



GENERAL INFORMATION

829 HS Series is a Low VOC 2K Polyurethane Topcoat. It is designed to meet stringent air quality requirements, allow for ease of application and provide a long lasting protective finish.



1. COMPONENTS

- 829 Series Color
- HPC0 Slow Activator
- HPC1 Standard Activator
- HPC2 Fast Activator
- HPC3 Very Fast Activator
- X01 Fast Exempt Uni-Solvent
- X02 Medium Exempt Uni-Solvent
- 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

For 3.5 VOC Compliance: Mix three (3) parts 829 2K HS Color with one (1) part HPC Activator and reduce with up to 10% Urethane Uni-Solvent (3:1:10%).
For 2.8 VOC Compliance: Mix three (3) parts 829 2K HS Color with one (1) part HPC Activator and reduce with up to 10% X01 or X02 Uni-Solvent (3:1:10%).
For 2.8 VOC Compliance (urethane reducer): Mix three (3) parts 829 2K HS Color with one (1) part AK21 Activator and reduce with up to 10% Urethane Uni-Solvent (3:1:10%).



3. POT LIFE @ 77°F (25°C)

4 hours.



4. CLEAN UP

Valspar Refinish 100 Thinner (check local regulations).



5. ADDITIVES

ACCELERATOR: T566 up to 2 ounces per mixed gallon
 FISHEYE: T152 Fisheye Eliminator up to 1 ounce per gallon.
 FLEX ADDITIVE: Not Required
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

(Cross coat technique) Spray a fast tack coat on panel using a top to bottom stroke. Follow with medium wet coat using a side to side stroke.



9. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Flash between coats	Up to 15 Minutes.
To Tape	6 Hours
To Deliver	8 Hours

9. FLASH / DRY TIMES (continued)

FORCE DRY

Flash before Force Dry	20 Minutes
Force Dry Time	40 Minutes @ 140°F (60°C)
Sand and Buff	After Cool Down (1-2 Hours)

10. INFRARED CURE

See Infrared Curing Information.



11. GUN SET UP

CONVENTIONAL GUN

Gravity Feed 1.5 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 35-45 psi

HVLP @ Cap

PANEL

30-35 psi
 35-45 psi
 8-10 psi

OVERALL

35-45 psi
 45-55 psi
 8-10 psi



12. PHYSICAL DATA

VOC (Ready-to-Spray)	2.8 lbs./gal. (with Exempt Uni-Solvent)
Volume Solids	52.6% (Average)
Theoretical Coverage	844 sq. ft. per mil per gallon
Recommended DFT	1 - 3 mils.
Zahn #2 Viscosity (RTS)	20 - 22 Seconds