



GENERAL INFORMATION

860 2K is a two-component polyurethane topcoat formulated to provide the ultimate in performance, gloss and color retention, durability, and superior productivity characteristics.



1. COMPONENTS

- 860 Series Mixed Color
- HPC0 Slow Activator
- HPC1 Standard Activator
- HPC2 Fast Activator
- HPC3 Very Fast 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 - 4:1:1

Mix four (4) parts 860 Series color to one (1) part Activator HPC0, HPC1, HPC2, or HPC3 and reduce with one (1) part 171-174 Uni-Solvent (4:1:1 by volume).



3. POT LIFE @ 77°F (25°C)

	HPC0	HPC1	HPC2	HPC3
Pot Life (Activated)	4 Hours	3 Hours	1 Hour	1 Hour



4. CLEAN UP

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



5. 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.
- Clean surface with Aqua Clean 170 prior to spraying.



6. SUBSTRATES

- Properly Prepared OEM Finish
- DTM2004
- VP50 Epoxy Primer
- HS35 HS Primer Surfacer
- All CPS Primer Series



7. APPLICATION

- Spray two to three medium wet coats or until hiding is achieved.
- Allow 10-20 minutes between coats.



8. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Flash Time	10-20 Minutes
To Tape	4 Hours

9. INFRARED CURE

See Infrared Curing Information section.



10. GUN SET UP

CONVENTIONAL GUN

Gravity Feed 1.4 mm - 1.5 mm
Suction Feed 1.4 mm - 1.5 mm



HVLP

Gravity Feed 1.3 mm - 1.5 mm

AIR PRESSURES

Conventional @ Gun

Gravity Feed

Siphon Feed

HVLP @ Cap

PANEL

30-35 psi

35-45 psi

8-10 psi

OVERALL

35-45 psi

45-55 psi

8-10 psi



11. PHYSICAL DATA

Reduced with Uni-Solvent 171-174

	860 Series
VOC (PKG) per U.S. Gal.	4.5
VOC (RTS) per U.S. Gal.	4.74
Total Solids by Weight (RTS)	40.7%
Total Solids by Volume (RTS)	34%
Sq. Ft. Coverage/US Gal. (RTS)	546
Flash Point (RFS)	45°F
Total HAPS (lb HAPS/gal solid)	3.79

Reduced with Uni-Solvent LV X01 or X02

	860 Series
VOC (RTS) per U.S. Gal.	4.23
Flash Point (RFS)	-4°F
Total HAPS (lb HAPS/gal solid)	1.86