



GENERAL INFORMATION

840 Series is a low VOC 2K Polyurethane that may be used as a high gloss topcoat or clearcoated making it a 2K polyurethane basecoat. 840 2K was formulated to meet both 3.5 VOC and National Rule VOC regulations depending on reducer selection. 840 2K develops unmatched gloss, depth of image and exhibits outstanding gloss as a topcoat while offering productive tape and topcoat times as a basecoat. 840 2K may be clear coated with a variety of Valspar Refinish clearcoats including AC4400, AC2135, AG350, AC200MS and AC355.



1. COMPONENTS

- 840 Series Color
- HPC007 Activator (Overall)
- HPC0 Slow Activator
- HPC1 Standard Activator
- HPC2 Fast Activator
- HPC3 Warp Speed 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
- T566 Accelerator Very Fast



2. MIXING RATIO

Mix three (3) parts 2K 840 Color with one (1) part HPC Activator (3:1). If desired, reduce up to 10% with X01, X02 or 170 Series Reducers (check local VOC regulations). For Basecoat, up to 4 oz. T566 may be added per mixed gallon.



3. POT LIFE @ 77°F (25°C)

4 hours.



4. CLEAN UP

Valspar Refinish 100 Thinner (check local regulations).



5. ADDITIVES

ACCELERATOR (Direct Gloss): T566 up to 2 ounces per mixed gallon
 ACCELERATOR (Basecoat): T566 up to 4 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 grit 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 2 - 3 medium wet coats
- Allow 10 - 15 minutes flash time between coats



9. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Flash between coats	10-15 Minutes.
To Tape (Direct Gloss)	4 Hours
To Tape (Basecoat)	1 Hour *
To Clearcoat	30 Minutes
To Deliver	6-8 Hours

* With 4 oz. of T566 per sprayable gallon

FORCE DRY

Flash before Force Dry	20 Minutes
Force Dry Time	30 Minutes @ 130°F (54°C)
To Sand/Buf	After Cool Down (1-2 Hours)

10. INFRARED CURE

See Infrared Curin Information section.



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
 Pressure Pot 6 - 10 psi at Pot
 Fluid Deliver 14 - 18 oz. per Minute

AIR PRESSURES

Conventional @ Gun

	PANEL	OVERALL
Gravity Feed	30-35 psi	35-45 psi
Siphon Feed	35-45 psi	45-55 psi
HVLP @ Cap	8-10 psi	8-10 psi



12. PHYSICAL DATA

VOC (Ready-to-Spray)	Coating: 3.5 lbs./gal. (max)
Volume Solids	47.4% (Average)
Theoretical Coverage	760 sq. ft. per mil per gallon
Recommended DFT	1 - 3 mils.
Zahn #2 Viscosity (RTS)	20 - 22 Seconds