 75°F (24°C)
- 172 Medium Uni-Solvent 75°-85°F (24°-29°C)
- HPC2 (Optional) Fast Activator



## 2. MIXING RATIO

Interior Surfaces: Use as single component (Ready-to-Spray).  
Exterior Surfaces: 8 parts 345 Color to 1 part HPC2.  
May be reduced up to 5% with 171 or 172 Uni-Solvent.



## 3. POT LIFE @ 77°F (25°C)

Indefinite without hardener.  
8 Hours with hardener.



## 4. CLEAN UP

Valspar Refinish 100 Thinner (check local regulations).



## 5. ADDITIVES

ACCELERATOR: N/A  
FISHEYE: T152 Fisheye Eliminator 1 oz. per gallon.  
FLEX ADDITIVE: N/A

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



## 6. SURFACE PREPARATION

### For Vinyl:

- Wash surface with mild detergent and water.
- Rinse and dry surface.
- Wipe surface with Valspar Refinish 100 Thinner or 170 AquaClean and wipe dry with clean cloth before product flashes.
- Spot test before using lacquer thinner to clean vinyls.

### For Plastics:

- Spray surface with PR1 Plastic Cleaner and wipe dry before product evaporates.
- Scuff surface with 320-400 grit wet or dry sandpaper or red scuff pad.
- Respray surface with PR1 and wipe dry with clean cloth before product evaporates.



## 7. SUBSTRATES

- Properly cleaned vinyl
- PR2 Plastic Adhesive Promoter
- PR4 Flexible 2K Polyurethane Primer



## 8. APPLICATION

- Apply two to three medium coats allowing 5 minutes between coats.



## 9. FLASH / DRY TIMES

### AIR DRY @ 77°F (25°C)

Flash between coats	5-10 Minutes.
Tape Deliver	Overnight



## 10. GUN SET UP

### CONVENTIONAL GUN

Gravity Feed 1.4 mm - 1.6 mm  
Siphon Feed 1.5 mm - 1.8 mm



### HVLP

Gravity Feed 1.3 mm - 1.5 mm

### AIR PRESSURES

#### Conventional @ Gun

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

#### HVLP @ Cap

#### PANEL

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



## 11. PHYSICAL DATA

VOC (Unreduced)	5.2 lbs./gal.
Volume Solids	20 - 25% Average
Theoretical Coverage	300 - 400 sq. ft. per mil per gallon
Recommended DFT	1 - 2 mils.
Zahn #2 Viscosity (RTS)	19 - 20 Seconds