



GENERAL INFORMATION

AC2100 is a medium solids two component polyurethane clearcoat formulated to offer refinishers ease of application, very good flow and leveling, very good gloss and good distinctness of image in a productive 2K polyurethane clearcoat. AC2100 is compliant under current 2.1 VOC regulations in the United States.



1. COMPONENTS

- AC2100 Low VOC Urethane Clearcoat
- HPC0 Slow Activator
- HPC1 Medium Activator
- HPC2 Fast Activator
- HPC3 Warp Speed Activator
- X02 Medium Exempt Uni-Solvent



2. MIXING RATIO

Mix four (4) parts AC2100 base with one (1) part HPC Activator by volume. Activator selection should be based on the size of the part to be painted and the temperature of both the air and part at time of painting.



3. POT LIFE @ 77°F (25°C)

When properly covered at 77°F (25°C), AC2100 will maintain a sprayable viscosity for at least from 3-4 hours depending on activator selection.



4. CLEAN UP

Lacquer Thinner or X01 Uni-Solvent (Check Local Regulations) Thinner or reducers of low conductivity should be avoided as they present an increased risk of combustion via static ignition. Check local regulations to ensure compliance.



5. ADDITIVES

ACCELERATOR: T566 up to 2oz. per gallon (max).
 FISHEYE: T152 Fisheye Eliminator up to 1oz. per gallon.
 FLEX ADDITIVE: N/A

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



6. SURFACE PREPARATION

- Apply Undercoats and Basecoat per data sheet instructions. Over OEM or completely cured previously painted substrates scuff with a grey scuff pad or 600 grit then wipe clean with an approved solvent or water base wipe.
- Allow basecoat adequate flash time (follow manufacturer's recommendation).
- Follow basecoat manufacturer's recommendation for recoat intervals.



7. SUBSTRATES

- 333 Series Basecoat
- 840 2K Polyurethane Basecoat
- 829 HS Basecoat
- Properly cleaned and sanded OEM finishes



8. APPLICATION

Spray 2-3 medium-wet to wet coats. Overlap 50%.



9. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Flash between coats	15-20 Minutes.
Dust Free	20-25 Minutes



9. FLASH / DRY TIMES (continued)

Sand and Buff

HPC0 Activated	HPC1 Activated	HPC2 Activated	HPC3 Activated
Overnight	Overnight	4 - 6 Hours	2 - 4 Hours

FORCE DRY with HPC0 and HPC1 Activator

Flash before Force Dry	20 Minutes
Force Dry Time	45 Minutes @ 130°F (54°C)
Sand and Buff	After Cool Down

FORCE DRY with HPC2 and HPC3 Activator

Flash before Force Dry	0 Minutes
Force Dry Time	15-20 Minutes @ 165°F (74°C)

10. INFRARED CURE

See Infrared Curing Information.



11. GUN SET UP

CONVENTIONAL GUN

Gravity Feed 1.3 mm - 1.5 mm

Siphon Feed 1.6 mm - 1.8 mm

HVLP

Gravity Feed 1.3 mm - 1.5 mm

AIR PRESSURES

Conventional @ Gun

Gravity Feed

Siphon Feed

HVLP @ Cap

PANEL

35-40 psi

35-45 psi

6-8 psi

OVERALL

45 psi

45-50 psi

9-10 psi



12. PHYSICAL DATA

VOC	2.1 lbs./gal.
Volume Solids	35.3%
Theoretical Coverage	566 sq. ft. per mil per gallon
Recommended DFT	1-4 mils.
Zahn #2 Viscosity (RTS)	19 - 21 Seconds